

# SILICON HR PRIMER

SILICON HR PRIMER is a silicon resin primer based on silicon resin with curing accelerator. It has excellent heat resistance (up to 700 °C), excellent weather resistance, excellent application workability, and excellent adhesion property.

## TECHNICAL DATA

Type	Silicon resin heat resisting primer				
Recommended Use	As undercoat for boilers, cylinders of engine, inside of exhaust pipes, radiators, oil burners, etc.				
Information	Mixing Ratio	: Base : Curing Accelerator = 100 : 1.53 [by volume] : Base : Curing Accelerator = 100 : 1 [by weight]			
	Color	: White			
	Flash Point	: Base = 19.3, Curing Accelerator = 38.3 [deg C]			
	Density	: 1.39 [g/ml]			
	Volume Solid	: 41 ± 2 [volume %]			
	Coverage (Theoretical)	: 0.061 [L/m <sup>2</sup> ],		0.085 [kg/m <sup>2</sup> ]	
	Film Thickness	: WET 61 [micron], : DRY 25 [micron],			
	Drying Time	Set-to-touch	5 °C	10 °C	20 °C
			1 hr.	50 mins.	30 mins.
	Painting Interval	Hard dry	5 °C	10 °C	20 °C
			7 hrs.	5 hrs.	3 hrs.
	Pot Life	Min.	5 °C	10 °C	20 °C
			24 hrs.	20 hrs.	16 hrs.
Pot Life	Max.	5 °C	10 °C	20 °C	
		-	-	-	
Condition of Application	Method of Application	: Airless spray, Brush, Roller			
	Weather	: Temperature : Min. 0 °C Humidity : Max. 85 % RH Dew Point : + Minimum 3 deg C			
	For Airless Spray	: Viscosity : (Ford Cup #4) 25 - 35 [sec] Tip No. : (GRACO) 415 Paint Output Pressure : 8.8 - 11.8 [Mpa] Spray Speed : 70 - 100 [cm/sec]			
	Thinner	: SILICON THINNER A Thinning : 7 - 15% by volume			
	Surface Preparation	: In case of direct application to the steel surface, ISO Sa2.5 is required. In case of application on shop primer coated surface, ISO St3 is required. The surface to be painted must be clean, free from rust, oil grease or other foreign matter using power wash, detergent or solvent wipe.			
	Preceding Coats	: -			
	Subsequent Coats	: SILICON HR, SILICON HS SILVER			
	Packaging Size	Two pack product			
		Base : 4.95kg, Curing Accelerator : 0.05kg, for size in Indonesia only			
	Storage	Shelf Life / 12 months after the date of production Subject to the satisfactory results of inspection, the product exceeding 12 months may be used.			
Safety	Follow all the local or national Health, Safety and Environment regulation. Read and follow all the precautionary notices on Material Safety Data Sheet and Container Labels. Apply only at ventilated areas. Handle with care.				
Notes	1.Paint film will be fully cured after 2 hours at 200 °C. 2.Total thickness of specification should be less than 150 microns. 3.Density and Volume Solid are measurement data of product samples without thinner. And there are various value depending on color or manufacturing regulation etc.				

The information given in this sheet is effective at the date shown above and subject to revision from time to time without notice.