

**Dynaspec 340-3  
N-5693  
MIL-PRF-24635E  
Gray Silicone Alkyd Enamel, Type II, Class 3, LRC**



**Intended Uses:**

This product is a low gloss copolymerized silicone alkyd enamel for use on primed, metal, glass reinforced plastic, and plastic/composite surfaces. This product exhibits excellent color and gloss retention. These low reflective coatings, LRC, have been designed to be highly absorbent in the visible and near infrared portion of the electromagnetic spectrum. Complies with Military Specification: MIL-PRF-24635E.

**Physical Properties**

<b>Color:</b>	Gray # 36270	<b>Substrate Tested:</b>	Product Applied on Q-Steel @ 3.0 mils DFT
<b>Gloss:</b>	6 maximum at 60°	<b>Water Resistance:</b>	Pass 18 hours
<b>Volume Solids:</b>	56.36 +/- 2.0 %	<b>Flexibility:</b>	Pass 1/8 inch Mandrel
<b>Weight Solids:</b>	72.53 +/- 2.0 %	<b>QUV 313B:</b>	Pass 300 hours Gloss loss < 35% ΔE < 1.0 CIELAB Units
<b>Weight Per Gallon:</b>	11.49 +/- 0.2 lbs	<b>Pencil Hardness:</b>	2B @ 72 Hours
<b>Theoretical Coverage:</b>	904 sq ft/gal @ 1 mil dft	<b>Florida Weathering (1 year):</b>	Pass Gloss loss < 50% ΔE < 1.0 CIELAB Units
<b>VOC:</b>	2.8 lbs/gal (340 gms/liter)	<b>Recommended Film Thickness:</b>	3 mils DFT
<b>Viscosity:</b>	90 KU Max.		

**Application Characteristics**

<b>Mix Ratio:</b>	Single component product. Mix thoroughly before use.		
<b>Reducer:</b>	No thinning allowed.		
<b>Cleaning Solvent:</b>	T-256, Mineral Spirits		
<b>Pot Life:</b>	Not applicable.		
<b>Dry Time @ 77°F:</b>	<b>Touch:</b> 2 hrs	<b>Through Dry:</b> 6 – 8 hrs	<b>Recoat:</b> 24 hrs.
<b>Full Cure:</b>	A function of time, temperature and film thickness.		

**Recommended Primers**

<b>Substrate</b>	<b>Recommended Primer</b>
<b>Aluminum/Galvanized Steel/Stainless Steel:</b>	MIL-DTL-24441, MIL-PRF-23236C or TT-P-645.
<b>Previously Painted Surfaces:</b>	Remove all mill scale, loose rust, loose paint and other foreign matter by “Hand or Power Tool Cleaning) (SSPC-SP2 or SSPC-SP3 respectively). Sand or “Brush Blast” (SSPC-SP7) hard glossy areas until dull before application.
<b>Steel:</b>	Remove all grease, oil or other surface contaminants per SSPC-SP 1. Apply over MIL-DTL-24441, MIL-PRF-23236C or TT-P-645 primer.

**Application Equipment**

<b>Conventional Spray:</b>	<b>Air Pressure:</b> As required for proper atomization.	<b>Fluid Pressure:</b> As required for proper atomization.	<b>Cap:</b> Medium to Heavy Visc. <b>Tip:</b> 2 –3 mm
<b>Airless:</b>	<b>Pressure:</b> 1500-2500 psi.	<b>Tip:</b> .017 - .019	
<b>Brush and Roll:</b> Use China Bristle or OX Hair Bristle Brushes, <i>Lint Free</i> , Soft Woven or Mohair Rollers. Roller nap should not exceed 3/8” to avoid heavy orange peel and excessive film build.			
<b>Note:</b> The above parameters are to be used as a guideline only.			

**Technical Data Sheet**

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## **Surface Preparation**

Do not apply if the surface temperature is less than 5°F above the dew point. Before applying, the surface should be cleaned per SSPC-SP 1 to remove all surface contaminants.

## **Safety Precautions**

This product is intended for professional use in an industrial environment only! Consult the Material Safety Data Sheet prior to application for detailed information on the health and safety hazards.

## **Shelf Life & Storage Conditions**

Shelf life: 24 months from the date of manufacture. This product must be stored in accordance with local, state, and national regulations. Keep containers in a cool (35°F –95° F), dry, well- ventilated space and away from sources of heat and ignition.

## **Comments**

For additional information contact your NCP Coatings, Inc. Sales Representative, Customer Service Representative, or visit our website: [www.ncpcoatings.com](http://www.ncpcoatings.com)

## **Note**

The above information is supplied as a guideline to our customers. The user must be aware of the cleaning, pretreatment, application and testing requirements for their specific job!