

## SELECTION DATA

**GENERIC TYPE:** Single package, modified silicone.

**GENERAL PROPERTIES:** A protective coating for medium to high temperature service with good resistance to mild chemical fume environments. After curing, the coating is very resistant to thermal shock conditions from ambient temperatures to 400°C.

**RECOMMENDED USES:** For the protection of equipment such as stacks, incinerators, furnace exteriors and heat exchangers operating from ambient temperatures to 400°C. The use of an inorganic zinc primer, such as Carbozinc 11 ZA, prevents rusting during shutdown and/or when the equipment is exposed to moisture and salts at temperatures less than 93°C.

**NOT RECOMMENDED FOR:** Immersion service

### CHEMICAL RESISTANCE GUIDE:

<u>Exposure</u>	<u>Splash and Spillage</u>	<u>Fumes</u>
Acids	Good	Excellent
Alkalies	Fair	Excellent
Solvents	Poor	Good
Salt	Good	Excellent
Water	Excellent	Excellent

### TEMPERATURE RESISTANCE (non-immersion):

Continuous:	400°C
Non-continuous:	540°C

**FLEXIBILITY:** Good

**WEATHERING:** Excellent

**ABRASION RESISTANCE:** Fair

**SUBSTRATES:** Apply to properly prepared steel or over inorganic zincs.

**TOPCOAT REQUIRED:** None

**COMPATIBILITY WITH OTHER COATINGS:** May be applied over inorganic zinc primer such as Carbozinc 11 ZA. Consult StonCor Africa Technical Service for specific recommendations.

**NOTE:** A mist coat may be required over inorganic zincs to minimize bubbling.

## SPECIFICATION DATA

### THEORETICAL SOLIDS CONTENT:

Thermaline 4674 ZA	<u>By Volume</u> 42% + 2%
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**RECOMMENDED DRY FILM THICKNESS PER COAT:**  
40 microns

**NOTE:** Excessive thickness may cause blistering.

### THEORETICAL COVERAGE:\*

10.5 m<sup>2</sup>/l at 40 microns

**\*NOTE:** Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

**SHELF LIFE:** 24 months minimum when stored at 25°C

**COLOURS:** Black only

**GLOSS:** Low

## ORDERING INFORMATION

Prices may be obtained from StonCor Africa Sales Representative or Main Office.

### APPROXIMATE SHIPPING WEIGHT:

	<u>5L</u>
Thermaline 4674 ZA	6.0 kg
Carboline Thinner # 10	4.9 kg

### FLASH POINT(Pensky-Martens Closed Cup):

Thermaline 4674 ZA	21°C
Carboline Thinner # 10	24°C

March 2012 SA replaces June 2010 SA

## APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

**SURFACE PREPARATION:** Remove any oil or grease from surface to be coated prior to abrasive blast cleaning.

**STEEL:** Abrasive blast to a Near White Metal Finish in accordance with ISO 8501 SA 2½ to obtain a 25-50 micron blast profile.

**MIXING:** Mix to smooth consistency with a mechanical agitator such as "jiffy" mixer. Thin up to 12% by volume with Carboline Thinner #10, if necessary.

**NOTE:** Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance or void product warranty whether express or implied.

### APPLICATION TEMPERATURES:

	<u>Material</u>	<u>Surfaces</u>
Normal	16-32°C	18-32°C
Minimum	5°C	5°C
Maximum	38°C	43°C

	<u>Ambient</u>	<u>Humidity</u>
Normal	16-32°C	10-85%
Minimum	5°C	0%
Maximum	43°C	95%

Do not apply when the surface temperature is less than 3°C above the dew point.

Special thinning and application techniques may be required above or below normal conditions.

**SPRAY:** Use sufficient air volume for correct operation.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

**NOTE:** The following equipment has been found suitable, however, equivalent equipment may be substituted.

**CONVENTIONAL:** Use a 10mm minimum I.D. material hose.

Hold gun approximately 300-350 mm from the surface and at a right angle to the surface.

### Mfr. & Gun

Binks #18 or #62  
DeVilbiss PMBC or JGA

### Fluid Tip

63B  
FX  
approx..043" I.D.

### Air Cap

63PB  
704

**AIRLESS:** Use a 10 mm minimum I.D. material hose. Hold gun approximately 450-500 mm from the surface and at a right angle to the surface.

### Mfr. & Gun

DeVilbiss JGB-507  
Graco 205-591  
Binks Model 500

### Pump\*

QFA-159  
President 30:1 or Bulldog 30:1  
Mercury 5C

\*Teflon packings are recommended and available from pump manufacturer.

Use a .013 - .015" tip with 2200 psi. (152 Bar)

**BRUSH:** Recommended for small areas or touch-up only. Avoid rebrushing or reworking of material. Take care to avoid excessive film thickness. Use a natural bristle brush applying with full strokes.

**ROLLER:** Not recommended.

### **DRYING TIMES (Between coats):**

<u>TIME</u>	<u>TEMPERATURE (SURFACE)</u>
16 Hours	10°C
8 Hours	16°C
4 Hours	25°C
2 Hours	32°C

**CLEAN UP:** Use Carboline Thinner # 2

### **STORAGE CONDITIONS (Store Indoors):**

Temperature: 4-43°C  
Humidity: 0-100%

**CAUTION: MAY CONTAIN FLAMMABLE SOLVENTS.** KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRONIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.



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