

Selection & Specification Data

Generic Type	Modified Novolac Epoxy
Description	Phenoline 353 is a highly cross-linked epoxy lining with extraordinary overall chemical resistance and versatility. It has a unique blend of resins that make it highly resistant to a variety of aggressive cargos like gasoline, gasoline blends, biodiesel, fuel oils, and others. It can be used is both acidic and high temperature caustic exposures. Markets served are terminals, refineries, petrochemical, wastewater, railcar linings, and many others.
Features	<ul style="list-style-type: none"> • Outstanding overall chemical resistance • Dense, highly cross-linked film for superior barrier protection • Excellent abrasion resistance and toughness • Well-suited for hydrocarbon exposures • Low temperature cure version available <p>For a comprehensive list of chemical resistance see the latest Phenoline 353 Chemical Resistance Chart.</p>
Color	Red-brown (0500), Gray (0700), White (0800)
Finish	Gloss
Dry Film Thickness	5 - 6 mils (127 - 152 microns) per coat
	Two coats are generally recommended to 10-12 mils (200-250 microns) total DFT.
Solids Content	By Volume 75% +/- 2%
HAPs Values	As supplied: 1.35 lbs/solid gallon These are nominal values and may vary by color.
Theoretical Coverage Rate	1203 ft ² /gal at 1.0 mils (29.5 m ² /l at 25 microns) 241 ft ² /gal at 5.0 mils (5.9 m ² /l at 125 microns) 200 ft ² /gal at 6.0 mils (4.9 m ² /l at 150 microns) Allow for loss in mixing and application.
VOC Values	Thinner 2 8 oz/gal w/ #2 2.04 lbs/gal (244 g/l) As Supplied 1.72 lbs/gal (206 g/l) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 250 °F (121 °C) Non-Continuous: 300 °F (149 °C) Discoloration and loss of gloss is observed above 200°F (93°C).
Limitations	Linings exposed to cargos warmer than the outside steel temperature are subject to a "cold-wall" effect. The smaller the temperature differential the less negative effect on performance. Epoxies lose gloss, discolor and eventually chalk in sunlight exposure.

Substrates & Surface Preparation

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
Steel	Immersion: SSPC-SP10 minimum Profile: 1.5-3.0 mils (38-75 microns)

Substrates & Surface Preparation

Concrete or CMU Immersion: Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258-92 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.

Mixing & Thinning

Mixing	Power mix separately, then combine and power mix. When using between 60-70°F (15-21°C), mix and allow the material to "sweat-in" for 15 minutes before using. DO NOT MIX PARTIAL KITS.
Thinning	May be thinned up to 8 oz/gal with Thinner #2. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	4:1 Ratio (A to B)
Pot Life	2 Hours at 75°F (24°C) Pot life ends when coating shows dramatic changes in viscosity. Pot life times will be less at higher temperatures

Application Equipment Guidelines

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General)	The following spray equipment has been found suitable and is available from manufacturers.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.055-0.070" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.015-0.019" Output PSI: 2100-2300 Filter Size: 60 mesh *PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Not recommended for tank lining applications except when striping welds and touching up.
Brush	Use a medium bristle brush.
Roller	Use a short-nap synthetic roller cover with phenolic core.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	60 °F (16 °C)	50 °F (10 °C)	50 °F (10 °C)	0%
Maximum	90 °F (32 °C)	110 °F (43 °C)	100 °F (38 °C)	85%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

Phenoline[®] 353

Curing Schedule

Surface Temp.*	Final Cure Immersion	Maximum Recoat Time	Minimum Recoat Time
60 °F (16 °C)	10 Days	10 Days	12 Hours
75 °F (24 °C)	7 Days	7 Days	8 Hours
90 °F (32 °C)	5 Days	2 Days	6 Hours

These times are based on a 5-7 mil (125-175 micron) dry film thickness and adequate ventilation for the release of solvents for proper cure. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment, delamination between coats and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. If the maximum recoat time is exceeded, the surface must be abraded prior to the application of additional coats. Note: It is recommended to cure above 60°F (16°C) for aggressive service.

Surface Temp.*	Final Cure Immersion
150 °F (66 °C)	8 Hours

The above curing schedule may be used to force cure the coating system. Allow the freshly applied coating to air dry for 4 hours prior to elevating temperature. Elevate temperature no more than 30°F (15°C) every 30 minutes.

Cleanup & Safety

Cleanup	Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions.
Ventilation	When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Packaging, Handling & Storage

Shelf Life	Part A & B: Min. 24 months at 75°F (24°C) <small>*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.</small>
Shipping Weight (Approximate)	<u>1 Gallon Kit</u> 15 lbs (7 kg) <u>5 Gallon Kit</u> 75 lbs (32 kg)
Storage Temperature & Humidity	40°-110°F (4°-43°C) 0-90% RH
Flash Point (Setaflash)	Part A: 81°F (27°C) Part B: 55°F (13°C) Mixed: 86°F (30°C)
Storage	Store Indoors.



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