

PROCEDURES FOR APPLICATION OF DAMPNEY THURMALOX 225HD TO “HOT SURFACES”

SCOPE: DAMPNEY THURMALOX 225HD CAN BE APPLIED TO HOT SURFACES THAT ARE OPERATING IN THE TEMPERATURE RANGE BETWEEN 200°F AND 450°F.

NOTE: THURMALOX 225HD IS SUITABLE FOR USE ON PIPING AND EQUIPMENT WITH SURFACES OPERATING TO 1000°F (1200°F INTERMITTENT). HOWEVER, MAXIMUM TEMPERATURE DURING HOT APPLICATION MUST NOT EXCEED 450°F.

NOTE: USE DAMPNEY TECHNICAL DATA SHEET PROCEDURES FOR APPLICATION TO SURFACES BELOW 200°F.

1. The following criteria should be followed for “Hot Surface” applications onto **Carbon Steel**:

1.1 Application to hot surfaces (*) between 200°F and 300°F

- For applications between 200°F and 300°F, product must be catalyzed.
- Apply coating in 2 or 3 coats, with a total system Dry Film Thickness (DFT) of 8 - 9 mils. Do not exceed 3 – 4 mils DFT per coat or 10 mils total system DFT.
- Allow a minimum of 6 hours cure time between application of each coat.

1.2 Application to hot surfaces (*) between 301°F and 450°F

- Apply coating in 3 or 4 coats, with a total system DFT of 9 - 12 mils. Do not exceed 3 – 4 mils DFT per coat or 14 mils total system DFT.
- Allow a minimum of 1 hour cure time between application of each coat.

NOTE: Under hot application procedures, thinning is recommended using Dampney 162 Thinner at a ratio of one pint per gallon.

2. The following criteria should be followed for “Hot Surface” applications onto **Stainless Steel**:

2.1 Application to hot surfaces (*) between 200°F and 300°F

- For applications between 200°F and 300°F, product must be catalyzed.
- Apply coating in 2 coats, with a total system Dry Film Thickness (DFT) of 6 mils. Do not exceed 3 – 4 mils DFT per coat or 7 mils total system DFT.
- Allow a minimum of 6 hours cure time between application of each coat.

2.2 Application to hot surfaces (*) between 301°F and 450°F

- Apply coating in 2 coats, with a total system DFT of 6 mils. Do not exceed 3 – 4 mils DFT per coat or 7 mils total system DFT.
- Allow a minimum of 1 hour cure time between application of each coat.

3. Thurmalox 225HD is designed for spray application. Dampney does not recommend the use of brushes or rollers in the application of this coating. If it is necessary to use brush or roller applications, the following suggestions should be beneficial:

- Use China bristle brushes with a wooden handle. Roller covers should be short nap, lambs wool covers with phenolic cores. As noted below, thinning with Dampney 180 Thinner will be necessary for brush and roller applications.

NOTE: Under hot application procedures, thinning is recommended using Dampney 162 Thinner at a ratio of one pint per gallon.

* “Hot Surface” temperature measurements must be verified using a “surface contact thermometer or a surface temperature probe” applied directly to the surface being painted. Measurements made with non-contact infrared hand held gages are dependent on the surface emissivity and may not be indicating actual surface temperatures. Calibration of non-contact infrared hand held gages should be made using temperature measurements made with the surface contact temperature probes.

If you have any questions or require additional information, please call me at 281-814-4406 or Tom Trane at 800-537-7023.

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