

HIGH HEAT COATING

K00032111, Aluminum

K00032200, Black

Product Data Sheet

KRYLON

INDUSTRIAL
COATINGS™

DESCRIPTION

High Heat Coating is a heat cured, interior/exterior, ready mixed, silicone resin, modified with an alkyd.

ADVANTAGES

- For service temperatures between 500°F - 1000°F
- Aluminum is heat reflective
- Resists discoloration
- Acceptable for use in federally inspected meat and poultry plants
- Long term protection against weathering and moisture
- Ultraviolet light resistant
- Interior or exterior use
- Maintains "sheen"

RECOMMENDED USES

For use over prepared steel surfaces in high temperature (between 500 and 1000°F) environments.

- Boilers
- Breechings
- Exhausts
- Exterior/Interior
- Heat Exchangers
- Piping
- Stacks
- Industrial Mufflers

DO NOT SHAKE ON MECHANICAL SHAKER

SPECIFICATIONS

RECOMMENDED SYSTEMS

Steel (Interior): 1-2 cts. High Heat Primer @ 0.75 - 1.0 mils dft/ct
Total dft 0.75 - 2.0 mils maximum

NOTE: Requires heat cure. See instructions under "Drying Schedule"

Steel (Exterior): 2 cts. High Heat Primer @ 0.75 - 1.0 mils dft/ct.
Total dft 1.5 - 2.0 mils maximum

SURFACE PREPARATION

NOTE: Requires heat cure. See instructions under "Drying Schedule"
Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel (Atmospheric Service): Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (0.5-1.0 mil maximum). Remove all weld spatter and round all sharp edges by grinding to a minimum 1/4" radius. Coat any bare steel the same day as it is cleaned or before flash rusting occurs.

ORDERING INFORMATION

Packaging: 1 gallon containers
Weight per gallon: 9.2 lb Aluminum,
11.0 lb Black

APPLICATION

APPLICATION CONDITIONS

Temperature: 50°F minimum, 100°F maximum (air, surface, and material). At least 5°F above dew point.
Relative humidity: 85% maximum

APPLICATION EQUIPMENT

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compatible with the existing environmental and application conditions.

Airless Spray:

Pressure: 2000 psi
Hose: 1/4" ID
Tip: .015"
Reduction: Not recommended

Conventional Spray:

Gun: Binks 95
Fluid Nozzle: 63C
Air Nozzle: 63PB
Atomization Pressure: 60 psi
Fluid Pressure: 20 psi
Reduction: Not recommended

Brush:

Brush: Natural Bristle
Reduction: Not recommended

Roller:

Cover: 1/4" woven with phenolic core
Reduction: Not recommended

If specific application equipment is listed above, equivalent equipment may be substituted.

APPLICATION PROCEDURES

- Surface preparation must be completed as indicated.
- Lightly stir before use. **Do not shake with mechanical shaker.**
- Special care should be exercised while using this product for maximum performance. Film thickness and surface preparation are critical. Be especially concerned at lap areas and when using airless spray. Excessive film thickness will cause blistering and peeling. Insufficient film thickness may lead to premature rusting of the surface. Always apply to cool surfaces (50°F-100°F).
- Apply paint at the recommended film thickness and spreading rate as indicated.
- Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

APPLICATION cont.

PERFORMANCE TIPS

- Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.
- When using spray application, use a 50% overlap with each pass of the gun to avoid holidays, bare areas, and pinholes. If necessary, cross spray at a right angle.
- Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions, and excessive film build.
- In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with Mineral Spirits, (K01661600) for Aluminum and Xylene, (K01661530) for Black.
- Always apply to a cool surface 50°F -100°F.
- No primer is required.
- No reduction of material is recommended as it can affect film build, appearance, and adhesion.
- Do not apply greater than 1.0 mils dft/ct. Maximum 2 cts.
- Not intended for use on interior of flues, stacks, etc.

CHARACTERISTICS

FINISH: Aluminum Sheen or Flat Black

COLOR: Aluminum or Black

VOLUME SOLIDS:

Aluminum 25% ± 2%
Black 40% ± 2%

WEIGHT SOLIDS:

Aluminum 42% ± 2%
Black 62.1% ± 2%

VOC (Calculated):

Aluminum 638 g/L; 5.3 lb/gal
Black 503 g/L; 4.1 lb/gal

SHELF LIFE: 36 months, unopened, at 77°F

RECOMMENDED SPREADING RATE PER COAT

Aluminum:

Wet mils: 2.9 - 4.0

Dry mils: 0.75 - 1.0

Coverage: 536 - 402 sq ft/gal approximate

Black:

Wet mils: 1.8 - 2.5

Dry mils: 0.75 - 1.0

Coverage: 855 - 642 sq ft/gal approximate

CHARACTERISTICS cont.

DRYING SCHEDULE @ 3.0 MILS WET @ 50% RH: @ 77°F

Aluminum:

To touch: 1 hour

To recoat: 2 hours

To handle: Air dry 24 hours

DRYING SCHEDULE @ 2.0 MILS WET @ 50% RH: @ 77°F

Black:

To touch: 1 hour

To recoat: 2 hours

To handle: Air dry 24 hours

HEAT CURE: For both Aluminum and Black, slowly raise heat to operating temperature, taking about 1 hour going through 400°F - 500°F range to cure.

Drying time is temperature, humidity, and film thickness dependent.

FLASH POINT: Aluminum 90°F

Black 80°F

CLEAN-UP: Aluminum: Mineral Spirits, (K01661600)

Black: Xylene, (K01661530)

CAUTIONS

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from your local Krylon Industrial Coatings™ Distributor. Please direct any questions or comments to your local Krylon Industrial Coatings™ Distributor.

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