



SE 65

Technical Data Sheet

Description:

Self-priming silicone paint (2 in 1) resistant up to 650°C

Usage:

A special one-component silicone self-priming paint (2 in 1) for the final treatment of steel, cast-iron objects and constructions exposed to increased thermal stress. Paint is applicable for products with a permanent thermal strain up to 650°C, a short strain up to 700°C. It is used especially for protection of engine parts, heat exchangers, smoke flues, steam pipelines, stoves, fireplaces etc. The second layer apply 25 minutes after the first layer, for brush/roller is recommended to apply the second layer after 16 hours This coating material is not applicable on copper, tinned and zinc-plated surfaces. Stoved coating resists against organic solvents, gasoline, petroleum, dilute acid and alkali solutions.

Substrate:

Steel, cast-iron

Colours:

RAL 9005, RAL 9006

Specific gravity: (ČSN EN ISO 2811-1)

1,13 g/cm³

Solids: (ČSN EN ISO 3251)

by weight 60 %

by volume 39 %

Theoretical spreading rate: (ČSN EN ISO 23811)

undiluted paint			
40 µm DFT	6,5 m ² /kg	7,9 m ² /liter	154,0 g/m ²
80 µm DFT	3,2 m ² /kg	4,0 m ² /liter	309,0 g/m ²

To reach 40 µm DFT apply 103 µm undiluted paint. Practical spreading rate depends on application method and conditions, shape and roughness of the surface.

Drying: (ČSN 673052)

120 µm WFT, temperature 23 ± 2°C, relative humidity 50 ± 5%, outflow time 60s, ISO outflow cup 6 mm	surface dry (grade 1)	to touch (grade 3)	to manipulation (grade 4)
	25 minutes	45 minutes	90 minutes

Drying and recoatability time strongly depend on wet film thickness, temperature, humidity, ventilation and paint colour. Fully load and measure the coated film after 7 days, laboratory testing after 3 weeks of drying under the above conditions.

Gloss: (ČSN ISO 2813)

Matt 9 GU, angle-wise 60°, outflow time 60s, ISO outflow cup 6 mm

Supply viscosity:

Thixotropic liquid unmeasurable by ISO outflow cup type

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Issued: 26.10.2020



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Recommended dilution: (ČSN 673032)

	airless	brush/roller
thinner	KT 01	KT 01
by weight	4 %	5 %
by volume	5 %	7 %

Sagging: (ČSN EN ISO 16862)

temperature 23 ± 2°C, relative humidity 50 ± 5%	
outflow time 60s, ISO outflow cup 6 mm	no sagging 350 µm WFT

Application conditions:

The surface must be dry. The air, surface and paint temperature cannot decrease below +5°C during application and drying. Relative humidity cannot exceed 80%. The surface temperature must be at least 3°C above the dew point.

Surface preparation:

Remove oil, grease, salt and other contamination from the surface with a suitable detergent according to ČSN EN ISO 12944-4. Use thinner or the highly effective ecological cleaner CL 07.

Steel and cast-iron surfaces: Abrasive blast-cleaning to Sa 2½, alternatively manual or mechanical cleaning to min. St 3 corresponding to ČSN EN ISO 8501-1. Apply the paint at least in two layers. The total recommended dry film thickness (DFT) is 80-120 µm. Each layer after drying will be burned at 230 °C for 30 minutes. Burning is not necessary, but the coating without burning is softer and does not resist organic solvents. When burning the whole painting system at the same time, take care of the gradual rise in temperature!

Galvanized substrate: This coating material is not intended for a direct application on this type of surface.

Aluminium substrate: This coating material is not intended for a direct application on this type of surface.

Previously painted surfaces: Remove oil, grease, salt and other contamination from the surface with a suitable detergent, sanding of the surface recommended. Repair all damage to the coating with an anticorrosive primer. Observe the compatibility of preceding and subsequent coats.

Application method:

Spray guns, brush, roller. For airless spraying use the nozzle orifice of Ø 0.011" - 0.021", nozzle pressure: 120 - 180 bar, adjust the angle of application to the shape of the surface. For spraying use the nozzle orifice of 1.5 - 2 mm, nozzle pressure: 3 - 4 bar. For application by brush/roller select appropriate equipment according to the paint type and viscosity.

Storage:

in the original unopened packaging at temperatures between +5°C and +25°C

Packaging in kg:

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Notes:

DFT - dry film thickness
WFT - wet film thickness

MS - medium dry matter
HS - high dry matter

GU - Gloss Unit
KU - Krebs unit of viscosity

All information given in this technical data sheet are based on our best knowledge, laboratory test results and practical experience to the date specified below. According to the fact that the conditions of the product's use are out of our control, we can only guarantee the product quality itself. As a producer we cannot be responsible for damage arising from the use of the products without following above recommended instructions or for improper purposes. We reserve the right to change above specified information without prior notice. Always request the actual version of the product data sheet. This technical data sheet replaces all previously released. The validity of the data provided here will be terminated automatically after five years.

