



Pyrotec HR 350™



POWDER & INDUSTRIAL COATINGS

Heat Resistant Powder Coating			
Product Code:		979 Line	
Description			
Pyrotec HR 350™ products are heat resistant powder coatings designed for applications requiring service temperatures up to 350°C, while maintaining physical integrity. Extremes of heat will alter gloss and colour of these coatings according to the temperature to which the coating is subjected. Pyrotec HR 350™ exhibits decorative characteristics suitable for internal use, combined with excellent overall performance.			
Features		Benefits	
Extreme heat resistance		Designed for service temperatures from 180°C up to 350°C (depending on formulation)	
Film integrity		Long intact life of coating	
Tough hard finish		Hard wearing/serviceable finish	
No solvents or emissions		Less waste and pollution to the environment	
Uses			
Pyrotec HR 350™ has a multitude of uses over shot blasted mild steel. Because of the unique nature of Pyrotec HR 350™ it is important that you check with your Dulux Powder Coatings Representative to determine the suitability of the product for its intended use.			
Performance Guide			
Weather	Poor resistance to direct UV exposure. Not for external use.	Salt Spray	Shot blasted mild steel to Class 2.5 (250 hours ASTM B117).
Heat	Excellent resistance from 180°C up to 350°C (depending on formulation)	Humidity	Resistant to 38°C/100% humidity for 250 hours on shot blasted mild steel Class 2.5.
Acid	Resistant to spills of dilute acid. Avoid contact.	Abrasion	Very good resistance to abrasion.
Alkali	Resistant to spills of dilute alkali. Avoid contact.	Pencil Hardness	2H
		Knoops Hardness	Average 15
Flexibility	Pass < 0.25 mandrel	Cross Hatch Adhesion	No removal
Chemical Resistance			
Ethyl Acetate	Softens/avoid contact	White Spirits	Resistant
Ethanol	Resistant	Xylene	Slight softening/limit contact
Methyl Ethyl Ketone	Softens/avoid contact		

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Product Guide			
Colour	Limited range. Refer to your Dulux Powder Coatings Representative.	Specific gravity	1.3 – 1.7 @ colour
Gloss Level	3 – 15% at 60°	Shelf life	12 months when stored below 25°C/dry conditions

Application Data			
Application Method	Electrostatic spray.		
Clean Up	Dust or vacuum loose powder. Avoid use of compressed air.		
Cure Schedule	Metal Temperature (°C)	Time (minutes)	
	200	20	
Cured Film Thickness	Recommended:	70 µm	
	Range:	40 – 100 µm	

Theoretical spreading rate at recommended film thickness

A spreading rate of 15 m²/kg corresponds to 65µm cured film thickness assuming no loss. Practical spreading rates will vary due to such factors as method and conditions of application and surface profile and texture.

Application Guide	
Surface Preparation	
<ul style="list-style-type: none"> Surfaces should be degreased and free from any oxides, mill scale, greases and lubricants for optimal performance. Substrates should be grit blasted with angular grit to SA 2.5 finish. To avoid “flash rusting”, ferrous metal should be pre-treated immediately with Zinc Phosphate or Iron Phosphate (refer BS6497 and/or AS/NZ4506). 	

Application Procedure and Equipment	
1a)	For fluidised bed, ensure uniform fluidisation of powder. Fluidised powder should resemble “simmering liquid”. Aged or compacted powder may require pre-conditioning for several minutes to fluidise evenly.
1b)	For box feeders, ensure probe is fully inserted in powder and operated as per manufacturer’s recommendations.
2.	Apply by electrostatic spray.
3.	Cure as per recommendations outlined above.
4.	Test for cure of the coating by contact with a drop of Corsol PGMA (available from Dulux Powder Coatings) for 30 seconds. Surface should be wiped dry and immediately checked for softening. Only slight surface softening should occur.

Care and Maintenance	
As a general rule, cleaning of externally located powder coating surfaces must take place every six months. Where salts/pollutants are more prevalent such as seaside and industrial areas, a cleaning program should be carried out more frequently.	
THREE STEPS TO CLEANING POWDER COATED SURFACES	
<ol style="list-style-type: none"> Remove loose deposits with a wet sponge (avoid scratching the surface by dry dusting). Using a soft clean cloth and a mild detergent in warm water, clean the powder coating to remove dust, salt or other deposits. Always rinse after cleaning with fresh water to remove any remaining detergent. 	
WARNING: In some cases, strong solvents recommended for thinning various types of paints and also for cleaning up mastics/sealants are harmful to the extended life of the powder coated surface. These solvents should not be used for cleaning purposes. If paint splashes or sealants/mastics need to be removed then the following solvents can be used safely: Methylated Spirits, Ethyl Alcohol, Isopropanol.	

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Health and Safety

The MSDS is an integral part of using this product as it contains information on the potential health effect of exposure, personal protective equipment needed and other relevant SH&E information.

For detailed information, refer to product label and the current Chemical Data Sheet (Product Specific) available through Sales and Customer Service Offices.

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Precautions and Limitations

- As a result of possible wide application variations and stoving conditions, some products and colours may show variation between Dulux Powder Coatings prepared samples and production applied material. Therefore, it is the applicator and/or their customer's responsibility to ensure the product conforms to their requirements.
- For optimum performance ensure recommended dry film thickness is obtained.
- Not recommended for use in highly corrosive environments such as severe marine or industrial locations.

Transport and Storage

Sizes:	20 kg	Flashpoint:	N/A
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Weight:	20 kg	UN:	N/A
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Dangerous Goods Class:	N/A	Package Group:	N/A
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Shipment Name:	Not dangerous goods. No special transport requirements.
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