



### NAPSIL-HT NAPKO 4995X901 HIGH HEAT ALUMINUM

- Product description:**
- EXCELLENT RUST-INHIBITIVE COATING IN HIGH TEMPERATURES
  - FOR PEAK TEMPERATURES UP TO 800°C
  - EXCELLENT FOR USE ON EXHAUST STACKS, BOILER FRONTS, INCINERATORS, AND OTHER EQUIPMENT
  - RESISTS STEAM AND WEATHERING
  - COMPLIES WITH NOM-018-STPS-2000
  - COMPLIES WITH NOM-003-SSAI-1993
  - COMPLIES WITH NORM 4.411.01

### Technical information:

|  |   |
|--|---|
| <b>CLASSIFICATION</b>                        | Silicone  |
| <b>FINISH</b>                                | Metallic  |
| <b>COLOR</b>                                 | Aluminium   |
| <b>APPLICATION METHOD</b>                    | Brush, air or airless spray   |
| <b>REDUCER</b>                               | Napko 4022  |
| <b>DRYING SCHEDULE AT 25°C AND 50% R. H.</b> |   |
| <b>TO TOUCH</b>                              | NA  |
| <b>TO RECOAT</b>                             | 8 hours minimum   |
| <b>THEORETICAL COVERAGE</b>                  | 14.9 m <sup>2</sup> /L a 1.0 Mil (25.4 microns)<br>7.4 m <sup>2</sup> /L a 2.0 Mil (50.8 microns)<br>(Take into account application losses) |
| <b>VOC, MAXIMUM</b>                          | 560 g/L   |
| <b>VISCOSITY AT 25°C</b>                     | 27 to 40 seconds Ford cup No.4  |
| <b>DENSITY AT 25°C</b>                       | 1.050 ± 0.050 kg/L  |
| <b>VOLUME SOLIDS</b>                         | 38.1 ± 2%   |
| <b>RECOMMENDED DRY THICKNESS</b>             | 1.0 mils per coat (25.4 microns)  |
| <b>NUMBER OF RECOMMENDED COATS</b>           | 2   |
| <b>NUMBER OF COMPONENTS</b>                  | 1   |
| <b>RECOMMENDED PRIMER</b>                    | The same or Napko 4995M081  |
| <b>CURING SCHEDULE</b>                       |   |
| <b>FOR IMMERSION</b>                         | Not recommended   |
| <b>FOR NON-IMMERSION AND/OR MAINTENANCE</b>  | 1 hour at 250°C*  |
| <b>TEMPERATURE RESISTANCE</b>                | 540°C dry   |
| <b>CLEANING SOLVENT</b>                      | Napko 4022  |

\*After second coat is applied, allow the coating to dry to air temperature for 35 minutes, then the product must be cured for one hour at 250°C.



## NAPKO 4995X901: APPLICATION GUIDE

### SURFACE PREPARATION:

If application is to be made over carbon steel, surface must be prepared to white metal blast cleaning (SSPC-SP5).

### MIXING:

Stir until thoroughly mixed the product. Napko 4995 Series Aluminum does not normally require thinning for application, but if thinning is required, it can be accomplished with small quantities of Napko 4022 only for viscosity control. Prior to application, strain mixed material through 30 to 60 mesh screen.

### NECESSARY EQUIPMENT:

- 1) High production air-operated spray equipment.
  - Pressure pot with mechanical or pneumatic stir.
  - Spray gun such as DeVilbiss model JGA-502 with tip combination 704FX or Graco spray gun model # 700 with kit of needle and fluid tip No. 106-735 and with air cap No. 106-803.
- 2) Airless spraying equipment.
  - Airless pump with minimum compression ratio of 30:1
  - Airless spray gun with 0.017 to 0.021 inch ID nozzle.
- 3) Humidity and oil separating filters in the air lines.

### APPLICATION PROCEDURE:

- 1) Prior to application, rinse equipment with Napko 4022 before use.
- 2) Once the product is well mixed, add it to the material pressure pot.
- 3) Add pressure to the material pot and open fluid discharge valve so that the coating flows to the spray gun air cap, hold gun at waist level parallel to the ground and pull trigger realising fluid. Proper pressure is established when stream strikes the ground approximately four feet from the operator.
- 4) Open atomization air valve on material pot. Adjust regulator to achieve 60 psi of pressure. Test spray pattern.
- 5) The spray gun should be held approximately 10 inch from the surface. Apply the material in one wet coat, overlapping each pass 50% and holding the spray gun at right angles to the surface at all times. Special attention should be given to all edges, pits, welds, corners, rivets and other rough spots to insure complete coverage.
- 6) Drying time depends of atmospheric temperature and relative humidity, under these conditions, the film will achieve a totally state of insolubility in approximately 24 hours.
- 7) Do not apply coating unless surface temperature is at least 3°C above dew point.
- 8) Before placing Napko 4995 Series Aluminum into service and after the second coat is applied, dry to air temperature for 35 minutes and then the coating must be cured for one hour at 250°C.
- 9) All equipment used with Napko 4995 Series Aluminum should be cleaned with Napko 4022 Thinner immediately after use.

### SAFETY:

**WARNING!!** Flammable product, keep away from high temperature, spark and flame. Contains highly toxic solvents. Prolonged exposure through any means or prolonged or repeated breathing of vapor causes serious health damage. Keep out of reach of children.

Sale to minors prohibited. Do not ingest. If ingested, do not induce vomiting. Seek immediate medical attention. Avoid skin and eye contact.

Use product with adequate ventilation. Keep container tightly closed after each use.

#### LIMIT OF LIABILITY

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