



Okitsumo Heat-and Acid-Resistant Paint AR-250

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1. Application

- Inside of chimney flue
- Dust collector

2. Characteristic

Item	Content
Appearance	2 liquid type
Type of packing	4Kg set, 16Kg set (Base : Hardener=96 : 4)
Color	Gray
Luster	Semi-gloss
Density(23°C)	Base : 1.58±0.08 g/ml Hardener: 0.75±0.08 g/ml
Viscosity (23°C)	Liquid part A BM-type viscomater 6/6 30,000mPa·s
Nonvolatile content	Liquid part A: 76.0±2.0%
Flash point	Liquid part A: 11°C Hardener: 10°C
Ignition point	Liquid part A: 480°C(toluene) Hardener: 480°C(toluene)
Shelf life	6 months
Danger sign	Liquid part A: Class4 grade2 petroleum Hardener: Class4 grade2 petroleum
Division of organic solvent	Liquid part A: Type II organic solvent Hardener: Type II organic solvent
Toxic substance	Liquid part A: xylene ethyl benzene toluene ethylene glycol monoethyl- ether acetate Hardener: toluene

Note: The value mentioned above shows the standard and there are some fluctuations.

3. Coating standard

Item	Content		
Appropriate Substrate	Iron		
Pre-treatment	SSPC-SP5,SSPC-SP10,SSPC-SP8, SIS Sa3,SIS Sa2 1/2 (Remove the rust, old coated film, oil and water stain completely until the base metal is exposed.)		
Paint Preparation	Mix the hardener(Liquid part A:Hardener=96:4) well before use, disperse uniformly		
Potlife	4Hrs		
Diluent	No.50B thinner, No.100B thinner		
Coverage	650g/m ²	840g/m ²	
Coating method	Coating method	Brush coating	Air-less coating
	Dilution	10~15wt%	10~30wt%
	Passes to spray or brush	4 pass	3 pass
	Dry Film Thickness	250μ m	
Ex. Of airless coating condition	Nozzle No: 07C09(ASAHI SANAC) Pressure: 8~10MPa(secondary pressure)		

Drying	Temp.	5°C	20°C	30°C
	to touch	4Hrs	2Hrs	2Hrs
	to handle	24Hrs	16Hrs	16Hrs

Note

- Depend on the air temperature or individual condition, the coverage may be changed.
- The film thickness mentioned above is supposition.
- Regarding to the detail of specification, please refer to the enforcement spec.

4. Precautions

- 1) Use after mixing well until no lumps of the solids remain.
- 2) Paint after removing oil, moisture, dust on the surface.
- 3) Do not paint under the condition mentioned below.
 - ① The day of rain and snow.
 - ② When the air temperature is under 5°C
 - ③ When the difference between air temp. and the dew point is within 3°C.
 - ④ When the relative humidity is over 85%.
 - ⑤ The day of gale.
- 4) Drying at room temp. only makes the paint film dried to touch.
To cure the paint it requires baking at 180°C for 20mins.
- 5) The coated film might become adherent temporarily and emit the smoke when the painted machine starts up for the first time.
But it will eventually stop smoking and soon be hardened.
- 6) Ensure to use the paint within the potlife after adding the hardener.
- 7) Regarding the general precautions for handling or others, please refer to MSDS.