HEAT-FLEX® HI-TEMP 1000HA

Product Description
HEAT-FLEX HI-TEMP 1000HA is formulated with an innovative silicone acrylic enabling it to be applied to hot metal substrates with temperatures ranges of ambient up to 500°F (260°C). It can be used direct to metal or as a topcoat over Heat-Flex Hi-Temp 1200 or an inorganic zinc rich primer to provide increased corrosion protection.

- Single component
- Can be applied to hot substrates up to 500°F (260°C)*
- User-friendly - can be brushed or rolled
- Excellent spray application properties
- Air dries at ambient
- Self-priming

Recommended Uses
- Direct to stainless steel or carbon steel
- Can be applied to hot substrates up to 500°F (260°C)
- Cyclic service up to 500°F (260°C) with temperature spikes up to 600°F (316°C)
- Power plants
- Chemical facilities
- Offshore/Marine
- Pulp & Paper

Not recommended for:
- Continuous exposure to temperatures above 500°F (260°C)
- Direct application to surfaces having a surface temperature above 500°F (260°C) (NOTE: Aluminum can not be applied above 250°F)
- Immersion service
- Interiors of industrial air pollution control devices

Recommended Systems

Carbon Steel or Stainless Steel - Atmospheric:
- Temperature: surface 50°F (10°C) minimum, 500°F (260°C) maximum
- Air and material 50°F (10°C) minimum, 120°F (49°C) maximum
- At least 5°F (2.8°C) above dew point, Relative humidity: 85% maximum

<table>
<thead>
<tr>
<th>Dry Film Thickness / ct. Mil</th>
<th>Carbon Steel or Stainless Steel - Atmospheric:</th>
<th>Carbon Steel or Stainless Steel - Atmospheric:</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Minimum</strong></td>
<td><strong>Maximum</strong></td>
<td><strong>Minimum</strong></td>
</tr>
<tr>
<td>1 ct. Heat-Flex Hi-Temp 1000HA**</td>
<td>2.0-2.5 (50-62)</td>
<td>1 ct. Heat-Flex Hi-Temp 1000HA**</td>
</tr>
<tr>
<td>1 ct. EpoPhen FF***</td>
<td>7.0-9.0 (175-225)</td>
<td>1 ct. Phenicon HS FF***</td>
</tr>
<tr>
<td>1 ct. Cor-Cote HT***</td>
<td>4.0-5.0 (100-125)</td>
<td>1 ct. Cor-Cote HT FF***</td>
</tr>
</tbody>
</table>

**Must apply a mist coat of Heat-Flex Hi-Temp 1000HA. Allow 10 minutes flash off and follow with a full coat.

**Refer to respective product data sheet for maximum service temperature recommendation.

NOTE: Heat-Flex Hi-Temp 1000HA is also suitable for use over inorganic zinc rich primers.

Tinting
Do not tint

Application Conditions

Temperature:
- Temperature: surface 50°F (10°C) minimum, 500°F (260°C) maximum
- Air and material 50°F (10°C) minimum, 120°F (49°C) maximum
- At least 5°F (2.8°C) above dew point, Relative humidity: 85% maximum
Surface Preparation Standards

Minimum recommended surface preparation:
- Iron & Steel: SSPC-SP6, 1.5-2.5 mil (40-63 micron) profile
- SSPC-SP11, 1.0-2.5 mil (25-63 micron) profile
- Stainless Steel: SSPC-SP1, Do not use chlorinated solvents for cleaning

Iron & Steel
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (1.5-2.5 mils / 40-63 microns maximum). If SSPC-SP6/NACE 3 is not possible, Power Tool Cleaning to Bare Metal per SSPC-SP11 is also acceptable (1.0-2.5 mil / 25-63 micron profile maximum). Hand Tool Cleaning per SSPC SP 2 or Power Tool Cleaning per SSPC SP 3 are acceptable preparation methods when SSPC SP 6 or SSPC SP 11 are not possible. Coat any bare steel the same day as it is cleaned or before flash rusting occurs. On stainless steel, clean per SSPC-SP1. Aluminum Oxide grit is also acceptable for use. Do not use chlorinated solvents for cleaning stainless steel.

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.

Application Equipment (Cont’d)

Brush
- Brush: Natural bristle
- Reduction: Not recommended

Roller
- Cover: 1/4”-3/8” woven with solvent resistant core
- Reduction: Not recommended

If specific application equipment is not listed, equivalent equipment may be substituted. For brush and roller application, maintain a wet edge while avoiding runs or excess film build.

Application Procedures

Surface preparation must be completed as indicated.

Mixing Instructions: Mix paint thoroughly with low speed, spark-proof, power agitation before use. Obtain a uniform consistency. Do not incorporate air.

Clean Up

Clean spills and spatters immediately with Xylene, R2K4. Clean tools immediately after use with Xylene, R2K4. Follow manufacturer’s safety recommendations when using any solvent.

Ordering Information

Weight per gallon: 13.5 lb (6.1 kg)

Safety Precautions

Refer to the MSDS sheet before use. Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

Disclaimer

The information and recommendations set forth in this Product Data Sheet are based upon tests conducted by or on behalf of The Sherwin-Williams Company. Such information and recommendations set forth herein are subject to change and pertain to the product offered at the time of publication. Consult your Sherwin-Williams representative to obtain the most recent Product Data Information and Application Bulletin.

Warranty

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MER CHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

www.sherwin-williams.com/protective