



## 328 TEMPTEC

### PRODUCT DESCRIPTION

Commercial Performance Coatings 328 Tempotec is a single pack high temperature silicone based coating.

It is designed to withstand continuous temperatures of up to 500°C. May be applied directly onto properly prepared steel and stainless steel. Application over D9 (Inorganic Zinc Primer) will provide superior performance by preventing rusting during a shut down or when the equipment is exposed to moisture at temperatures less than 95°C. Optimum hardness for handling can be obtained by baking at the temperature to 200°C for 2 hours.

328 Tempotec is used for coating metal products exposed to temperatures up to 500°. It may also be used on exhaust manifolds and furnaces, barbecues and wood stoves.

### PRODUCTS

328 Tempotec

32800-BLACK5/4L Tempotec Satin Black  
32800-BLACK5/20L Tempotec Satin Black

Reducers

THINNER 42106  
EXR20 Epoxy Reducer Normal

Cleaners

971-9119 PROTEC® Metal Conditioner  
AA-6822 *Protec* Heavy Duty Wax & Grease Remover

### SUBSTRATES & PREPARATION



#### Structural Steel:

Abrasive blast clean to AS1627.4 Class 2½



#### Mild Steel:

Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

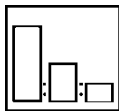
#### Galvanised Steel:

Degrease with AA-6822, abrade and clean with AA-6822 *Protec* Heavy Duty Wax & Grease Remover and wipe with dry clean cloths. Abrade the surface using Startline P240 grit on an orbital sander or by hand rubbing using Startline P320 grit. Thoroughly blow down to remove dust and clean the surface again using AA-6822 *Protec* Heavy Duty Wax & Grease Remover.

#### Stainless Steel:

Degrease with AA-6822, abrade and clean with AA-6822 *Protec* Heavy Duty Wax & Grease Remover and wipe with dry clean cloths. Abrade the surface using Startline P240 grit on an orbital sander or by hand rubbing using Startline P320 grit. Thoroughly blow down to remove dust and clean the surface again using AA-6822 *Protec* Heavy Duty Wax & Grease Remover.

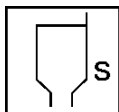
## MIXING RATIO BY VOLUME



**PRODUCT**  
328 Temptec  
Reducer

**PARTS**  
100  
Up to 25%

## SPRAY VISCOSITY



16 - 20 seconds (DIN 4) at 25°C

## SPRAYGUN



**CONVENTIONAL, HVLP  
SETUP**

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

**SPRAY PRESSURE**

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

## APPLICATION & FLASH OFF



Apply 2 coats @ 15-25µm per coat

Allow 3 - 10 minutes flash off between coats at 25°C

## DRYING TIMES



**AIR DRY (25°C)**

- DUST FREE: 15 minutes
- TOUCH DRY: 30 minutes
- DRY TO HANDLE: 2 hours

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

## RECOAT



Recoating should not be attempted after 4 hours drying. To obtain optimum hardness for handling temperature must be raised to 200°C for 2 hours.

## TOTAL DRY FILM BUILD

25 - 50µm \*Less than 25µm may lead to adhesion failure

## TECHNICAL PARAMETERS

<b>VOLUME SOLIDS (RFU)</b>	15%, depending on colour
<b>COVERAGE</b>	4 metres squared per litre (m <sup>2</sup> /L) @ 40µm dry film thickness
<b>RESISTANCE PROPERTIES</b>	
<b>WEATHERING</b>	Good when applied over inorganic zinc primers
<b>ABRASION</b>	Good when cured at elevated temperatures
<b>CHEMICAL</b>	Not normally recommended
<b>HEAT</b>	Up to 500°C dry heat
<b>IMMERSION</b>	Not normally recommended
<b>SHELF LIFE</b>	24 Months
<b>TOPCOATING</b>	Not recommended

## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.  
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.  
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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