

## GEHODUR-S330-Aluminium

**1C-Si Topcoat**  
**temperature resistant up to +600 °C**  
**BASF-No.: 3343 794**

### ■ FIELDS OF APPLICATION

Together with a suitable primer coating for protective coatings which are both resistant to high temperatures and natural weathering, e.g. for outer sides of equipments, pipes, machines and other steel structures.

The use of GEHODUR-S330-Aluminium in the application range of the Directive 2004/42/EG "Decopaint-Directive" is not allowed (e.g. coating of buildings or building parts).

### ■ PRODUCT PROPERTIES

GEHODUR-S330-Aluminium is based on special silicone resins and metal pigments with their specific properties.

GEHODUR-S330-Aluminium results together with a suitable primer coating in a coating system which shows good protective qualities already at normal temperatures.

The optimal degree of crosslinking as well as the best weather resistance is only achieved when the materials are exposed to higher temperatures, e.g. one hour at 230 °C or 24 hours at a minimum of 160 °C.

The coating system may also be used for objects where higher temperatures arise only after some time, fulfilling the stoving conditions and allowing optimal crosslinking of the coating film. However, it must be noted that non-stoved coatings are thermoplastic in the temperature range of 40 to 160 °C. This point is particularly important when different temperatures occur on different spots of the object to be coated.

### ■ PRODUCT DATA

#### GEHODUR-S330-Aluminium

**Product number and colour** S330-F7700  
Bright silver

**Form of delivery** Ready for spray and brush application

**Shelf life** At least 3 months in original cans at normal temperature

**Suitable thinner** V-89

#### **Theoretical parameters** GEHODUR-S330-Aluminium, S330-F7700

Density (g/mL)	Solid content (weight %)	VOC-content		Solid content by volume	
		(weight %)	per 10 µm DFT* (g/m <sup>2</sup> )	(%)	(mL/kg)
1.1	42	58	23.5	27	245
DFT (µm)	Calculated wet-film thickness (µm)	Consumption (kg/m <sup>2</sup> )		Spreading rate (m <sup>2</sup> /kg)	
20	74	0.081		12.3	

#### Remarks

- All values are relevant for the mixture in case of two-pack materials
- DFT: Dry film thickness
- All values named are approximate values and relevant for the quality (colour).  
The values may differ slightly for other colours.
- \* baseline for calculation: consumption in g/m<sup>2</sup> at DFT 10 µm

**Coating systems**     Suitable primer coatings:

GEHODUR-F330-Zink-S1	BASF-No.: 3343 417
GEHODUR-F330-Zink-S2	BASF-No.: 3343 417

Note: The temperature resistance of the total system depends on the temperature resistances of the individual products/layers. Please observe the information in the respective data sheets.

■ **INSTRUCTIONS FOR APPLICATION**

**Surface preparation**     Existing primers must be intact as well as dry and clean.

**Air and surface temperature**     Optimal results at temperatures of 15 to 25 °C, not below 5 °C.

**Relative humidity**     Max. 80 % relative humidity

The surface temperature of the parts to be coated must be at least 3 °C above the dew point of the surrounding air throughout the application. (see basic specification for corrosion protection EN ISO 12944-7)

**Comments on processing**

**Application methods**

Means of application / parameters	recommended nominal dry film thickness per working operation	Addition of thinner V-89
Airless spraying Nozzle diameter: 0.28 to 0.38 mm Material pressure: 150 to 250 bar	25 to 30 µm	up to 1 %
High pressure/air spraying Nozzle diameter 1.5 to 2.0 mm Pressure 3 to 4 bar	25 to 30 µm	1 to 2 %
Roller coating / brush application	15 to 30 µm	ready for brush application at delivery

In case of roller coating / brush application several working operations can be necessary to obtain a uniform layer thickness and appearance. Among other things this depends on the colour, the processing procedures and equipment, the ambient conditions and the geometry of the parts to be coated.

Remarks     • The values above are related to a temperature of approximately 20 °C and are recommendations respectively rough guides. In practice it may be necessary to make modifications.

GEHODUR-S330 is preferably applied by spraying.  
If other coating materials are used in the same room at the same time, GEHODUR-S330 materials may cause coating defects.

**Drying and curing times**

GEHODUR-S330-Aluminium

(Related to a temperature of 20 °C and a DFT of 20 µm)

dry to touch:

After 30 to 60 minutes

Best film formation only after stoving e.g. for 1 hour at 200 °C or for min. 24 hours at minimum 160 °C (for instance at normal object temperature).

■ **SAFETY MEASURES**

The relevant data concerning safety measures can be found in the material safety data sheet of this product.

The valid issue of the material safety data sheet is available from our website [www.geholit-wiemer.de](http://www.geholit-wiemer.de).

The statements made here are based on the present state of our knowledge. We do not assume liability for damages resulting from the use of the material or from any advice given by our employees. In this respect, any advice given by our employees has to be seen as not binding. The processor is responsible for the supervision of construction, the maintaining of process guidelines and the observation of the established rules of techniques, even if our employees are present at the time our material is being applied.

This information is subject to modifications due to technical improvements. The latest edition of this information replaces all previous issues.