

# SIP THERM 520

## Silicone High Heat Coating

Product No. 6520

### Features

- Heat Resistance: For peak temperatures up to 650°C and operating temperatures of 550°C.
- Air Drying.
- Easy Application.
- High performance silicone resin and thermally stable pigments.
- Approved under APCS-11B

### Recommended Use

- Stacks, Boilers, Breechings, Kilns, Furnaces, Piping, Pumps, Manifolds, Process Vessels and Stainless Steel.
- Service temperature of 180°C or higher is desirable to ensure optimum film properties in terms of chemical and weathering resistance.

### Physical Data

**Colour** : Aluminium

**Volume Solids** : 34%

**Recommended Film Thickness:**  
20 microns dry = 60 microns wet

**Theoretical Coverage:**  
17 m<sup>2</sup>/ltr. at 20 microns

**Density** : 1.12 kg/ltr.

**Drying Times:**

25°C/ 50% RH

Tack Free : 1 - 2 Hours

Recoatable : 12 Hours

Maximum Recoating Time : No Limit

**Heat Resistant** : 650°C dry

**Flash Point** : 28°C

### Specification Data

#### Preparation

All surfaces must be free of oil, grease, moisture and other foreign matter prior to blast cleaning. Round off all rough welds and sharp edges. Remove all weld spatters. Abrasive blast to near white metal, equivalent to Steel Structures Painting Council SP10 or ISO 8501-1 Sa 2.5. The steel profile after blast cleaning should be 0.25 mils to 1.0 mil (6 to 25 microns) in depth, with an average of 0.5 mils (13 microns), and be of a jagged nature as opposed to a peen pattern. Surfaces must be free of grit dust. Coating should be applied to cleaned surfaces as soon as possible to prevent rerusting or contamination. Spot prime all bare areas as recommended before applying finish coats.

SIP THERM 520 may be used over a compatible inorganic zinc rich primer such as SIPZINC 120, 130 and 150 Primers.

## Application Data

<b>Mixing Advice</b>	Use mechanical agitation for proper mixing, such as Jiffy Mixers or similar commercially available mixers. Stir until thoroughly mixed. Prior to application, strain mixed material through 30 - 60 mesh screen or other suitable filtration device. Do not thin the material.
<b>Thinning</b>	Thinning is not required.
<b>Application Methods</b>	Air or Airless spray, Brush or Roller.
<b>Application Details</b>	<p>Airless Spray - 30 : 1 pump and 0.011" tip size will provide a good spray pattern.</p> <p>SIP THERM 520 is applied at 1.0 mil (25 microns) per coat. In exterior areas two coats are recommended, or one coat when used over an inorganic zinc primer.</p> <p>Allow the first coat to dry for at least 4 hours at 25°C before applying next coat. SIP THERM 520 air dries at normal temperatures allowing for transport and handling, though total cure for maximum durability will be achieved only after being placed in service for approximately one hour at 204°C. When applying over inorganic zinc, air dry for 72 hours prior to placing in service.</p> <p>In application over inorganic zinc rich primers, allow full cure of the inorganic zinc primer prior to application of SIP THERM 520.</p>
<b>Cleaning of Equipment</b>	Use Thinner 730.

## Storage

<b>Pack Size</b>	5 ltr. can
<b>Storage</b>	Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.
<b>Shelf Life</b>	1 Year

## Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

## Disclaimer

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