

**TEKNOHEAT 650**  
**Silicone Aluminium Paint**

<b>PAINT TYPE</b>	TEKNOHEAT 650 is a silicone aluminium paint.
<b>USAGE</b>	Used on hot surfaces indoors.
<b>SPECIAL PROPERTIES</b>	TEKNOHEAT 650 forms a silvery coat that withstands heat up to +650°C.

**TECHNICAL DATA**

<b>Solids</b>	30 ±2% by volume		
<b>Total mass of solids</b>	abt. 500 g/l		
<b>Volatile organic compound (VOC)</b>	abt. 630 g/l		
<b>Recommended film thickness and theoretical spreading rate</b>	Dry film (µm)	Wet film (µm)	Theoretical spreading rate (m <sup>2</sup> /l)
	15	50	20,0

As many of the properties of the paint are changed when too thick coats are applied, we do not recommend that the product is applied to a film thickness that is more than 1,5 times the thickest recommended film.

**Practical spreading rate** The values depend on the application technique, surface conditions, overspray, etc.

**Drying time at +23°C / 50% RH (dry film 15 µm)**  
 - dust free (ISO 9117-3:2010) after ½ h  
 - touch dry (ISO 9117-5:2012) after 2 h

The paint film obtains the final hardness when it is dried for added 2 hours at min + 200°C.

NOTE! When the paint film is for the first time heated to more than +200°C, acrid combustion gases are formed in the hardening process. Take then care of good ventilation.

**Overcoatable (dry film 15 µm)**

<b>by itself</b>
Before a new coat is applied the first coat must be heated to the operating temperature: minimum of +200°C for 2 h.

Increase in film thickness and rise in the relative humidity of the air in the drying space usually slow down the drying process.

<b>Thinner, clean up</b>	TEKNOSOLV 9502, TEKNOSOLV 1639
<b>Finish</b>	Metallic
<b>Colours</b>	Aluminium
<b>SAFETY MARKINGS</b>	See Safety Data Sheet.

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**DIRECTION FOR USE****Surface preparation**

Remove from the surfaces any contaminants that might be detrimental to surface preparation and painting. Remove also water-soluble salts by using appropriate methods. The surfaces are prepared according to the different materials as follows:

**STEEL SURFACES:** Remove mill scale and rust by blast-cleaning to preparation grade Sa 2½ (standard SFS-ISO 8501-1). Wire-brushing to preparation grade Sa 2 may be possible in environments with mild corrosivity and in touch-up painting. Roughening the surface of thin-plate improves the adhesion of the paint to the substrate.

**OLD PAINTED SURFACES SUITABLE FOR OVERCOATING:** Any impurities that might be detrimental to the application of paint (e.g. grease and salts) are removed. The surfaces must be dry and clean. Old, painted surfaces that have exceeded the maximum overcoating time are to be roughened as well. Damaged parts are prepared in accordance with the requirements of the substrate and the maintenance coating.

The place and time of the preparation are to be chosen so that the prepared surface will not get dirty or damp before the subsequent treatment.

**Application conditions**

The surface to be painted has to be dry. During the application and drying period the temperature of the ambient air, the surface and the paint shall be above +5°C and the relative air humidity below 80%.

The temperature of the surface to be painted must not be above +50°C.

Additionally the temperature of the surface to be painted and the paint must be at least 3°C above the dew point of the ambient air.

**Application**

Open the lid of the container cautiously as there may be pressure in the container. Stir the paint thoroughly and apply in an even coat.

Apply with paint brush or conventional spray.

**ADDITIONAL INFORMATION**

The storage stability is shown on the label. Store in a cool place and in tightly closed containers.

Additional instructive information for surface preparation can be found in standards EN ISO 12944-4 and ISO 8501-2.

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The information of this data sheet is normative and based on laboratory tests and practical experience. Teknos guarantees that the product quality conforms to our quality system. Teknos accepts, however, no liability for the actual application work, as this is to a great extent dependent on the conditions during handling and application. Teknos accepts no liability for any damage resulting from misapplication of the product. This product is intended for professional use only. This implies that the user possesses sufficient knowledge for using the product correctly with regard to technical and working safety aspects. The latest versions of Teknos data sheets, material safety data sheets and system sheets are on our home pages [www.teknos.com](http://www.teknos.com).

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