



# CL 9320 HEAVY DUTY IRON COATING

**CL 9320 Heavy Duty Iron Coating** is designed to provide anti corrosive protection and it should be applied to abrasive blast cleaned surface that has been suitably primed. Before apply, remove all wax, oil and grease by solvent cleaning in accordance with the guideline given by SSPC-SP1. Steel structures coated with this product without primer or metal spray treatment should not be stored outside for prolonged periods prior to putting into service. The surface to be coated must clean and dry and free from all visible traces of surface contaminants.

## Technical Information

### Recommended Use

**CL 9320 Heavy Duty Iron Coating** designed to be a heat resistant finish coating for primed steel structures subjected to temperatures up to 200 °C of industrial environments: Petrochemical Plants, Power Stations and offshore structures etc. Suitable for both new construction and maintenance coating. To be overcoated with high resisting aluminum finish.

### Performance

- Excellent heat resistant property
- Good resistance to moisture
- Good resistance to abrasion and weather

### Physical Properties

Volume Solids	49%
Theoretical Coverage	19.6 m <sup>2</sup> /litre @ 25 microns DFT
Flash point	38°C (mixed)
Type	One component
Packing Ratio	None
Colour Availability	Aluminium and selected colour range.
Recommended Thickness	25 microns DFT
Recommended Thinner	Thinner No. 1

### Average Drying Time

Ambient Temperature	Touch Dry	Hard Dry	Overcoating Interval		PotLife
			Minimum	Maximum	

15°C	30 mins.	2 hours*	32 hours	Indefinite	32 hours
25°C	20 mins.	1 hours*	16 hours	Indefinite	24 hours
35°C	10 mins.	0.5 hours*	8 hours	Indefinite	16 hours

\*This product will cure only when the temperature is raised to above 200°C for a minimum of 5 hours, which is normally brought into service.

### Application Data

Application Methods	Brush/Roller, Conventional Spray and Airless Spray.
Mixing ratio (by volume)	None
Thinner	Standard Thinner
Thinner Consumption	Brush/Roller-0-5% Conventional Spray-5-10% Airless Spray0-5%
Airless Spray	Nozzle Size : 0.33-0.38mm (13-15thou) Fan Angle : 65° Operating Pressure : 110-150 kg/cm <sup>2</sup> (1600-2100 psi) Nozzle Size : 1.27mm (50 thou) Atomising Pressure : 3.5 kg/cm <sup>2</sup> (50 psi)
Conventional Spray	Fluid Pressure : 0.7-1.0 kg/cm <sup>2</sup> (10-15 psi)
Brush	This product is suitable for brush application.
Roller	This product is suitable for roller application.

### Application

	Airless Spray	Conventional Spray	Brush	Roller
Dry	25	25	25	25
Wet	51	51	51	51

### Health and Safety

Consult Chemical Safety Data Sheet for information on safe handling and application of this product.



Keep seal tight



Secure upright



Wear proper  
protection



Practice proper  
disposal

### **Application Conditions and Overcoating**

This product should preferably be applied at temperature in excess of 10°C. In conditions of high relative humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temperature should be at least 3°C above the dew point. At application temperature below 10°C, drying and curing time will be significantly impaired. **Application at temperature below 5°C is not recommended.**

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