SilFORT* AS4000

Description
SilFORT AS4000 Hard Coat

AS4000 premium-performance hard coat is a clear, non-yellowing silicone coating which provides optimal protection against deterioration from weather, including ultraviolet rays, heat, cold, rain, snow and ice. It also resists damage from sand and dirt. AS4000 may be used with any of the following primers: LHP100PM, SHP401.

SilFORT SHP401 Primer

SHP401 primer is used as an adhesion promoter for AS4000 hard coat on polycarbonate parts. It can be applied by flow, dip or spray coating. The primer is designed to air dry and should be tack free in about 10 minutes.

The AS4000/SHP401 coating system passes the requirements of the DOT FMVSS#108 and is included in the AMECA List of Acceptable Plastics for Optical Lenses and Reflectors Used on Motor Vehicles. It also complies with the ECE Automotive Regulations for European forward lighting applications.

Key Features and Benefits
AS4000 Hard Coat

• Ultraviolet resistance
• Thermal resistance  
• Abrasion and mar-resistance  
• Good clarity  
• Solvent/chemical resistance  

**SHP401 Primer**

• No thermal cure required  
• Improves coating adhesion  
• Improves water resistance  
• Improves ultraviolet resistance  

**Typical Physical Properties**

<table>
<thead>
<tr>
<th>Property</th>
<th>AS4000 Hard Coat Values</th>
<th>SHP401 Primer Values</th>
</tr>
</thead>
<tbody>
<tr>
<td>Solids Content, %</td>
<td>20 ± 1</td>
<td>2.1 ± 0.2</td>
</tr>
<tr>
<td>Solvent</td>
<td>Methanol, n-butanol, isopropanol</td>
<td>1-Methoxy-2-propanol, diacetone alcohol</td>
</tr>
<tr>
<td>Flash Point, Penske-Martens Closed Cup</td>
<td>19.4°C (67°F)</td>
<td>36.1°C (97°F)</td>
</tr>
<tr>
<td>Density, lbs/gal (g/cc)</td>
<td>7.6 ± 0.1 (0.91)</td>
<td>7.7 ± 0.1 (0.925)</td>
</tr>
<tr>
<td>pH</td>
<td>7.0 ± 0.5</td>
<td>-</td>
</tr>
<tr>
<td>Warranty Period in original sealed containers</td>
<td>3 months at ≤10°C (50°F)</td>
<td>6 months at ambient temperature</td>
</tr>
<tr>
<td>Viscosity, cstk @ 25°C</td>
<td>4-7</td>
<td>4-7</td>
</tr>
<tr>
<td>VOC, g/l</td>
<td>728</td>
<td>907</td>
</tr>
</tbody>
</table>

SHP401 Primer/AS4000 Hard Coat on transparent Polycarbonate (0.5 micron primer/5.0 microns top coat)
<table>
<thead>
<tr>
<th>Test Type</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Taber Abrasion</td>
<td>( \leq 10 \text{ d% Haze} )</td>
</tr>
<tr>
<td>Water Immersion</td>
<td>( &gt; 250 \text{ Hrs.} )</td>
</tr>
<tr>
<td>UV-B</td>
<td>( &gt; 3,000 \text{ Hrs.} )</td>
</tr>
<tr>
<td>#0000 Steel Wool</td>
<td>No visual scratches</td>
</tr>
<tr>
<td>Impact Resistance</td>
<td>No fracture or chipping</td>
</tr>
<tr>
<td>Heat/Humidity/Cold Cycle Test</td>
<td>Passed 15 cycle (90 days)</td>
</tr>
</tbody>
</table>

1 Taber Abrader with 500g load, CS10F wheels at 500 cycles. Haze measured per ASTM D1003. Higher haze indicates greater abrasion. Humidity during coating and Taber wheel variability will affect final values.
2 Temperature = 65°C.
3 Exposure data on UV instrument manufactured by Q Panel Corp. Cycle is 8 hours, FS 40 lamps on at 70°C and 4 hours off with condensing humidity at 50°C.
4 FMVSS 108
5 GM MG5060

**Chemical/Solvent Resistance**

<table>
<thead>
<tr>
<th>Chemical/Solvent</th>
<th>Resistance</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ethylene Glycol Antifreeze</td>
<td>Windshield Washer Fluid</td>
</tr>
<tr>
<td>Heavy Duty Brake Fluid (Glycol)</td>
<td>Tar Remover</td>
</tr>
<tr>
<td>Gasoline (Leaded) or Petrol</td>
<td>Power Steering Fluid</td>
</tr>
<tr>
<td>Wax Remover</td>
<td>Sulfuric Acid (0.1N)</td>
</tr>
<tr>
<td>Heavy Duty Detergent</td>
<td>Sodium Hydroxide (0.1N)</td>
</tr>
<tr>
<td>10W40 Motor Oil</td>
<td></td>
</tr>
</tbody>
</table>

**WEATHERABILITY**
(On Polycarbonate)
UV-B WEATHERABILITY

*SiFORT is a trademark of Momentive Performance Materials Inc.
**Patent Status**
Standard copy to come

**Product Safety, Handling and Storage**

**CAUTION**
Compatibility of Momentive Performance Materials hard coat and polycarbonate resins, is dependent on a number of factors including operational stresses, chemical exposure, temperature levels, impact and exposure to ultraviolet light.

While it is up to the end user to determine what application specific testing is appropriate, it is suggested that all polycarbonate resin applications be tested for at least thirty (30) days for compatibility and crazing with this hard coat use. There is no dependable substitute for careful testing of prototypes of production parts in typical operating environments.

**AS4000 Hard Coat**
Refrigeration is required.

The warranty period is 3 months from date of shipment from Momentive Performance Materials if stored in the original unopened container at <-15°C / <5°F or lower.

**SHP401 Primer**
Store and ship at ambient temperature approximately 2 - 43°C (35 - 110°F)

When stored in original sealed containers, SHP401 primer will have a warranty period

*SiFORT is a trademark of Momentive Performance Materials Inc.*
of 6 months. Exposure to low temperatures may cause some solid precipitation. If this occurs, the precipitate may be re-dissolved by submerging the closed container in a water bath. Mix until homogeneous.

Standard copy to come

**Processing Recommendations**

**General Requirements**

Coating area should be clean, dust-free (Class 10,000 or better), well-ventilated and with the relative humidity controlled to 40 ± 10%. If necessary, parts should be washed or wiped clean with isopropyl alcohol, a mild detergent solution and clean water rinse, followed by a filtered-air blowoff and a final ionized-air blow-off. Cleanliness is critical for the production of good parts. Both primer and hard coating solutions should be filtered continuously or just prior to use to approximately 0.5 to 1.0 micron, using a 3 to 5 micron prefilter. Electric or indirect gas-fired ovens with good convection and air exchange are recommended.

**AS4000 Hard Coat**

The hard coat can be applied to primed parts by dip, spray, or flow coating. For spray applications and large-part flow coating, the coating can be reduced to 15% solids with an appropriate solvent (e.g. n-butanol or IPA). Topcoat should be applied to result in a cured film thickness of 0.18 to 0.26 mil (4.5 to 6.5 microns) or thicker, depending on application. The coating should be allowed to dry at room temperature until tack free, 10 to 20 minutes. After the part reaches a temperature of 130°C (266°F), AS4000 cures to an abrasion resistant hard coat in 30 to 60 minutes.

**SHP401 Primer**

The primer can be applied by dip, spray or flow coating to polycarbonate parts that have an initial stress level under 1000 psi. If a higher stress level is found to exist, the tool and molding conditions should be adjusted to reduce residual stress on parts. Alternatively, parts can be annealed to reduce stress, (for example, 30 minutes at 130°C (266°F) for each 100 mils of part thickness.) If necessary, primer solids content
may be reduced by adding 1-Methoxy-2-Propanol/diacetone alcohol (85/15) or pure 1-Methoxy-2-Propanol. The primer should be applied to obtain a dry film thickness of approximately 0.5 micron. After application, the primer should air dry until tack free (approximately 10 minutes). Recirculate the primer through a 1 or better micron filter.

Limitations
Standard copy to come

Contact Information
For product prices, availability, or order placement, contact our customer service at Momentive.com/CustomerService/

For literature and technical assistance, visit our website at: www.momentive.com

DISCLAIMER:

THE MATERIALS, PRODUCTS AND SERVICES OF MOMENTIVE PERFORMANCE MATERIALS INC. AND ITS SUBSIDIARIES AND AFFILIATES (COLLECTIVELY “SUPPLIER”), ARE SOLD SUBJECT TO SUPPLIER’S STANDARD CONDITIONS OF SALE, WHICH ARE INCLUDED IN THE APPLICABLE DISTRIBUTOR OR OTHER SALES AGREEMENT, PRINTED ON THE BACK OF ORDER ACKNOWLEDGMENTS AND INVOICES, AND AVAILABLE UPON REQUEST. ALTHOUGH ANY INFORMATION, RECOMMENDATIONS, OR ADVICE CONTAINED HEREIN IS GIVEN IN GOOD FAITH, SUPPLIER MAKES NO WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, (i) THAT THE RESULTS DESCRIBED HEREIN WILL BE OBTAINED UNDER END-USE CONDITIONS, OR (ii) AS TO THE EFFECTIVENESS OR SAFETY OF ANY DESIGN INCORPORATING ITS PRODUCTS, MATERIALS, SERVICES, RECOMMENDATIONS OR ADVICE. EXCEPT AS PROVIDED IN SUPPLIER’S STANDARD CONDITIONS OF SALE, SUPPLIER AND ITS REPRESENTATIVES SHALL IN NO EVENT BE RESPONSIBLE FOR ANY LOSS RESULTING FROM ANY USE OF ITS MATERIALS, PRODUCTS OR SERVICES DESCRIBED HEREIN. Each user bears full responsibility for making its own determination as to the suitability of Supplier’s materials, services, recommendations, or advice for its own particular use. Each user must identify and
perform all tests and analyses necessary to assure that its finished parts incorporating Supplier’s products, materials, or services will be safe and suitable for use under end-use conditions. Nothing in this or any other document, nor any oral recommendation or advice, shall be deemed to alter, vary, supersede, or waive any provision of Supplier’s standard Conditions of Sale or this Disclaimer, unless any such modification is specifically agreed to in a writing signed by Supplier. No statement contained herein concerning a possible or suggested use of any material, product, service or design is intended, or should be construed, to grant any license under any patent or other intellectual property right of Supplier covering such use or design, or as a recommendation for the use of such material, product, service or design in the infringement of any patent or other intellectual property right.

*SilFORT is a trademark of Momentive Performance Materials Inc.

Momentive and the Momentive logo are trademarks of Momentive Performance Materials Inc.