

DE 340 AF Blast Resistant Coating

Dyna Therm

**Technical Bulletin
January, 2002**

PRODUCT DESCRIPTION meets Mil-C-47244; NAVORD-2180981, MIS-36199

Flamemaster (Dynatherm) E-340 is a room temperature curing, high temperature resistant ablative coating for use in areas subject to exposure to extreme heat and high erosion such as experienced in solid propellant missile launchings. E-340 is a rigid, two component silicone-modified epoxy based compounds designed for trowel or molding application. E-340 is supplied in a variety of camouflage colors for application to tracked vehicles of the United States and its allies. A deck gray shade matching color chip 26081 of Federal Standard 595 is available for use on naval vessels.

ENVIRONMENTAL REQUIREMENTS

Ambient and metal surface temperatures for mixing and application of the ablative coatings must be between 50°F and 100°F. If conditions warrant, a cover or shroud should be erected over the work areas in order to insure a clean, dry surface during application and initial cure of the coating.

SURFACE PREPARATION

Cover any bearing seals with tape or appropriate plastic cover to prevent entry of foreign material.

Clean metal surfaces where ablative is to be applied by chipping, scraping, wire brushing or equivalent method. Use a vacuum cleaner or equivalent method to remove chips, etc. from around the areas.

Color and Designation:

All Colors 8030-00-097-9088

#26081 = Deck Gray 8030-00-164-4389 Gallon

8030-01-353-8379 5-Gallon

#34094=Forest Green

8030-00-01-032-1749 Gallon

#24087 = Olive Drab

#23448 = Desert Sand

Morocco Brown

Coverage Approximately 12 sq. ft.
per gallon at 1/8" Thick

Pot Life 1 hour minimum at 75°F

Flow 0.3" Maximum

Tack Free Time 8 hours at 75°F

Cure Cycle to 40 Shore "D" Hardness
24 hours at 75°F

Specific Gravity 1.5

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MIXING AND APPLICATION INSTRUCTIONS

The ablative coating is supplied in pre-measured kits of 150 parts by weight of Part A and 100 parts by weight of Part B. Mix thoroughly with a power mixer until a uniform color (no light or dark streaks) is achieved, normally ten to fifteen minutes. Apply material with trowels by using an even back and forth swirling motion until the desired uniform thickness is obtained. Multiple coats may be required be wiped with a suitable solvent (methyl ethyl ketone or toluene).

FINISH

After one hour cure, a smooth surface may be obtained by going over the coating with a trowel that has been dipped in water or solvent. If a non-skid surface is desired, a notched trowel may be used or a grooved polyethylene de-airing roller may be dipped in water and rolled over the surface to produce grooves.

INSTRUCTIONS FOR REFURBISHING

The environmental requirements are the same as previously stated under Environmental Requirements. To prepare and clean the surface use a power sander with 50-80 grit sand paper and roughen the ablative surfaces to be refurbished. Bevel all surface edges. Clean surfaces thoroughly with Isopropyl Alcohol then allow material time to return to original dry color. Follow the above mixing and application instructions and finish instructions.

STORAGE LIFE

The shelf life of E-340 is 12 months.

CLEAN UP

When work is completed, promptly clean all equipment and tools used in the application by washing with warm, soapy water.

SAFETY

Safety precautions are the normal requirements for most paints and epoxy systems, i.e., avoid breathing of vapors and use with ventilation. Precautions should be taken to avoid contact with the skin. Rubber gloves or protective creams are normally used and hands should be thoroughly washed with soap and water after exposure.

PACKAGING

E-340 is packaged in Quart, Gallon and 5-Gallon Kit sizes.

The information presented herein is based on data believed to be reliable. However, Flamemaster cannot insure that your results will be the same as those described, as the conditions of use are beyond our control.