



**SHALIMAR  
PAINTS**



# TUFFKOTE

PROTECTIVE COATINGS

## LUSTROTHERM HT 400 SILICONE ALUMINIUM PAINT

DATA SHEET NO. 2006-049

A single pack high performance heat resistant aluminium paint based on silicone resin medium for protection of steel surface operating between 250o C – 400o C dry heat.

### Product Information

Colour	Aluminium
Finish	Bright Metallic
Flash Point	Above 23° C
Volume Solids	15% approximately
Recommended dry film thickness	15 microns per coat
Corresponding wet film thickness	100 microns
Theoretical Spreading Rate	10.0 Sq. metre per litre
Drying time	Dust Free 4 hours
Curing	Apply 1st coat. Air dry for 24 hours. Alternatively heat cure at 200° C for 1 hour after 4 hours of air drying. Apply 2nd coat. Allow it to dry overnight and then gradually raise the temperature to working temperature.
Interval before Overcoating	Minimum - 18 hours Maximum - Indefinite
Storage life	Upto 12 months so long as the material is stored in sealed containers under standard warehouse storage conditions. Avoid exposure to heat and moisture during storage.
Dry Heat Resistance	Upto 250° C - 400°C (Continuous)

### Surface Preparation

#### Steel Surfaces:

Degrease and blast clean to Sa 2 ½ grade minimum of Swedish specification SIS-05-5900-1967.

If blast cleaning is not practical make full use of mechanical tools along with manual cleaning and wire brushing to remove loose rust/scale to St 2 or St 3 grade of Swedish specification. Surface should be perfectly clean and dry before application of HT-400.

### Application Details

#### Method of Application:

Brush / Conventional Spray

Airless spray not recommended for difficulty in controlling film thickness

Thinner: Thinner 6752

### Uses

For painting of Chimneys, Flare Stacks, Exhausts, Pipe works, Incinerators and similar surfaces exposed to dry heat attack.

System Selection Guide

<b>SURFACE</b>	Steel (Upto 250° C - 400°C)	Steel (Upto 250° C - 400°C)
<b>1<sup>st</sup> COAT</b>	Tuffkote Zilicate	Lustrotherm HT 400 Silicone Aluminium
<b>2<sup>nd</sup> COAT</b>	Lustrotherm HT 400 Silicone Aluminium	Lustrotherm HT 400 Silicone Aluminium
<b>3<sup>rd</sup> COAT</b>	Lustrotherm HT 400 Silicone Aluminium	-

Chemical Resistance Guide

<b>EXPOSURE</b>	Acids	Alkalis	Solvents	Salt	Water
<b>SPLASH &amp; SPILLAGE</b>	Fair	Fair	Good	Good	Excellent
<b>FUMES &amp; OUTDOOR EXPOSURE</b>	Good	Good	Good	Very Good	Excellent

- NOTES**
1. This cancels all previous literature on this product and is subject to revision without notice
  2. Do not apply when temperature falls below 10° C or rises above 50° C and when relative humidity rises above 90%. Do not apply during rain, fog or mist.
  3. The paint should not be applied on hot surface. After complete drying of the final coat the painted surface should be gradually heated to the working temperature
  4. For maximum corrosion protection, when chimney is not in continuous operation, a coat of heat resisting primer (e.g. Tuffkote Zilicate) is recommended over blast cleaned surface.
  5. For zinc silicate primed steel, surface should be clean, dry, and free from zinc salts and the film fully cured.
  6. Use of thinners other than supplied or approved by Shalimar may adversely affect product performance and void product warranty whether express or implied.

Health and Safety

Please refer to the separate safety data sheet available with detailed information.

Precaution

1. Not to be used in areas of high acidity or alkalinity.
2. Does not cure and remains soft until temperature reaches min. 2000 C.
3. Improper curing of this product can cause rusting, flaking and blistering.
4. At the time of application metal must be at room temperature.
5. Avoid applying thick coats since that may cause blistering.
6. Check actual skin temperature before selecting this product.



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