

## Technical Data Sheet

# Indokote SIL 400

### Heat Resistance Silicone Aluminium Coating

### Product Description

Indokote SIL400 is single component, Silicone resin based high temperature aluminum coating. SIL400 is designed to provide heat resistant up to 400 °C. It can be used as primer, mid coat or finish coat in atmospheric environments. It is suitable for properly prepared carbon steel, galvanised steel, stainless steel and aluminium substrates. Also suitable for intermittent heat of maximum of 540°C.

### Recommended Use

Indokote SIL400 can be directly applied outside storage tanks, furnace, pipe stack, exhaust stacks, ducting radiator, boiler fronts, Chimney as well as structural steel & other surfaces operating at elevated temperatures. Strongly recommended in combination with an inorganic zinc silicate coating as primer, providing heat resistance up to 400 °C and long term corrosion protection.

### Physical Data

Colour	: Bright Silver
Finish	: Matt
Soild by Volume	: 42 ± 2%
Flash Point	: 25° C
Dry Heat Resistance	: Intermittent: 540°C, Continuous: 400°C
Shelf Life	: 12 months

### Film Thickness

#### Recommended film thickness per coat

Dry Film Thickness	: 20-30µ in single coat
Wet Film Thickness	: 50-70µ in single coat
Therotical Coverage Rate	: 17.00 sq.mt / lit at recommended DFT of 25µ

### Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

**Primed Surface:** Indokote SIL400 is suitable for application to steelwork freshly coated with zinc silicate shop primers. If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Ensure that the zinc primer is fully cured prior to the application of SIL 400.

**Steel:** Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007). Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 30-40 microns is recommended.

**Repair & Maintenance:** Indokote SIL400 can be applied directly over aged HR Aluminium coating following thorough fresh water washing and degreasing provided the coating to be overcoated is in an intact and tightly adherent condition. Loose or flaking coatings should be removed back to a firm edge and SIL400 or an appropriate primer should be used to repair the area before application of the full coat.

## Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: One Component Coating
Thinner and Cleaner	: Not Recommended. IK.1702 can be use as cleaner.
Airless Nozzle Orifice	: 0.28 - 0.33mm
Nozzle Pressure	: 130 kg/cm <sup>2</sup> or 1800 psi

**Working Precautions:** Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommences with freshly mixed units.

**Maintenance:** Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

## Drying Characteristics

Surface Dry	: 30 mins
Touch Dry (to Handle)	: 120 mins
Overcoating Interval	: Minimum 10 Hours, Maximum - Unlimited

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

## Compatibility

Previous Coating	: Inorganic Zinc Silicate, Silicone Acrylic
Subsequent Coating	: Silicone Acrylic

## Product Features

Indokote SIL400 is not suitable for exposure in acid or alkaline conditions and in immersion service. Do not over apply. Application above 30 microns DFT in single coat will result in blistering when subject to high temperatures. Excessive dry film thickness may result in cracking.

SIL400 can be coated up to 3 coats at a maximum of 25 microns per coat without the requirement of heating between coats. This provides maximum corrosion protection when it is not possible to use a zinc silicate priming system.

The maximum performance is achieved after complete drying. At higher relative humidity, drying may get retarded. SIL400 should not be applied on hot surfaces.

## Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

## Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

### Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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