SilFORT* AS4000
SilFORT AS4000 Hard Coat
Technical Data Sheet
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

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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</th>
<th>Result</th>
</tr>
</thead>
<tbody>
<tr>
<td>Taber Abrasion(^1)</td>
<td>≤ 10 d% Haze</td>
</tr>
<tr>
<td>Water Immersion(^2)</td>
<td>≥ 250 Hrs.</td>
</tr>
<tr>
<td>UV-B(^3)</td>
<td>≥ 3,000 Hrs.</td>
</tr>
<tr>
<td>#0000 Steel Wool(^4)</td>
<td>No visual scratches</td>
</tr>
<tr>
<td>Impact Resistance(^4)</td>
<td>No fracture or chipping</td>
</tr>
<tr>
<td>Heat/Humidity/Cold Cycle Test(^5)</td>
<td>Passed 15 cycle (90 days)</td>
</tr>
</tbody>
</table>

- 1Taber 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.
- 2Temperature = 65°C.
- 3Exposure 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.
- 4FMVSS 108
• 5GM MG5060

Chemical/Solvent Resistance

<table>
<thead>
<tr>
<th>Ethylene Glycol Antifreeze</th>
<th>Windshield Washer Fluid</th>
</tr>
</thead>
<tbody>
<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)
FLORIDA/ARIZONA

FRESNEL

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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
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.

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**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
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