



Temasilox

Product code: 99V-serie

Hardener: 008 7601

High quality, isocyanate free two component, high solids and glossy polysiloxane paint, which has outstanding colour and gloss retention. Temasilox can be used as a single coat paint and as topcoat.

PAINT PREPARATION

Mixing ratio: Paint : hardener 2 : 1 in volume

The paint and hardener in correct mixing ratio are mixed properly. Power mixer or two component equipment is recommended.

Pot life: 2 h (23 °C)

Thinning: Thinner 1048 or Thinner 1061

PAINTING CONDITIONS

All surfaces must be clean, dry and free from contamination. The temperature of the ambient air, surface and paint should not fall below +5°C during application and drying. Relative humidity of the air should not exceed 80% during application and drying. The surface temperature of steel should remain at least 3°C above the dew point. Good ventilation and sufficient air movement is required in confined areas during application and drying.

PAINTING METHODS

Dry film thicknesses less than 100µm can be sprayed with single layer. Dry film thicknesses over 120 µm should be sprayed with wet-on-wet method, when the first layer is about 100-125 µm wet paint. After 5 - 20 minutes evaporation the paint film is finished by spraying the needed film thickness. The spray pattern should be good / even, that is achieved with correct thinning, adequate paint pressure and correct tip size. Pay attention on the quality of the tip, don't use worn-out tip.

When painting porous substrates like on zinc silicate primer (Temasil 90), apply about 40% thinned Temasilox to fill the pores and avoid bubbles on the finished paint film. After evaporation the painting can be continued like described above.

Air assisted airless spray

Depending on the temperature of the components (paint, hardener and thinner) the mixture is thinned 0 - 5 til-% in airless spray. Spray tip in airless spray should be 0,09"- 0,011". Angle is chosen (30° - 50°) according to the painted object. Nozzle pressure 160-200 bar and possible assisting air 2-3 bar.

Recommended airless spray equipment:

Pump pressure ratio:	1 : 40 - 1 : 60	Tip size:	0,09" - 0,013"
Pump fluid delivery:	3 - 8 liters/min.	Angle:	40°
Paint hoses:	Inner diameter Ø 3/8" (or Ø 1/4", if the length of the hose is less than 15 m)		

Feeding pumps and container mixers should be used with two component equipment.

CURING IN ELEVATED TEMPERATURES

The recommend temperature of the convection oven is +50 °C - +70 °C. Flash off before ovening is not needed. Benefits with the oven curing are faster curing and smoother paint surface.

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