

Stokes HR Matt Black

Product Description	A heat resistant, silicone resin based , matt black finish.			
Features & Use	<ul style="list-style-type: none"> • Use for metal surfaces operating up to 400°C, with an occasional surge up to 500°C • Good resistance to water, dilute acids and alkalis • Excellent flexibility 			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Matt			
Volume Solids	9 ± 2%			
VOC Content	776 ± 20 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	15 µm	166 µm	6.0 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 15 microns DFT	+23°C		
	Touch Dry	1 - 2 hr		
	Hard Dry/Overcoat	2 hr		
	Full cure	1 hr @ 200°C		
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation			
Colours	Black			
Product Code	20HRS-MAB			
SG	0.93 kg/lit			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 12 months if stored as above in unopened containers			
Flash Point	23-60°C			

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Surface Preparation	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Performance will depend on degree of surface preparation obtained It is recommended to blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns. Where blast cleaning is impractical the surface should be prepared to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface Do not apply over a primer or previous coatings 														
Mixing	Mix thoroughly before and during use.														
Thinner	No.7 Thinner		Equipment Cleaner No.7 Thinner												
Application Conditions	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="451 909 692 987">Method</th> <th data-bbox="692 909 938 987">Airless Spray</th> <th data-bbox="938 909 1185 987">Conventional Spray</th> <th data-bbox="1185 909 1339 987">Brush</th> <th data-bbox="1339 909 1490 987">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 987 692 1043"></td> <td data-bbox="692 987 938 1043">Yes</td> <td data-bbox="938 987 1185 1043">Yes</td> <td data-bbox="1185 987 1339 1043">Yes</td> <td data-bbox="1339 987 1490 1043">Yes</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes
	Method	Airless Spray	Conventional Spray	Brush	Roller										
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<ul style="list-style-type: none"> Airless spray: do not overapply or blistering may occur on heating Conventional spray: thin as necessary 															
Product Notes	<ul style="list-style-type: none"> For exterior use, 2 coats are recommended to a total dft of 25 microns Do not exceed 15um dft per coat or blistering may result on heating The coating needs to be fully cured before optimum protection is provided Apply at normal ambient temperatures (approx. 20°C), do not apply to surfaces at hot operating temperatures 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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