



**Thurmalox® 2600 Air Dry Series  
Self Priming Baghouse Coating  
Heat and Corrosion Resistant to 600°F**

**Description**

Thurmalox 2600 series coatings are VOC compliant high performance silicone coatings formulated for the protection of the interior surfaces of baghouses and other air pollution control equipment exposed to a combination of high temperatures and aggressive environments. Thurmalox 2600 series coatings are designed to protect metal surfaces operating at temperatures up to 600°F (315°C). They provide a tough, chemical and abrasion resistant film with excellent thermal shock properties. Consult Dampney Technical Service on all projects when applying and/or specifying Thurmalox 2600 series coatings.

**Recommended Uses**

- Interior walls of boilers and furnaces
- Interior surfaces of breechings, ducts and stacks
- Insulated surfaces (carbon and stainless steel)
- Dry scrubbers

**Features**

- Air dries and self priming
- Excellent heat, corrosion and chemical resistance
- Resistant to thermal shock and cycling temperatures
- VOC Compliance - 3.5 lb./gal (420 g./l.)
- Forms a tough, abrasion resistant film

**Not Recommended For**

- Continuous exposure to temperatures above 600°F (315°C)
- Immersion service

**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 1.5-2.5 mils maximum. Abrasive used in blasting should be selected carefully from materials of mesh size required to produce the desired anchor pattern.

**Mixing**

Redisperse any settled-out pigments by stirring with a paint paddle followed by thorough mixing to a uniform consistency with an explosion-proof or air-driven power mixer. Do not open containers until ready to use. Keep lid on container when not in use.

**Application Guidelines - Carbon Steel**

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

Primer: Thurmalox 2600-00 Off White	4.0 - 5.0 mils (100-125 microns)
Midcoat: Thurmalox 2600-0108 Lt. Gray	4.0 - 5.0 mils (100-125 microns)
Finish: Thurmalox 2600-00 Off White	4.0 - 5.0 mils (100-125 microns)
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Total dry film thickness	12 - 15 mils (300 - 375 microns)

**Application Equipment**

Thurmalox 2600 series coatings can be applied using conventional or airless spray equipment. Do not apply Thurmalox 2600 series coatings in heavier film 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.

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\*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 pressure to pump	100 psi
Pump operating pressure	80-90 psi

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

### Application Procedures

1. Flush spray equipment with Dampney 160 Thinner before use.
2. Thinning of Thurmalox 2600 series coatings is not normally required for spray application. If required for brush or roller application, use up to 1/2 pint maximum of Dampney 160 Thinner per gallon of coating.
3. DO NOT use any other solvents to thin 2600 series coatings. Incompatibility may result and too rapid solvent evaporation can cause dry spray and poor film characteristics.
4. Use Dampney 160 Thinner cautiously. Addition of a small amount of thinner will cause a great reduction in coating viscosity. Excessive thinning will cause runs or sags.
5. For conventional spray use adequate air pressure and volume to obtain proper atomization.

### Thinning

Only thin Thurmalox 2600 series coatings with Dampney 160 Thinner. Do not thin beyond federal, state and/or local VOC (volatile organic compound) emission regulations. Note: Use of other thinner not approved by Dampney may hinder product performance and void product warranty.

### Dry Time 70°F (21°C) 50% RH

Thurmalox 2600 series coatings will air dry tack and thumb print free within 6-8 hours. Allow 12-16 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 2600 series 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 2600 series coatings in the air-dried state will heat cure when placed into service.

### Cleanup

Thoroughly flush spray equipment and hoses immediately after use with Dampney 160 Thinner. Dismantle spray equipment and clean parts, brushes and rollers with Dampney 160 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 2600 Series Coatings	
Generic Type	Silicone	
Color	Off-white, light-gray	
Temperature resistance	600°F (316°C)	
Continuous	56	
Percent (%) Solids by volume	4.0 - 5.0 mils (100 - 125 microns)	
Dry film thickness per coat	7.0 - 9.0 mils (175 - 225 microns)	
Wet film thickness per coat	898 mil. sq. ft. per gallon	
Theoretical coverage	21.5 sq. m. @ 25 microns per liter	
Application temperature @ 50% RH	50°F-120°F (10°C-50°C)	
Drying time @ 50% RH	50°F (10°C)	70°F (21°C)
To touch	10-12 hours	6-8 hours
To recoat	24 hours	12-16 hours
To ship	72 hours	48 hours
Full cure @ 350°F (177°C)*	30 minutes	
Weight per gallon		
Thurmalox 2600 Series	11.5 lb. (5.21 kg.)	
Dampney 160 Thinner	8.1 lb. (3.6 kg.)	
Flash point	134°F (57°C)	
Pot life	N/A	
Shelf life	1 year	
Volatile organic compounds	3.5 lb./gal. (420 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.**