



# TEMPERKOTE® H<sub>2</sub>O PRIMER

## HI-HEAT® Corrosion Control

\*Maximum Service Temperature 450°F (232°C)

### DESCRIPTION:

TemperKote H<sub>2</sub>O Hi-Heat Corrosion Control Primer is a VOC compliant water-based primer designed to impart corrosion resistance in severe environments. The primer withstands thermal cyclic conditions to 450°F. It is specially formulated to form a tenacious protective bond providing maximum corrosion protection under TemperKote H<sub>2</sub>O topcoats. TemperKote H<sub>2</sub>O Hi-Heat Corrosion Control Primer air dries by coalescence to form a tough, durable, heat, chemical, and moisture vapor resistant film. It does not require any complex heat-curing schedule to obtain heat resistant properties. TemperKote H<sub>2</sub>O Hi-Heat Corrosion Control Primer is designed to be topcoated with TemperKote H<sub>2</sub>O within 2 hours.

### RECOMMENDED USES:

Wherever maximum resistance to heat, humidity, and weather is required. Can be used as a primer under TemperKote H<sub>2</sub>O on heaters, stacks, boilers, breeches, mufflers, radiators, storage tanks, pipelines, steam lines, etc., where operating temperature will not exceed 450°F (232°C). **Not recommended** for use on the **inside** of ovens, stacks, etc.

### FEATURES:

- VOC Compliant, waterbased formulation
- Low odor
- Very Good resistance to corrosion, weathering and heat.
- Excellent resistance to thermal shock.
- Open recoat window
- Water clean-up

### CHARACTERISTICS:

**Colors** . . . . . Gray or Red Oxide  
**Thermal Stability** . . . . 450°F (232°C)  
**Finish** . . . . . Flat

**Resin Type** . . . . . Modified Acrylic  
**Spreading Rate** . . . . . 400 sq. ft./gal. (12.3m<sup>2</sup>/L)  
 Per coat 4.0 mils wet, 1.50 mils dry  
**V.O.C.** . . . . . <1.45 lbs. /gal. (174g/L)  
**Volume Solids** . . . . . 36.7% ± 2  
**Weight Solids** . . . . . 48% ± 2  
**Drying Time @**  
**77°F & 50% RH:** . . . . .  
 To touch 1 hour  
 To overcoat 2 hour  
**Type of Cure** . . . . .  
 Water Evaporation/Coalescence  
**Flash Point.** . . . . . None  
**Reducer/Cleaner** . . . . . Water  
**Shelf Life.** . . . . . 1 year (unopened)  
**Packaging** . . . . 1 & 5 gal. Containers  
 weight/gal. 10.3 lbs.  
**Shipping weight** . . . . 4 gals - 44 lbs  
 5 gals - 55 lbs  
**Application** . . . . . Brush,  
 conventional and airless spray

### PRECAUTIONS:

**CAUTION!** Do not take internally. Close container after each use.

**Protect from freezing**

**Read MSDS before opening containers**

### SURFACE PREPARTION:

For best results surfaces should be free from oil, grease, dirt, mill scale, rust, corrosion products, oxides, paint and foreign matter.

### STEEL:

Remove all flux, splatter and slag left from welding. Grind all welds until smooth. Remove rust, mill scale, oil, grease, and other contamination by solvent cleaning per SSPC-SP1. For typical industrial environments a low profile white metal blast, SSPC-SP5, is preferred as it will result in the highest performance of a paint system since all surface contamination is completely removed.

SSPC-SP5 should be conducted at a time when no contamination or rusting will occur and when prompt painting is possible. If abrasive blasting is not permitted, prepare surface by power tool cleaning per SSPC-SP3. If this is not practical hand tool cleaning per SSPC-SP2 may be utilized. Please note that the adhesion of the primer relies greatly on surface preparation and this becomes increasingly critical as service temperatures increase. Methods in order of effectiveness are SSPC-SP-5, SSPC-SP-3, SSPC-SP-2. When utilizing power tool cleaning or hand tool cleaning it must be followed by SSPC-SP-1, solvent cleaning.

### APPLICATION:

Flame Control TemperKote H<sub>2</sub>O Hi-Heat Corrosion Control Primer is ready to use. It can be applied by brush, airless or conventional spray equipment. Stir thoroughly and apply one coat of TemperKote H<sub>2</sub>O Hi-Heat Corrosion Control Primer at approximately 4.0 mils wet film thickness, (400 sq. ft. /gal.) to yield a dry film thickness of 1.5 mils. Allow to cure a minimum of 2 hours at ambient temperatures. Apply one coat of TemperKote H<sub>2</sub>O Series Hi-Heat Coating at the specified coverage rate. If thinning is required, use WATER only. Do not apply in temperatures below 50°F (10°C).

### APPLICATION EQUIPMENT:

**Airless Spray**  
**Titan 440 Impact** (or Equivalent)  
 Pump  
 Fluid Pressure. . . . . 1800-2200 psi  
 Manifold Filter . . . . . 60 Mesh  
 Gun Filter . . . . . 60 Mesh  
 Fluid Hose . . . . . ¼" diameter  
 Gun . . . . . LX-80 II  
 Tip. . . . . .015 - .019

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