



HIGH-SOLIDS SILICONE 412

DESCRIPTION

This guide covers handling and airless spray application of High-Solids Silicone 412 single component elastomeric silicone coatings. High-Solids Silicone 412 polymerizes through chemical reaction with air borne moisture yielding tough, waterproof, weather-resistant elastomeric films. Airless spray is an effective method of application particularly on large areas and irregular or vertical surfaces. Air-atomized application is not recommended.

Personnel using this product should familiarize themselves with procedures for personal safety, workplace precautions, and equipment operation. Refer to Product Data Sheet, Safety Data Sheet and General Instructions for product information. Refer to equipment manufacturer's instructions for spray equipment operation, maintenance and safety

SAFETY EQUIPMENT & VENTILATION

Spray application creates finely atomized particles and vapors which dictate specific procedures to minimize health and safety risks.

PROTECTIVE EQUIPMENT

- Atmospheric levels should be maintained below the exposure guidelines as stated on the MSDS. When respiratory protection is required use an approved air-purifying or positive pressure supplied air respirator.
- Fabric coveralls
- Impervious gloves

INDOOR SPRAYING PRECAUTIONS

1. Isolate the area to be sprayed from the rest of structure.
2. High-Solids Silicone 412 may contain flammable solvents, which evaporate into the air during application and cure cycle.
3. Spray only in well ventilated areas. Air from spray area must be exhausted outdoors in a manner that prevents return through windows, doors or intake vents.
4. Keep spectators and other personnel away from spray area.
5. Be sure to take proper precautions to not spray over unprotected energized lighting or electrical outlets. Doing so could be a fire hazard. Electrical wiring and conduit can be sprayed on as long as open energized circuits are protected.

OUTDOOR SPRAYING PRECAUTIONS

1. Rope off the area within 150 feet of spray area.
2. Seal off ventilation intakes within the affected area.
3. Use windbreaks, where necessary, to confine spray mist and avoid damage to nearby surfaces due to overspray or drift.
4. Keep spectators and other personnel away from spray area.
5. Be sure to take proper precautions to not spray over unprotected energized lighting or electrical outlets. Doing so could be a fire hazard. Electrical wiring and conduit can be sprayed on as long as open energized circuits are protected.



HIGH-SOLIDS SILICONE 412

STORAGE AND HANDLING

Storage:

1. Keep containers closed. Store in a dry, cool place away from heat, sparks, open flame and moisture.
2. For cold weather application, keep material stored above 65°F.
3. Open containers should be blanketed with dry nitrogen or place a small amount of thinner (mineral spirits) on top before resealing to prevent product from skinning.

Mixing:

1. Settling or separation may occur from storage.
2. Mix material before using to assure uniform consistency. Use folding blade-type mixer for closed head drums.
3. Ground container and equipment to prevent accumulation of static charge.
4. Place a small amount of thinner (mineral spirits) on top of mixed material to prevent formation of "skin."

Thinning:

1. Thinning High-Solids Silicone 412 is not required when proper application conditions exist and adequate equipment is used.
2. Pure Mineral Spirits is recommended to clean equipment. Note that some thinners may contain alcohol or other contaminants, which will adversely affect coating characteristics, resulting in decreased physical properties and weather resistance or potential damage to spray equipment.

SPRAY EQUIPMENT

A. Airless spray equipment generates very high fluid pressure. Spray equipment must be properly maintained and operated. Any misuse of spray equipment or accessories (such as over-pressurizing, modified parts, or worn or damaged parts) can result in serious bodily injury, fire, explosion, or property damage. Read and follow the equipment manufacturer's instructions and recommendations. Airless spray pump must have minimum 5,950 psi output pressure rating and adequate delivery volume to support the spray tip orifice gallons per minute (gpm) rating. High-pressure airless sprayers with a higher maximum pressure capability will allow spray application in cold weather or using spray hose lengths greater than 250 feet. Airless spray rigs that produce less than 5,600 psi can be used in the right conditions. These may include high outside temperatures, shorter hose lengths or additional thinning of the silicone coatings.

Listed below are the individual components necessary for ordering a complete silicone airless spray rig set up from Graco. It includes the Graco Xtreme airless motor, 180cc lower, hoses, spray gun and spray tips. This is the airless spray rig configuration that American WeatherStar recommends for use.

Graco 70:1 High-Pressure Air-Powered Airless Sprayer	Quantity
XN6DH4 Xtreme spray pump with cart (lower not included)	1
L180C3 Xtreme Lower, 180cc without filter	1
3/4" X 50' spray hose, 6500psi rating	5