



PRODUCT DATA SHEET

62H241 MUFFLER COATING BLACK

STOVE BRIGHT® HIGH TEMPERATURE

CHARACTERISTICS

Forrest's Muffler Coating is a high heat coating formulated with a unique blend of heat resistant pigments in a silicone polymer resin. This product provides excellent color retention and film integrity in working temperatures up to 1200°F (650°C).

This coating is designed for rapid curing and good working properties over ferrous and properly prepared non-ferrous metal surfaces. It's ideal for mufflers, engines, engine manifolds, and other metal surfaces subject to high temperatures.

PHYSICAL PROPERTIES

Vehicle:	Modified Silicone
Volume Solids:	16-18%
Weight Solids:	24-26%
Weight/Gallon:	8.6 lbs./gallon
Viscosity:	36-40 #4 Ford Cup
Gloss @ 60°:	4-6
Gloss @ 85°:	38-45
Theoretical Coverage at 1 mil:	318 ft²/ gallon
Recommended: Dry Film:	0.8 to 1.2 dry mils
Coverage @ 1.2 mils	265 ft²/ gallons
VOC:	686 grams/liter 5.4 pounds/gal
Dry to touch:	30 minutes
Dry Time Before Heat Cure:	24 hours
Reducer:	Xylene or Toluene @ 10% max
Salt Spray	100 + hours

SURFACE PREPARATION

DO NOT USE PAINT THINNER! Surface must be clean, dry and free of oil, grease, mill scale and other contaminants. Possible cleaning methods include sandblasting (preferred), solvent scrub, wire brushing, or vapor degreasing. The repaired steel should then be solvent cleaned with Xylene, Toluene, or lacquer thinner. Use clean solvent and clean wiping rags. Do not use colored rags containing dye, which may dissolve in the solvent leaving incompatible contaminants on the surface.

APPLICATION

For conventional spray reduce no more than 10% by volume with Toluene (Forrest's 3-T-1). For conventional spray application use 0.013 tip, with 35 to 40 pounds pressure. Electrostatic application may require additional or slower thinner (Xylene, Forrest's 3-T-2) and the addition of Forrest's 03M000 Electrostatic spray additive at 4-6 liquid ounces per gallon. (This product will air dry or may be force cured with temperatures up to 250°F). Dry time will vary with temperature, film thickness, air movement and humidity.

SAFETY

This product contains solvent and/or other chemical ingredients. Adequate health and safety precautions should be observed during storage, handling, use and drying periods. This product may contain metallic aluminum pigments and should be tested carefully for shorting problems with electrostatic equipment.

READ MATERIAL SAFETY DATA SHEETS BEFORE USING THIS PRODUCT

LIMITATIONS

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the product for the intended use. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstance are we liable for incidental and consequential damages.



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Test Data Results:

Color Stability: (Delta E)

500°F:	1.90
700°F:	1.95
800°F:	1.20
900°F:	2.58
1000°F	2.37
1100°F	2.51

*Aluminized panels held together at 950°F, delaminated at 1000°F.

Adhesion: (0B = poor adhesion, 5B = excellent adhesion)

Substrate not cleaned:

70°F:	5B
500°F:	5B
700°F:	5B
800°F:	5B
900°F:	3-4B
1000°F	0B
1100°	0B

Adhesion:

Substrate, wash system:

70°F:	5B
500°F:	5B
700°F:	5B
800°F:	5B
900°F:	4B
1000°F	0B
1100°	N/A (Paint flaked off)

Substrate, Xylene wipe:

70°F:	3B
500°F:	3B
700°F:	4B
800°F:	5B
900°F:	4B
1000°F	0B
1100°	N/A (Paint flaked off)

Conclusion:

Stove Bright 62H241 coating has good adhesion up to 900°F on all the panels tested. The coating lost adhesion at 1000° F due to the failure of the aluminized panels. Aluminized sample panels all delaminated at 1000° F. The panels held together for several hours at 950° F.

62H241 has good color stability up to 1100° with a slight fade at 900°F.

Stove Bright 62H241 coating has shown good adhesion on the panels cleaned by a proper three or five stage wash system.

These tests were performed and evaluated by Jeff Turner, R&D Chemist, Forrest Paint Co.