



Dampney

Protective Coatings

**Thurmalox® 245C Air Dry
VOC Compliant High Solid
Silicone Zinc Dust Primer
Heat Resistance 500°F - 1200°F**

Description

Thurmalox 245C Primer is a VOC compliant, high temperature, corrosion resistant primer formulated from silicone resins and zinc dust. Thurmalox 245C Primer provides outstanding corrosion protection for metal surfaces operating at temperatures from 500°F (260°C) to 1000°F (538°C), with peaks to 1200°F (648°C). Thurmalox 245C is the primer for Thurmalox 230C and 280C series heat resistant topcoats. The 245C primer/230C and 280C series topcoat systems have excellent intercoat adhesion and are able to withstand severe thermal shock from ambient to 1000°F (538°C).

Recommended Uses

Application where (1) the benefits and features of Thurmalox 245C are needed and where (2) federal, state, and/or local authorities require high temperature coatings to be compliant with reduced VOC (volatile organic compound) emissions regulations.

- Stacks, Breechings, Boiler Casings
- Manifolds, Mufflers and Exhausts
- Hot Piping, Process Vessels, Heat Exchangers
- Refinery Equipment - Heaters, Crackers
- Furnaces, Ovens

Features

- VOC compliant - 3.45 lb. / gal. (413 g./l.)
- Withstands continuous temperature of 1000°F (538°C), with peaks to 1200°F (648°C)
- Air dries
- Prevents rusting of steel during shutdowns
- Easily topcoated with Thurmalox 230C/280C series heat resistant topcoats
- Excellent intercoat adhesion
- Protects against weathering and corrosion
- Prevents underfilm corrosion attack

Not Recommended For

- Immersion service
- Interiors of stacks, breechings and scrubbers
- Stainless steel

Surface Preparation - Carbon Steel

1. To ensure optimum long-term coating system performance surfaces must be clean, dry and free from dirt, oil, grease, salts, welding flux, mill scale, rust, oxides, old paint, corrosion products or other foreign matter.
2. Remove all surface imperfections that will induce premature coating system failure. Chip or scrape off weld splatter. Grind down sharp and rough edges, gouges, and pits.
3. Abrasive blast surface per specification SSPC-SP 10, "Near-White Blast Cleaning", or per NACE Standard No. 2 to a profile depth of 1.5 - 2.0 mils maximum, with a 1.5 mil anchor pattern being ideal. Abrasive used in blasting should be selected carefully from materials of mesh size required to produce the desired anchor pattern.
4. If abrasive blasting is not permitted, prepare surface by power tool cleaning per SSPC-SP 11. Use 3M brand "Heavy Duty Roto Peen", type C flap wheel cleaning system mounted on an air-driven motor. This method will provide a surface equivalent to that provided by commercial blast cleaning per SSPC-SP 6, including the desired surface profile (anchor pattern).
5. Feather out all edges of adjacent painted surfaces after completion of surface preparation operations and prior to application of the first coat of paint.

Mixing

Thurmalox 245C Primer is a two package system consisting of a base component and zinc dust that must be mixed together before use. Sift zinc dust slowly into base with continuous mechanical agitation. Mix thoroughly until free of lumps. Pour mixture through 30-mesh screen or nylon mesh bag. If a partial unit is needed, mix by weight, 10 parts Base component with 3 parts Zinc Dust component.

Application Guidelines

Surface temperature must be at least 5°F (3°C) above dew point.

Carbon Steel

Primer: Thurmalox 245C Primer	1.5-2.0 mils (37-50 microns)
Topcoats: Thurmalox 230C Series	1.5-2.0 mils (37-50 microns)
Total dry film thickness	3.0-4.0 mils (75-100 microns)

Application Equipment

Conventional spray is the recommended method of application. However, Thurmalox 245C Primer may also be applied by airless spray, or brush. Do not apply Thurmalox 245C Primer in heavier films than specified since blistering may occur.

Conventional Spray:

Spray gun	DeVilbiss JGA402 or equal
Fluid tip	EF
Air cap	704
Fluid hose*	3/8" ID
Air hose	5/16" ID
Atomizing pressure	60 psi

Provide material pot with agitator, regulators for fluid and air pressure, and oil and moisture traps in supply line.

*Smaller hose diameter or length over 25 ft. may require increased pressure.

Airless Spray:

Spray gun	Graco 205-591, 208-663
Fluid tips*	163-610, 163-315
Pump	Graco Bulldog 30:1
Fluid hose	3/8" to 1/2" ID
Air press. to pump	100 psi
Pump operating press.	80-90 psi

* Use Reverse-A-Clean® tips for fast, easy clean out.

Brush: Use only wooden-handled brush with short China bristles. Do not use synthetic-bristled brushes. Do not flood surface with coating. Brush out thoroughly, maintaining a continuous wet edge and uniform appearing paint film.

Thinning

Only thin Thurmalox 245C Primer with Dampney 180 Thinner. Do not thin beyond federal, state and/or local VOC (volatile organic compound) emission regulations. Note: Use of other thinners not approved by Dampney may hinder product performance and void product warranty.

Provide material pot with agitator, regulators for fluid and air pressure, and oil and moisture traps in supply line.

Dry Time 70°F (21°C) 50% RH

Thurmalox 245C Primer will air dry tack and thumb print free within 6 - 8 hours. Allow 10 - 12 hours dry time between coats. Allow 48 hours dry time prior to shipping and handling if coating is not heat cured. Surfaces coated with Thurmalox 245C Primer in the air dried state can be handled and shipped prior to a heat cure as long as shipping and handling procedures for thin filmed systems are followed. Avoid mechanical abrasion during shipping and handling. Higher temperatures will reduce tack free, recoat and shipping times. Allow one hour solvent flash off period before heat curing or placing into service. Optimum film properties require a heat cure of 350°F (177°C) for 30 minutes. Equipment protected with the Thurmalox 245C Primer in the air dried state will heat cure when placed into service.

Cleanup

Thoroughly flush spray equipment and hoses immediately after use with Dampney 100 Thinner. Dismantle spray equipment and clean parts, brushes and rollers with Dampney 100 Thinner.

Storage

Store in a cool, dry place with temperature between 50°F and 100°F (10°C and 38°C). Keep container closed when not in use.

Precautionary Information

WARNING: Flammable Liquid and Vapor
 Keep away from heat, sparks and flame. Vapors may cause flash fire. Do not breathe vapors or spray mist. Avoid contact with eyes, skin and clothing. Use with adequate ventilation during mixing and application. Wear an appropriate, properly fitted organic vapor cartridge-type respirator (NIOSH approved) during and after application unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Wash thoroughly after handling. Wear protective gloves, chemical safety goggles and impervious protective clothing. Use skin cream. In confined spaces it is required to use a positive pressure supplied-air respirator (NIOSH approved). Use explosion-proof lights and electrical equipment. Use only nonsparking tools and equipment. Wear conductive and nonsparking footwear. Make certain all electrical equipment is grounded. Observe all safety precautions and follow procedures described in OSHA regulations. See Material Safety Data Sheet (MSDS) for complete precautionary and disposal information.

If instructions and warnings cannot be strictly followed,
do not use this product.

FOR INDUSTRIAL USE ONLY

TECHNICAL DATA

Characteristics	Thurmalox 245C Primer	
Generic Type	Silicone Zinc Dust	
Color	Dark Gray	
Number of components	Two	
Temperature resistance		
Continuous	1000°F (538°C)	
Intermittent	1200°F (648°C)	
Percent (%) Solids by volume	50	
Dry film thickness per coat	1.5 - 2.0 mils (37 - 50 microns)	
Wet film thickness per coat	3.0 - 4.0 mils (75 - 100 microns)	
Theoretical coverage	820 mil. sq. ft. per gallon 20.0 sq. m. @ 25 microns per liter	
Application temperature @ 50% RH	50°F-120°F (10°C-50°C)	
Drying time @ 50% RH		
To touch	8-10 hours	70°F (21°C) 6-8 hours
To recoat	24 hours	10-12 hours
To ship	72 hours	48 hours
Full cure @ 350°F (177°C)*	30 minutes	
Weight per gallon		
Thurmalox 245C Primer	15.0 lb. (6.7 kg.)	
Dampney 180 Thinner	8.3 lb. (3.7 kg.)	
Dampney 100 Thinner	7.2 lb (3.2 kg.)	
Flash point	45°F (7°C)	
Pot life	8 hours	
Shelf life	6 months	
Volatile organic compounds	3.33 lb./gal. (395.5 g./l.)	

* See Dry Time section

WARRANTY

Dampney protective coating products are expressly warranted to meet applicable technical and quality specifications. The technical data contained herein are accurate at the date of issuance but are subject to change without prior notification. No warranty of current accuracy is hereby given or implied. User must contact Dampney to verify correctness before ordering. Dampney assumes no responsibility for coverage, performance or injuries resulting from handling or use and **LIABILITY, IF ANY, SHALL BE LIMITED TO PRODUCT REPLACEMENT**. In no event will Dampney be responsible for consequential damages, except insofar as mandated by law. Dampney **DISCLAIMS ALL OTHER WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE**.