

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Reinforced inorganic polymer (inert multi-polymeric matrix)
<b>Description</b>	<p>This is an extreme performance coating for hot, cryogenic and cycling exposures. Thermaline Heat Shield contains a unique blend of plate-like reinforcing pigments fortified with an inert polymeric matrix. The resulting film provides an outstanding barrier against corrosives and harsh exposures typically seen in elevated temperature environments. This versatile coating is ideal for all piping, vessels and equipment operating from cryogenic conditions up to 650°C (1200°F). It is particularly well suited to prevent corrosion under insulated equipment/piping for both carbon steel substrates and stainless steels. This fortified coating has superior shop handling properties over standard silicone coatings (see Curing). It is recommended for CS-6 and SS-5 systems of NACE SP0198 Standard Practice for coatings to control corrosion under insulation (CUI).</p>
<b>Features</b>	<ul style="list-style-type: none"> <li>• Unique reinforced but flexible polymer film</li> <li>• Versatile use from cryogenic to 650°C (1200°F) exposures</li> <li>• Dries to handle without heat cure (See curing schedule)</li> <li>• Outstanding barrier properties</li> <li>• Protects steel from thermal wet cyclic conditions</li> <li>• Suitable for both shop and field application</li> <li>• Provides corrosion protection even with ambient temperature cure</li> <li>• Self priming or apply over Carbozinc 11 primers when uninsulated</li> <li>• Protects stainless steels from chlorides and stress corrosion cracking</li> <li>• Very fast recoat times</li> </ul>
<b>Colour</b>	Metallic Grey (0700)
<b>Finish</b>	Eggshell (10-25)
<b>Primer</b>	Self-priming. May be used over Carbozinc 11 primers for uninsulated applications.
<b>Dry Film Thickness</b>	<p>89 - 127 microns (3.5 - 5 mils) per coat</p> <p>Two coats are recommended for optimal performance. For best results keep maximum dry film thickness below 300 microns.</p>
<b>Solids Content</b>	By Volume 51% +/- 2%
<b>Theoretical Coverage Rate</b>	<p>20.1 m<sup>2</sup> at 25 microns (818 ft<sup>2</sup> at 1.0 mils)</p> <p>5.7 m<sup>2</sup> at 88 microns (234 ft<sup>2</sup> at 3.5 mils)</p> <p>4.0 m<sup>2</sup> at 125 microns (164 ft<sup>2</sup> at 5.0 mils)</p> <p>Allow for loss in mixing and application.</p>
<b>VOC Values</b>	<b>As Supplied</b> : 420 g/l
<b>Maximum Service Temperature</b>	This product will handle thermal cycling from cryogenic of -196°C (-321°F) to high heat of 650°C (1200°F).

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	All surfaces must be thoroughly cleaned to remove dirt, grease, mill scale, loose rust and any other contaminants that can reduce adhesion in accordance with SSPC-SP1, (AS 1627.1) solvent cleaning along with the recommended surface preparation as referenced below.
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# Thermaline Heat Shield

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### SUBSTRATES & SURFACE PREPARATION

<b>Ferrous Metal</b>	For optimum performance, abrasive blast to SSPC-SP 10 (AS 1627.4 Sa 2½) and achieve a uniform jagged blast profile of between 35µm (minimum) and up to 75µm. Where blasting is impractical or not permitted use hand power tools to prepare surface to SSPC-SP 11 and achieve a uniform surface profile greater than 25µm. The better the cleaning standard achieved, the better the performance and service life of the system.
<b>Stainless Steel</b>	Abrasive blast using non-metallic media; surface profile should be a dense angular 27-75 microns. Remove all contaminants that would interfere with the performance of stainless steel for the intended service such as, but not limited to, embedded iron or chlorides.

### MIXING & THINNING

<b>Mixing</b>	Power mix base component and add Fortifier HT to base and mix to uniformity.
<b>Thinning</b>	Thinning not normally required for spray application. For applications over hot surfaces (up to 260°C) conventional spray is the preferred method of application. For small areas or touch-up use a brush and thin up to 6% by volume with Thinner #10 for normal temperatures or up to 6% with Thinner 25 for hot surface applications. Use of thinners other than those supplied or approved by Carboline may adversely affect product performance and will void product warranty whether express or implied.
<b>Ratio</b>	<b>Thermaline Heat Shield kit: 1.04 Us gallons (3.93 litres)</b> <ul style="list-style-type: none"><li>• Thermaline Heat Shield (Base): 1 US gallon (3.78 litres)</li><li>• HT Fortifier: 0.04 US gallon (150 mls)</li></ul>
<b>Pot Life</b>	8 hours at 24°. Less at higher temperatures.

### 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.

<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 9.5 mm (3/8") ID minimum material hose, 1.8 mm (0.070") fluid tip with appropriate air cap. Adjust air pressure to provide uniform spray pattern.
<b>Airless Spray</b>	Pump Ratio: 32:1 (min)* Volume Output: 11 litres / minute(min) Material Hose: 12.5 mm(min) Tip Size: 0.017-0.021" Output PSI: 1500-2000  *PTFE packings are recommended and available from the pump manufacturer.
<b>Brush &amp; Roller (General)</b>	Use a natural bristle brush applying in full strokes. Avoid rebrushing. If rolled, use a short nap roller with solvent resistant core. Avoid rerolling. Appearance will vary using brush or roller application methods due to the orientation of the aluminum flake.

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	13°C (55°F)	10°C (50°F)	7°C (45°F)	0%
Maximum	32°C (90°F)	260°C (500°F)	38°C (100°F)	95%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

## CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Recoat	Dry to Handle
10°C (50°F)	1 Hours	6 Hours	6 Hours
16°C (60°F)	1 Hours	3 Hours	5.5 Hours
24°C (75°F)	45 Minutes	1 Hours	5 Hours
32°C (90°F)	30 Minutes	1 Hours	2 Hours

These times are based on the recommended dry film thicknesses, 90-125 microns. Excessive film thickness or inadequate ventilating conditions after application require longer dry times and will cause premature failure in extreme cases. Lower humidity may lengthen dry time.

**Note:** Avoid rapid temperature excursion for the first heat cycle; particularly early in the cure. A gentle heat rise through 260°C will achieve maximum film durability. For recoat time via brush or roller, follow the dry to handle time (thumb twist test).

This product has superior handling properties over standard silicones (harder film), but has some thumbnail softness until it has undergone a heat excursion. In these cases use padded slings and dunnage. Typical dry-to-ship time is 24 hours.

## CLEANUP & SAFETY

**Cleanup** | Use Thinner #2 or Acetone.

**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 vapour 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 suitable approved supplied air respirator.

**Caution** | This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the local electrical code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## PACKAGING, HANDLING & STORAGE

**Shelf Life** | Heat Shield Base: 12 months at 24°C  
HT Fortifier: 24 months at 24°C

**Shipping Weight (Approximate)** | 1.04 Gallon - 14 lbs (6.35 kg)  
5.2 Gallon - 70 lbs (31.75 kg)

**Storage Temperature & Humidity** | 40°-120°F(4°-49°C)  
0-95% Relative Humidity

**Flash Point (Setaflash)** | Part A (base component): 80°F(27°C)  
Fortifier HT: 108°F (42°C)

# Thermaline Heat Shield

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## PACKAGING, HANDLING & STORAGE

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**Storage** | Store indoors

## WARRANTY

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