THERMOTECT 600
SILVER

Heat Resistant Paint

A heat resisting paint based on silicone resin and aluminium powder

No heat cure necessary with additional additive to improve the hardness of paint film

Steel structure protection for high temperature service

- Excellent heat resistance (Up to 600℃)
- Lead and chromium free
- Good weather resistance
- Good applicability

Physical Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Unit</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td></td>
<td>Silver</td>
</tr>
<tr>
<td>Finish</td>
<td></td>
<td>Semi-gloss</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>%</td>
<td>49</td>
</tr>
<tr>
<td>Typical Thickness</td>
<td>micron / coat</td>
<td>25</td>
</tr>
<tr>
<td>Theoretical Coverage</td>
<td>micron / L</td>
<td>25</td>
</tr>
<tr>
<td>Flash Point</td>
<td>°C</td>
<td>38</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>g/cm³</td>
<td>1.00</td>
</tr>
<tr>
<td>VOC</td>
<td>g/L</td>
<td>440</td>
</tr>
<tr>
<td>Temperature Resistance</td>
<td></td>
<td>Non-continuous : 600℃, Continuous : 550℃</td>
</tr>
</tbody>
</table>

Surface Preparation

- All surfaces to be coated should be completely clean, dry and free from contamination.
- Surface preparation method shall be in accordance with ISO 8504: 2000.
- Remove salt and other water-soluble contaminants by fresh water.
- Remove oil and grease with suitable detergent or solvent (SSPC-SP-1).
- Remove rust, mill scale and other loose material completely by abrasive blasting (ISO 8501-1:2007 Sa 2 1/2 or SSPC SP-10).

Application

Application Conditions

- Ambient temperature shall be above 5℃ and relative humidity shall be below 85%. Surface temperature shall be a minimum of 3℃ above dew point.
- Adequate ventilation shall be provided in confined spaces to ensure proper drying.

Mixing

- Stir THERMOTECT 600(M) thoroughly.
- Add one container of "THERMOTECT 600(M) Additives" into one container of THERMOTECT 600(M) and stir thoroughly.

Mixing ratio

- Paint / Additives = 20 litres / 220g

Induction Time

- Not required

Application Method

- Power mix thinner if required.
- Airless spray
  - Thinner: Enamel Thinner 200 (0-5% by weight)
  - Nozzle pressure: Not less than 10Mpa
  - Nozzle Tip: No.163-415~617
- Brush/Roller
  - Thinner: Enamel Thinner 200 (0-3% by weight)

*Too much thinning results sagging and slower cure.
Clean Up

Clean all the equipment with thinner immediately after use.

Pot Life

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*Use all mixed paint within pot life.

Drying Time

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Surface dry</td>
<td>3 hour(s)</td>
<td>1 hour(s)</td>
<td>1 hour(s)</td>
</tr>
<tr>
<td>Touch dry</td>
<td>5 hour(s)</td>
<td>3 hour(s)</td>
<td>3 hour(s)</td>
</tr>
</tbody>
</table>

*Drying time may vary depending on film thickness, ventilation, humidity, undercoat paint condition etc.

Overcoating Interval

<table>
<thead>
<tr>
<th>Temperature</th>
<th>5 °C</th>
<th>20 °C</th>
<th>30 °C</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>16 hour(s)</td>
<td>12 hour(s)</td>
<td>8 hour(s)</td>
</tr>
<tr>
<td>Maximum</td>
<td>7 day(s)</td>
<td>7 day(s)</td>
<td>7 day(s)</td>
</tr>
</tbody>
</table>

*The overcoating intervals are based on overcoating with same or same type of paint.

Typical undercoat

THERMOTECT 600 (M) SILVER

Typical topcoat

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SAFETY PRECAUTIONS

Detail information is given on Material Safety Data Sheet (MSDS). Avoid inhalation of spray mist or vapour. Avoid skin and eye contact. Paint contacted with skin should be immediately removed with water and/or suitable cleanser. Eyes should be flushed with water and seek immediate medical attention. Since this product contains flammable solvents, keep away from sparks and open flames. Application and handling of this product should be in compliance with relevant national regulations.

STORAGE

Store in dry, cool condition and away from sources of heat and ignition. Containers must be kept tightly closed. Store conditions shall be in accordance with national regulations.

SHELF LIFE

6 months from date of production

GENERAL REMARKS

- Although direct two coats application on to steel surface is possible for in door service, blast cleaning to steel surface is required.
- Make sure to protect painted film from dust in case drying time under normal temperature becomes long before high temperature service starts.
- It is not suitable for strong steam, acid and alkali environment due to poor resistance.
- When over coated, bleeding of undercoat may be observed. The bleeding would stop when second coat of over coat is applied or by spray application.

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ISSUED DATE: 23/09/2010