

HI TEMP[™] UNIPRIME

Heat Resistant Primer

PC 926

- FEATURES**
- HEAT RESISTANT TO 550°C CONTINUOUS
 - EXCELLENT HEAT QUENCH RESISTANCE

USES Areas of use include steel boiler stacks, chimneys, steam pipes, furnaces, reaction vessels, etc., which are subject to high heat in industrial atmospheres.
A HI TEMP[™] catalyst is available which facilitates air drying in the event that delays occur before topcoating with HI TEMP[™] 400 or 600.

SPECIFICATIONS
RESISTANCE GUIDE

HEAT RESISTANCE	Up to 550°C dry heat (Continuous). Up to 600°C dry heat (Intermittent).	ALKALIS	Not recommended where fumes, splash or spillage may occur.
WEATHERABILITY	On exterior exposure some chalking may also occur. This will not detract from the protective properties of the coating. Use a weatherable topcoat if required for appearance.	SALTS	Unaffected by splash and spillage of neutral salt solutions.
SOLVENTS	Resists splash and spillage of most hydrocarbon solvents when fully cured.	WATER	Resists rain and condensation. Not recommended for permanently damp or immersed exposure.
ACIDS	Not recommended where fumes, splash or spillage may occur.	ABRASION	Good adhesion resistance when exposed to normal weathering.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Silicone heat resistant primer	APPLICATION CONDITIONS	Min	Max	
FINISH	Flat	Air Temperature	10°C	45°C	
COLOUR	Grey	Substrate Surface Temperature	10°C	45°C	
COMPONENTS	One	Relative Humidity		85%	
SOLIDS BY VOLUME	40%		Min	Max	Recom.
VOC LEVEL	<530 g/L	Wet film per coat (microns)	50	75	65
FLASH POINT	26°C	Dry film per coat (microns)	20	30	25
POT LIFE	24 Hours if catalyst is used	SUITABLE SUBSTRATES	Abrasive blast cleaned steel.		
MIXING RATIO (V/V)	Single pack	TOPCOATS	HI TEMP [™] heat resistant finishes		
THINNER	965-63020 Dulux [®] CR Reducer	APPLICATION METHODS	Brush, roller, conventional, airless spray or air assisted spray.		
PRODUCT CODE	950-16185				

Drying characteristics at 25 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure*	Overcoat	
					Min	Max*
25° C	50%	2 Hours	12 Hours	On Heating	12 Hours	Until Heated
With Catalyst						
25° C	50%	2 Hours	8 Hours	On Heating	8 Hours	Until Heated

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

* Product does not fully harden until the surface is heated to 150°C to 200°C for 2 hours.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 16.0 sq. metres per litre corresponds to 25 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

HI TEMP™ UNIPRIME

TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM	DRY FILM THICKNESS
STEEL	Abrasive blast AS1627.4 Class 2	150°C – 435°C	
		1st Coat HI TEMP™ UNIPRIME	25 Microns
		2nd Coat HI TEMP™ 400	20 Microns
		3rd Coat HI TEMP™ 400 (Optional)	20 Microns
		150°C – 550°C	
		1st Coat HI TEMP™ UNIPRIME	25 Microns
		2nd Coat HI TEMP™ 600	20 Microns
		3rd Coat HI TEMP™ 600 (Optional)	20 Microns

SURFACE PREPARATION Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to AS1627.4 Class 2. Remove all dust by brushing or vacuum cleaning.
In less demanding environments hand or power tool (AS1627.2.St 3) cleaning may be satisfactory.

APPLICATION Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Remix thoroughly before using. If the surface is to be handled before heating, mix in HI TEMP™ catalyst at 190 grams per 4 litre. This will minimise damage to the coating.

BRUSH/ROLLER Apply even coats of the mixed material to the prepared surface. When brushing and rolling additional coats may be required to attain the specified thickness.

CONVENTIONAL SPRAY Thin up to 50ml/litre with Dulux® CR Reducer (965-63020) to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

Typical Set-up

Graco Delta Gun: 1.8mm (239543)
Pressure at Pot: 70-100 kPa (10-15 p.s.i.)
Pressure at Gun: 380-410 kPa (55-60 p.s.i.)

AIRLESS SPRAY Standard airless spray equipment such as a Graco 33:1 Bulldog with a fluid tip of 15 thou (0.38mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 50 ml/litre of Dulux® CR Reducer (965-63020) may be added to ease application.

PRECAUTIONS This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint.

Allow at least 2 hours drying before heating up. After this initial drying period increase temperatures gradually until 150°C is reached. The coating does not fully harden until the surface is heated to 150°C to 200°C for at least 2 hours. Film thicknesses are critical to sound performance; over-thick films will cause blistering on heat-up.

Where frequent shut down of plant occurs in aggressive industrial or marine environments, maximum corrosion resistance will be given by priming with ZINCANODE® 304 provided that the operating temperatures are below 400°C.

Not suitable for use under insulation where moisture is present.

CLEAN UP Clean all equipment with Dulux® CR reducer (965-63020) immediately after use.

OVERCOATING Do not overcoat with itself once the coating has been heat cured. Rust, millscale, oxide deposits and old paint films on metal surfaces must be removed by abrasive blast cleaning to AS1627.4 Class 2.5.

SAFETY PRECAUTIONS **Read Data Sheet, Material Safety Data Sheet and any precautionary labels on containers.**

STORAGE Store as required for a flammable liquid Class 3 in a bonded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

HANDLING As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

USING Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.

FLAMMABILITY This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.

WELDING Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

MATERIAL SAFETY DATA SHEET is available from Customer Service (132377) or www.duluxprotectivecoatings.com.au

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PACKAGING	Available in 4 litre containers
TRANSPORTATION WEIGHT	1.60 kg/litre
DANGEROUS GOODS	Class 3 UN 1263

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