



# Lumeros 37 Silicone Acrylic Finish

## Single Pack Silicone Acrylic Heat Resistant

Issue Date : Nov 2024

### Product Description

A protective coating designed for use in areas where heat resistance is required. It is recommended for application over Zinc Silicate Coating or Epoxy Zinc Primer for resistance to weather and moisture. The product is suitable for use on steel, subject to elevated temperature in industrial environment.

### Usage Areas

Suitable for use on stacks, ductings, equipment, pipings for temperature resistance up to 200°C

### Product Data

| Composition                | Modified Silicone Acrylic medium suitably pigmented with Aluminium |
|----------------------------|--|
| Volume Solids              | 43±2%  |
| VOC                        | 498 gms/ltr  |
| Application Method         | Brush or Spray   |
| Recommended DFT            | 25-40 µ per coat   |
| Recommended WFT            | 58-93 µ per coat   |
| Theoretical Spreading Rate | 10.8-17.2 m²/ltr /coat   |
| Colour                     | Grey, Aluminium  |
| Gloss                      | Medium High Gloss  |

Practical Coverage : Dependent on-site condition and transfer losses due to substrate design, profile, wind, heights, application method, painter's skill etc.

### Pot Life

| 10°C | 15°C | 25°C | 40°C |
|------|------|------|------|
| NA   | NA   | NA   | NA   |





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|                         |  |                                      |   |
|-------------------------|--|--------------------------------------|---|
| Typical Coating Systems | Systems compatibility can be provided on request to the Technical Service Team |                                      |   |
|                         | Coats  | Generic Systems                      | Compatible Products                                     |
|                         | Primer   | Zinc anode Coating, Zinc Rich Primer | Zinc Anode 304 HS Silicate Coating, Epilux HB ZR Primer |
|                         | Mid Coat   | Heat Resistant                       | Lumeros 37 Silicone Acrylic Finish                      |
|                         | Top Coat   | Heat resistant (Optional)            | Lumeros 37 Silicone Acrylic Finish                      |

|           |        |       |             |        |
|-----------|--------|-------|-------------|--------|
| Pack size |        | UOM   | Single Pack | Total  |
|           | Volume | Lt/Kg | 20 ltr      | 20 ltr |

|         |   |
|---------|---|
| Storage | The paints must be in its sealed original containers and be kept under cover in a dry place with ambient conditions inside closed room until use. The curing agent is sensitive to moisture and hence relative humidity within the room should be maintained preferably at $\leq 55\%$ . Stacking should not be more than 3 drums / cartons one above other. DO NOT expose to direct rain/ sunlight. Any deviation to the defined storage condition shall have a negative effect on the shelf life. |
|---------|---|

|            |  |
|------------|--|
| Shelf life | <p>Up to 12 months as long as the sealed original containers are kept under cover in a dry place under normal temperature conditions until use.</p> <p>Note :</p> <ol style="list-style-type: none"> <li>Storage life @23°C will be extended up to 24 months. Storage at elevated temperatures may reduce shelf life; and hence never exceed maximum room temperature of 40°C. Storage life, thereafter, subject to re-inspection; consult tech-service.</li> <li>It may be noted that higher volume solid material will tend to soft settling on long term storage, and it can made to a normal homogeneous consistency by use of a slow speed 200-400 rpm power stirrer particularly in the PART A (BASE) container; and this soft settling is not considered as a failure of keeping properties.</li> </ol> |
|------------|--|

|             |             |
|-------------|-------------|
| Flash Point | Mixed Paint |
|             | 25°C        |

|                 |   |
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| Health & Safety | Please refer to the separate Safety Data Sheet available with detailed information. |
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### APPLICATION GUIDELINE

|                              |  |   |
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| <b>Substrate</b>             | Mild Steel   |   |
| <b>Surface preparation</b>   | <p><b>Mild Steel :</b> Remove grease, oil and other contaminants preferably by using Solvent Cleaning as per SSPC SP1. For Application of Primer: Abrasive Blast clean to a minimum SSPC SP10. For severe corrosive conditions, blast clean to a surface profile not exceeding 55 microns. Special care must be taken on weld areas to remove flux and spatter; welds should be ground back to avoid pockets. The cleaned surface should be free of dust, contaminants and dry and coated before it gets primed.</p> <p><b>Application over Primer :</b> The primed surface should be free of white rust, dust, contaminants and dry and air used for blowing should be free of oil and moisture. Repair if corrosion spots are developed during fabrication and it should be suitably primed. For aged primers adopt SSPC SP2 or SP3 before application of top coats.</p> |   |
| <b>Atmospheric Condition</b> | Ventilation  | Suitable air engineering systems, which will ensure reduction of air contaminants and thatto further help regulate the temperature and humidity of the working environment. |
|                              | Dew Point  | Ensure surface temperature to be more than 3°C over the dew point temperature.  |
|                              | Humidity   | Do not apply when relative humidity rises above 85%.  |
| <b>Mixing</b>                | <p>Stir the base thoroughly and then mix base to a homogenous liquid and then add recommended part of catalyst to uniform consistency.</p> <p>NOTE : DO NOT ADD THINNER beyond recommendation as it will reduce mixed VS calling for revised WFT calculations as well as challenges on flow properties.</p>  |   |
| <b>Thinner</b>               | Thinner 853  |   |





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| Application            | <p><b>Brush</b> : Apply without thinning to recommended thickness.</p> <p><b>Conventional Spray</b> : Add upto 3% Thinner 853, depending on conditions. Use any standard equipment at an atomizing pressure of 2.8 - 3.5 Kg/Cm<sup>2</sup>.</p> <p><b>Airless Spray</b> : Apply preferably without thinning. However add upto 10% Thinner depending on conditions. Use any standard equipment having pump ratio 30 : 1.</p> <p><b>Tip Size</b> : 0.33– 0.43 mm.</p> <p><b>Tip Pressure</b> : 110 –140 Kg/cm<sup>2</sup>.</p> <p>*Do not apply on hot/ cold surfaces. Always apply within the window of 10-50°C.</p> |           |          |
| Work Stoppage          | <p>Ensure to use the mixed paint within pot life as there are no methods to increase working pot life. Keep the working tools and tips free of drying and clogging. Always use fresh material and never add-up to previous mixed paints.</p>  |           |          |
| Clean Up               | <p>Clean all equipment immediately after use with thinner 853. It is good working practices to flush or clean all the spray equipment periodically. All the surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations.</p>   |           |          |
| Drying Time            | Temperature   | Touch dry | Hard dry |
|                        | 10°C  | 60 min    | 4 hrs    |
|                        | 23°C  | 20 min    | 3 hrs    |
|                        | 30°C  | 15 min    | 2 hrs    |
|                        | 40°C  | 10 min    | 1 hrs    |
| Over Coating Intervals |   | @23°C     | @30°C    |
|                        | MIN   | 3 hrs     | 2 hrs    |
|                        | MAX   | 2 Weeks   | 2 Weeks  |





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| <b>Curing Time</b>             | <p>One week minimum</p> <p>NOTE : Drying and Curing times are determined under controlled temperatures and at relative humidity below 85%, for the NDFT of the product.</p>  |
| <b>Inspection</b>              | <p>Refer SSPC PA2 guidelines for measurement of DFT.</p> <p>Do not conduct any destructive test like peel off/ pull off &amp; high voltage Holiday test unless and otherwise mandatory in the specification.</p> <p>Consult Technical Service team for preparation of QAP (Quality Assurance plan).</p>  |
| <b>Repair Methodology</b>      | <p>Clean off loose paints, debris, contaminants and ensure spot repair with available tools as practiced in hand/ power tool cleaning using wire brush/buffing, emery/feathering to smoothen the edges of impaired areas. Use appropriate touch up primer followed by recommended coating system, allowing due over coating interval time to area of 2-3 inches in excess of the spot repaired portion.</p>  |
| <b>Product Characteristics</b> | <ul style="list-style-type: none"> <li>• When overcoating weathered zinc silicate primers the surface should be clean, free from contamination, and the presence of zinc corrosion products.</li> <li>• Zinc epoxy primers will also provide satisfactory anti-corrosive protection for in-service temperatures up to 150°C. Hence touch up with Epoxy Zinc should be used in caution.</li> <li>• Addition of Thinner in paint is normally not advisable.</li> <li>• The coating has to be air dried for a min. of 24 Hrs, before putting into service at elevated temperature.</li> <li>• Do not apply during rain, for or mist.</li> </ul> |
| <b>Disclaimer</b>              | <p>The information contained within this Data Sheet is based on information believed to be reliable at the time of its preparation. The Company will not be liable for loss or damage howsoever caused including liability for negligence, which may be suffered by the user of the data contained herein. It is the users' responsibility to conduct all necessary tests to confirm the suitability of any product or system for their intended use. No guarantee of results is implied since conditions of use are beyond our control.</p>   |