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PRODUCT TECHNICAL DATA SHEET

Product: 36-603 Vel-Von High Temp Aluminum (TTP-28-G)

Generic Type: Silicone Copolymer

Color: Aluminum

Sheen or Gloss: High Luster

Percent Solids by Weight: 41.6% ± .5
Percent Solids by Volume: 27.0% ± .5

Percent Vehicle Solids by Weight: 18.6% ± .25
Percent Pigment by Weight: 23.0% ± .25

Viscosity: 12-16 sec #4 Ford Cup @ 77-F

Weight per Gallon: 8.6 lbs/gal ± .10

Flash Point, TCC: 80 Deg F

Volatile Organic Compounds (VOC): 5.03 LBS/GAL (603 G/L)

Drying Time, Normal @ 77-F, 50% RH:
- Touch: 30 minutes
- Handle: 1 hour
- Recoat: 1 hour
- Full Cure: full cure is obtained by gradually raising to operating temperature

Theoretical Coverage: 434 sq ft/gal
Recommended Coverage: .8 mils DFT min, 2.0 mils DFT max (calculated) Mils Dry
*When computing working coverage, allow for application losses, surface irregularities, etc.

Heat Resistance: 1,200-F

Type of Cure: Oxidation/Cross-linking

Reduction, Clean-up Solvent: Toluene, Xylene, or Aromatic 100

The information presented here is based on carefully conducted laboratory tests and is believed to be accurate. Final determination of the suitability of the material for the use contemplated, the manner of use, and whether the sug- gested use infringes any patent is the sole responsibility of the buyer.

10/20/94

APPLICATION INSTRUCTIONS
36-603 VEL-VON ALUMINUM

High temperature coatings require much better surface preparation than conventional coatings used at ambient temperatures, in order to provide extended protection under temperature extremes. Inadequate surface preparation and/or coatings application will result in premature coating failure.

TYPICAL USE:
Boiler jackets, smokestacks, mufflers, towers, reactors, piping, components of process equipment and engine components.

PRODUCT ADVANTAGES:
Protects metal surfaces under continuous heat exposure up to 1200 °F. Resists weather extremes, thermal shock and discoloration. Fast drying, dust free in 30 minutes.

SERVICE CONDITIONS:
For continuous service up to 1200°F. Do not use over conventional finishes, failure will occur.

SURFACE PREPARATION: Near White Blast (SSPC-SP10) or NACE#2.
In this method all oil, grease, dirt, mill scale, rust, corrosion products, oxides, paint or other foreign matter have been completely removed from the surface; except for very light shadows, very slight streaks, or slight discoloration caused by rust stain, mill scale oxides or slight, tight residues of paint or coating. At least 95% of each square inch of surface area shall be free of all visible residues, and the remainder shall be limited to the light discoloration mentioned above. From a practical standpoint, this is probably the best quality surface preparation that can be expected today.

All surfaces must be clean, dry, and free of all contaminants. Oil and grease should be removed by cleaning solvent cleaning or detergent washing. Where impractical, flame or power tool cleaning followed by solvent cleaning to remove dust is acceptable.

APPLICATION:
May be applied by conventional or airless spray, brush or roller. Spray is the preferred method. Use as received after thorough mixing. Thinning may be required for proper atomization with spray equipment. Use up to 1 pint per gallon of Toluene, Xylene, or Aromatic 100 for spraying. Do not add unspecified solvents or mix with other paints, do not tint.

A mist coat followed by a wet coat usually gives best results. Do not attempt to build film by applying heavy coats. Excessive film thickness will result in mudcracking and checking due to high temperature and thermal shock. Once the cracking and checking start, rust and corrosion will develop rapidly.

Surfaces to be painted must be at ambient temperature (out of service) during application (50°F to 90°F).

DRYING:
Drying Time, per coat @ 77°F, 50% RH:

Touch: 30 minutes
Handle: 1 hour
Recoat: 1 hour

Full Cure: full cure is obtained by gradually raising to operating temperature or by force drying or baking. Rapid heating can result in solvent entrapment, blistering, and possible film failure.

Allow longer drying time under cool, or more moist conditions.

03/27/96