TEMAL 600

DESCRIPTION
A silicone aluminium paint.

PRODUCT FEATURES AND RECOMMENDED USES
♦ Resistant to temperatures up to +650 ºC dry heat on steel without primer and to +400 ºC when applied over zinc silicate paint.
♦ Recommended for exteriors of steel structures exposed to high temperatures.
♦ Suitable for fireplace doors, flues, exhaust pipes, sauna stoves and other hot metal surfaces.
♦ For industrial use only according to Directive 1999/13/EC.

TECHNICAL DATA

Volume solids 22 ± 2 %. (ISO 3233)
Weight solids 34 ± 2 %.
Specific gravity 1.0 kg / l
Product code 006 7679

Recommended film thicknesses and theoretical coverage

<table>
<thead>
<tr>
<th>Recommended film thicknesses</th>
<th>Theoretical coverage</th>
</tr>
</thead>
<tbody>
<tr>
<td>dry</td>
<td>wet</td>
</tr>
<tr>
<td>15 µm</td>
<td>70 µm</td>
</tr>
</tbody>
</table>

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

Drying times

<table>
<thead>
<tr>
<th>DFT 15 µm</th>
<th>+ 10 ºC</th>
<th>+ 23 ºC</th>
<th>+ 35 ºC</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dust dry, after</td>
<td>30 min</td>
<td>15 min</td>
<td>10 min</td>
</tr>
<tr>
<td>Touch dry, after</td>
<td>2 h</td>
<td>1 h</td>
<td>30 min</td>
</tr>
<tr>
<td>Recoatable, after</td>
<td>3 h</td>
<td>2 h</td>
<td>1 h</td>
</tr>
</tbody>
</table>

Final cure and hardness will be obtained by curing at +230 ºC.

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

Finish
Metallic lustre.

Colours
Aluminium.
TEMAL 600

APPLICATION DETAILS

Surface preparation
Oil, grease, salts and dirt are removed by appropriate means. (ISO 12944-4)

**Steel surfaces:** Blast clean to grade Sa2½. (ISO 8501-1) If blast cleaning is not possible, phosphating is recommended for cold rolled steel to improve adhesion.

**Zinc silicate surfaces:** Oil, grease, salt and dirt are removed from the surface by appropriate means. Repair any damage to the primer coat. Note the overcoating time of primer. (ISO 12944-4)

Primer
TEMASIL 90.

Finish
TEMAL.

Application conditions
All surfaces must be dry. The temperature of the ambient air, surface or paint should not fall below + 5 °C during application. Relative humidity should not exceed 80 %. The surface temperature of the steel should remain at least 3 °C above the dew point.

Application
By conventional spray or brush. Mix the paint thoroughly before use. Depending on the application method the paint can be thinned 0 - 10 %.

Thinner
Thinner 1006.

Cleaning of equipment
Thinner 1006.

VOC
The Volatile Organic Compounds amount is 660 g/litre of paint. VOC of the paint (thinned 10 % by volume) is 680 g/l.

HEALTH AND SAFETY
Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Tikkurila Coatings Oy.