

ThermaCoat- 300 and 400 Temperature Gradient Chart (Temperature are in Celsius)

Dry Film Thickness (microns)	Number of Coats	Initial Surface Temp. C	Temperature After Coating is Cured																	
			200	190	180	160	150	140	130	120	110	100	95	90	85	80	75	70	65	60
50	1		180	173	164	145	136	127	118	109	100	91	87	83	78	74	69	65	61	56
100	2		165	158	150	132	124	116	108	100	92	84	81	76	73	68	65	62	57	54
150	3		150	146	139	122	115	108	101	94	87	80	75	73	68	66	64	59	56	53
200	4		139	128	123	108	103	98	93	88	78	73	68	66	64	62	59	56	54	52
250	5		127	122	118	104	100	96	92	82	78	68	64	62	59	57	55	52	50	48
300	6		116	110	105	100	94	89	84	78	73	68	63	60	57	55	52	49	47	44
350	7		106	101	97	92	87	82	77	73	68	63	58	56	53	51	49	46	44	
400	8		97	93	89	85	80	76	72	67	63	59	54	52	50	48	46	44		
450	9		90	86	82	78	74	70	66	63	59	55	51	49	47	45	43			
500	10		82	78	75	71	68	64	61	57	54	50	47	45	43	42				
550	11		75	73	70	67	64	61	58	55	51	48	45	44						
600	12		71	68	65	62	60	57	54	51	48	45								
650	13		66	63	61	58	56	53	51	48										
700	14		61	59	57	54	52	50												
750	15		57	55	53	51														
800	16		53	52																

Gray shaded areas are within the OSHA safe touch range of under 60C

ThermaCoat-300 and 400 will dry to approximately 50% of applied wet film thickness. Each coat should be applied at 100 micron wet film thickness (WFT) and will dry to 50 micron dry film thickness (DFT). Use wetfilm thickness gauge to measure your film thickness. Number of coats is approximate, make sure that you measure the dryfilm thickness for your application. There are 25.4 microns per mils to measure film thickness. Temperature reflects fully cured applications. Cure time is typically 30 to 90 days depending on total thickness and environmental conditions.