



ONE COMPONENT OVEN VARNISH

THERMODUR 600 HPNS 1K

- no fumes at the first heating
- excellent temperature resistance
- layer thickness approx. 20 µm TSD

High temperature resistant 1-component oven lacquer based on a special silicone resin. This varnish distinguishes by its excellent resistance to high temperatures and stability to colour-shade at temperatures up to 600°C.

APPLICATION

PROCESSING	NOZZLE TYPE	VISCOSITY	PRESSURE
Air syringe	1,5–1,8 mm	processing in mixing viscosity	2,5–3,5 bar
Airless	0,28–0,33 mm	processing in mixing viscosity	70–100 bar

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APPLICATION:

Application:

spraying, air-atomisation, electro-static, airless

Application instructions:

No processing below 10°C!

Delivered viscosity:

DIN 53211 4 mm, 40–45 sec.

Film thickness:

approx. 20 µm DFT (minimum 10 µm DFT, maximum 50 µm DFT)

Thinner:

87052, 200 Use thinner 87052 for dilution and for cleaning the tools.

Drying:

DIN 53150 – Air drying or forced drying

Repair of mechanical damages with Thermodur 600 Spraycans.

DRYING TIME

DRYING	TIME
Forced drying	20 Min./40°C 15 Min./60°C
Air drying	60 min./20°C

Shelf life:

at least 6 months

Solids content:

EN ISO 3251 50 +/- 3 % in mixture e.g. black

Volume-solids content:

calculated 34 +/- 3 % in mixture e.g. black

Specific weight:

EN ISO 2811-2 – 1,19 +/- 0,05 g/ml/20°C in mixture e.g. black

Theoretical consumption:

14,4 m²/kg with 20 microns DFT

Solids content, volume, specific weight and theoretical consumption depend on the colour.

TECHNICAL DATA

Colours:

black, anthracite, silver-grey, cast grey etc. (behold colour tint card)

Gloss degree:

mat

Substrate:

Pure wipe degreasing
conditionally suitable (depending on the quality of the steel)
Radiation recommended
steel sheet: sandblasted;
sand blasting – SA 2,5 according ISO 8501-1
cast steel:
sand blasting – SA 2,5 according to ISO 8501-1
Ra value = 3–5 µm and Rz value = 20–30 µm according DIN EN ISO 4287; Do not use chemically treated sheets;



This data is based on experience, for its completeness we assume no liability. As we take no influence on the processing, it lies within the obligation of the customer to test, whether it is suitable for the intended purpose, before using the product. Any change in the processing procedure, the environmental conditions or the failure to comply with instructions may unfavourably influence the result.