Technical Data Sheet n° SIL 08 120 3 – May 2008
Cancels and replaces SIL 99 343 3

RHODORSIL® RESIN 6405

Industrial Coatings

Description

RHODORSIL RESIN 6405 is a 50 % solids methylphenylsilicone resin especially developed to resist continuous service temperatures in the range 400-500°C.

This resin is thus ideal for the formulation of high temperature paints for industrial applications. Its prime advantage is to develop gloss which, often, is a desired property for aesthetic effects.

Its use has since been extended to the manufacture of medium-temperature decorative paints (200 to 350°C).

This product is also available as a solution in xylene (RHODORSIL RESIN 6405 X).

Characteristics

Chemical nature	Methylphenylsilicone resin
Appearance	Clear liquid
Colour	Colourless to slightly yellow
Solids, % approx	52
Solvent	Toluene
Flash point, °C approx (closed cup)	4
Specific gravity at 25°C, approx.	1.01
Viscosity at 25°C, mm^2/s,	50
Diluents	Aromatic and chlorinated hydrocarbons, esters, ketones, glycol ethers and their esters.

Processing

For good adhesion of the paint on the substrate, the surface to be coated must be first sandblasted. The painted piece can be handled after drying 24 hours at room temperature.

For curing the two cases mentioned above should be considered:

a) Equipment used in the range 400 - 500°C:

Curing can be carried out at time of use (in this case, the coating should be protected during storage) or, if possible, the piece can be immediately heat-cured after application of the paint (1 hour at 250 - 300°C).

b) Equipment used between 200 and 350°C:

Baking for 2 hours at 300°C is necessary for curing.

In the case of thick coatings, it is advisable to bring the temperature to 300°C in stages in order to avoid blistering.

In decorative paints, the thermoplasticity of the film can be reduced by adding a catalyst such as iron octoate (0, 2 %, calculated on solids, of iron octoate containing 6 % iron).

RHODORSIL® RESIN 6405

Packaging	**RHODORSIL RESIN 6405** is normally supplied in 200 kg drums.
Storage and shelf life	When stored in its original packaging at a temperature of between -20°C and +30°C, **RHODORSIL RESIN 6405** may be stored for up to 18 months from its date of manufacture (expiry date). Comply with the storage instructions and expiry date marked on the packaging. Past this date Bluestar Silicones no longer guarantees that the product meets the sales specifications. Paints should not be packaged in containers which incorporate lead solder, as gelling might occur.
Safety	Consult the Safety Data Sheet of **RHODORSIL RESIN 6405**.

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