

SELECTION & SPECIFICATION DATA

Generic Type	Inorganic silicate
Description	Thermaline 4000 Aluminum is a high heat polymer coating used for the protection of equipment operating at elevated temperatures. It is typically used over Carbozinc® inorganic zinc primers for outstanding corrosion protection and heat resistance. The combination of an inorganic zinc primer with this grey-aluminum finish provides exceptional performance in durability. Unlike most high temperature silicone-based technologies with soft films, Thermaline 4000 Aluminum does not require a heat cure for film forming properties. It cures hard rapidly under ambient conditions (humidity greater than 30%).
Features	<ul style="list-style-type: none"> • Inorganic; stable; inert polymer • Outstanding durability • Excellent corrosion protection (used over Carbozinc inorganic primers) • High temperature resistance (1000°F/538°C) • VOC compliant • Cures at ambient conditions (hard in 4 hours) • Cures down to 40°F • Does not require heat cure for high-temp service • Outstanding resistance to handling damage • Single-package
Color	Grey-Aluminum (C901); See Thermaline 4000 for other color options.
Finish	Flat
Primer	Best when used over solvent-based inorganic zinc primers such as Carbozinc 11 Series. Carbozinc 608 HB, Carbozinc 808, Carbozinc 858 Series, and Carbozinc 859 Series are suitable organic zinc primers for lower maximum dry temperature service and/or for repairing mechanical damage to the coating system that may result in bare metal being exposed. Refer to the specific organic zinc primer's Product Data Sheet for the maximum dry temperature resistance.
Dry Film Thickness	3 - 5 mils (76 - 127 microns) . Not to exceed 7 mils (175 microns).
Solids Content	By Volume 57% +/- 2%
Theoretical Coverage Rate	914 ft ² /gal at 1.0 mils (22.4 m ² /l at 25 microns) 305 ft ² /gal at 3.0 mils (7.5 m ² /l at 75 microns) 183 ft ² /gal at 5.0 mils (4.5 m ² /l at 125 microns) Allow for loss in mixing and application.
VOC Value(s)	Per EPA Method 24: 3.0 lbs/gal (360 g/l) mixed 12 oz/gal of Thinner 254: 3.43 lbs/gal (410 g/l) 6 oz/gal of Thinner 33: 3.21 lbs/gal (385 g/l) This product contains US EPA VOC-exempt solvent(s).
Dry Temp. Resistance	Continuous: 1000°F (538°C) *Dry temperature resistance listed above is only applicable when applied over suitable solvent-based inorganic zinc primers.
Limitations	Do not use over water-based inorganic zinc-rich primers.

Thermaline[®] 4000 Aluminum

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Refer to specific primer's Product Data Sheet for detailed requirements of the specified primer.
Steel	Minimum: SSPC-SP6 for zinc primer application Surface Profile: 1.0-3.0 mils (25-75 micron) Apply over properly applied and clean inorganic zinc primers. When used over Carbozinc 11 Series primers allow a minimum 2-hour cure on primer prior to topcoating.
Galvanized Steel	Not recommended.
Stainless Steel	Not recommended.

MIXING & THINNING

Mixing	Power mix to a uniform consistency.
Thinning	May be thinned up to 5% by volume with Carboline Thinner #33 for most applications or 5-10% with Thinner #254 for hot (85°F/29°C) or windy conditions.
Pot Life	Indefinite. Avoid moisture contamination.

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General)	The following spray equipment has been found suitable and is available from manufacturers. Material should be agitated to keep aluminum pigment in suspension.
Conventional Spray	Conventional pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, and 0.043" to 0.070" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.) Volume Output: 2.5 gpm min. - 11.5 l/min min. Material Hose: 3/8" I.D. min. - 9.0 mm min. Tip Size: 0.017-0.021" - 0.43-0.53mm Output Pressure: 2100-2500 psi - 135-170kg/cm ²
Brush	For touch up use only. Use medium bristle brush and avoid re-brushing. Two coats may be required to obtain desired thickness and appearance. For best results tie-in within 5 min.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	40°F (4°C)	40°F (4°C)	40°F (4°C)	30%
Maximum	90°F (32°C)	110°F (43°C)	110°F (43°C)	95%

Industry standards are for substrate temperatures during application to be 5°F (3°C) above the dew point. This product does not require heat-curing; but it does require moisture to complete its final cure. Use water mist if humidity is below minimums.



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CURING SCHEDULE

Surface Temp.	Cure for Service	Dry to Handle	Touch Dry
75°F (24°C)	24 Hours	4 Hours	15 Minutes

These times are based on recommended coverage rates. Curing under low humidity conditions will extend times. Final cure will depend on humidity levels; but generally overnight cure (18-24 hours) is sufficient prior to placing in high-heat service.

CLEANUP & SAFETY

Cleanup	Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
Ventilation	When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life	6 months at 75°F (24°C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40-90°F (4°C-32°C) 0-90% Relative Humidity This product is sensitive to elevated temperature storage.
Storage	Store Indoors. KEEP DRY
Shipping Weight (Approximate)	1 Gallon - 13 lbs (kg) 5 Gallon - 65 lbs (kg)
Flash Point (Setflash)	Thermaline 4000 Aluminum: 61°F (19°C) Thinner 33: 75°F (24°C) Thinner 2: 23°F (-5°C) Thinner 254: 167°F (75°C)

WARRANTY

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