

DATOS DE SELECCIÓN Y ESPECIFICACIÓN

Tipo genérico	Low temperature bake high solids modified epoxy cured with an amine curing agent
Descripción	Plasite 9570 is a highly resistant film for chemical tank lining service. Specifically formulated for excellent abrasion resistance while retaining temperature, chemical and other physical properties to provide greater release properties to aid in the prevention of product hang-up or bridging problems.
Características	Meets the requirements of US Food & Drug Regulations 21 CFR 175.300 Accepted by the US EPA for use on surfaces which contact potable water Excellent chemical resistance to all caustic solutions up to 200 °F (93 °C) and to a wide range of acids, solvents and water solutions
Color	Iron Oxide Yellow, Olive Oxide, *Cream Note: Will discolor when exposed to UV. * for use of prime coat
Acabado	Semibrillante
Espesor de película seca	102 - 178 micras (4 - 7 milésimas) por capa 305 - 381 micras (12 - 15 milésimas) in two to three coats
Usos típicos	As a highly resistant film for chemical tank lining service
Contenido de sólidos	Por volumen 83% +/- 2%
Tasa de cobertura teórica	32.7 m ² /l a 25 micras (1331 pies ² /gal a 1.0 milésimas de pulgada) 8.2 m ² /l a 100 micras (333 pies ² /gal a 4.0 milésimas de pulgada) 2.2 m ² /l a 375 micras (89 pies ² /gal a 15.0 milésimas de pulgada) Tenga en cuenta la pérdida de producto durante el mezclado y la aplicación.
Valores de COV	Como se suministra : 158 ± 2% Plasite Thinner #71 : 218 ± 2% VOC content varies between colors. Contact Carboline Technical Service Department for VOC of specific colors.
Resistencia a temperatura seca	No continuo: 204°C (400°F) Non-continuous temperature resistance is for non-immersion service. Immersion temperatures depend on particular reagent.

SUSTRATOS Y PREPARACIÓN DE LA SUPERFICIE

<p>Acero</p>	<p>Immersion Service All sharp edges shall be ground to produce a radius and all imperfections such as skip welds, delaminations, scabs, slivers and slag shall be corrected prior to abrasive blasting. Skip welds shall be welded solid. Surface shall be contaminant-free. Organic solvents, alkaline solutions, steam, hot water with detergents, heat or other methods that will completely remove dirt, oil, grease, etc. may be used. Additional decontamination may also be necessary. The surface shall be blasted to an SSPC-SP5 or NACE No. 1 white metal surface using a Venturi blast nozzle supplied with 80 to 100 psi. The air supply shall be free of oil, water and other contaminants. An anchor pattern or "tooth" in the metal shall correspond to approximately 20 to 25% of the total film thickness of the coating. Contaminated grit shall not be used for the finish work. The blasting media used shall be natural abrasive, steel grit, or slag grit (similar or equal to BLACK BEAUTY®). These abrasives shall be sharp with a hard-cutting surface, properly graded, dry and of best quality. The media shall be of proper size to obtain the specified anchor pattern and shall be free of objectionable contaminants. The anchor pattern shall be sharp and no evidence of a polished surface is allowed. Remove all traces of grit and dust with a vacuum cleaner or by brushing. Care must be taken to avoid contaminating the surface with fingerprints or from detrimental material on the workers' clothes. The surface temperature shall be maintained at a minimum of 5°F above the dew point to prevent oxidation of the surface. The coating shall be applied within the same day that the surface has been prepared. Visible oxidation or condensation is not allowed.</p>
<p>Aluminio</p>	<p>Surface shall be clean and grease-free with a blast produced anchor pattern or "tooth" as described earlier under STEEL. In addition, the blasted surface shall be given a chemical treatment such as: ALODINE 1200S available from Henkel Surface Tech IRIDITE 14-2 produced by MacDermid Incorporated OAKITE CRYSCOAT 747LTS and OAKITE CRYSCOAT ULTRASEAL produced by Oakite Products For immersion, blasting with a sharp grit followed by the chemical surface treatment is required. Note: On metallic surfaces prepared only by chemical etching, the total coating film thickness applied should be restricted to only half the film normally applied to blasted surfaces. This reduced film thickness should be considered during selection of the coating for the service and the type of surface preparation performed.</p>

MEZCLADO Y DILUCIÓN

<p>Mezclado</p>	<p>Thoroughly mix Part A then add Part B curing agent slowly and mix completely. The coating should stand approximately 30 minutes after the Part B has been thoroughly mixed.</p>
<p>Dilución</p>	<p>Thinner #71 is recommended for thinning and clean-up. It will always be necessary to thin the coating. The applicator must make exact thinner adjustments based on his equipment and air and surface temperatures. The following thinning guidelines are appropriate: Normal application temperatures and conditions will require the addition of approximately 10-20% thinner by volume with approximately 5% additional thinner added for each 5°F of increased temperature. It is recommended that the amount of thinner included on each order amount to approximately 20% of the coating order.</p>
<p>Relación</p>	<p>4:1 A:B</p>
<p>Vida útil</p>	<p>Approximately 3-4 hours @ 70°F (21°C)</p>

GUÍAS SOBRE EQUIPO DE APLICACIÓN

A continuación, se enumeran las guías generales de equipamiento para la aplicación de este producto. Es posible que las condiciones del lugar de trabajo requieran que se modifiquen estas guías para lograr los resultados deseados.

Aplicación por aspersión (General)

All spray equipment should be thoroughly cleaned and the hose in particular should be free of old paint film and other contaminants.

Use standard production type spray guns such as:

DeVilbiss JGA-510 (Fluid E, Air 797)

Binks #2001 (Fluid 66-SS, Air 63-PB)

Graco P800 (Fluid 04, Air 02)

Liquid pressure: 1500-1800 psi

Tip size: 0.017-0.021"

Air pressure: 60-80 lbs at gun

Pot pressure: 30-35 lbs Thinning requirements are more than for conventional spray.

Adjust spray gun by first opening liquid valve and then adjusting air valve to give an 8-12" wide spray pattern with best possible atomization.

Note: Prior to spray application, stripe brush all welds, attachments and surface irregularities using PLASITE 9570 thinned a minimum of 50% by volume with Thinner #71.

Apply a "mist" bonding pass.

Allow to dry approximately one minute but not long enough to allow film to completely dry.

Apply crisscross multi-passes, moving gun at fairly rapid rate, maintaining a wet appearing film. Observe the coating surface and when it appears to be flowing together, you will have an average of 4-5 mils wet film. By allowing the solvents to flash-off for a few minutes, several more fast multipasses may be applied until you have a film thickness of approximately 5-7 mils DFT (approximately 8-10 wet mils). Repeat this procedure for the second coat to obtain a 12-15 mill DFT.

Overcoat time will vary both with temperature and ventilation and will require from 16-24 hours at 70-90°F for enclosed spaces. Refer to DRYING TIME section. Remove all overspray by dry brushing or scraping if required.

Air dry with ventilation a minimum of 60 minutes prior to introducing heat.

Brocha | Not normally recommended except for touch-up, repairs or at weld areas prior to spraying.

PROGRAMA DE CURADO

Temp. de la superficie	No pegajoso
21°C (70°F)	24 Horas
32°C (90°F)	16 Horas

Drying time between coats may be decreased by force curing. Do not force cure at temperatures in excess of 150°F. When force curing at temperatures between 120-150°F the length of cure must not exceed 12 hours.

CAUTION: Overbaking between coats will result in loss of adhesion.

FINAL BAKE

The final bake is based on metal temperatures. Air dry with ventilation a minimum of 60 minutes prior to introducing heat. After the air dry period has elapsed the temperature should be raised approximately 30°F in increments of 30 minutes until the desired temperature is reached.

4 Hours at 200°F Minimum (Metal Temperature)

2 Hours at 250°F Minimum (Metal Temperature)

A final bake of 250°F will increase resistance to certain exposures and is generally recommended when the exposure is considered to be extremely severe.

LIMPIEZA Y SEGURIDAD

Limpieza | Plasite Thinner #71

Plasite 9570

HOJA DE DATOS DEL PRODUCTO



LIMPIEZA Y SEGURIDAD

Seguridad	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Keep container closed when not in use.
Ventilación	When used 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. User should test and monitor exposure levels to insure all personnel are below guidelines. If not able to monitor levels, use MSHA / NIOSH approved respirator.
Precaución	Fire and explosion hazards: This product contains less than 1% volatile components, however, vapors are heavier than air and can travel long distances, ignite and flash back. Eliminate all Ignitions sources. 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.

EMPAQUE, MANEJO Y ALMACENAMIENTO

Invasado	1 gallon and 5 gallon units
Vida de almacenamiento	Part A: 12 months Part B: 24 months
Almacenamiento	Store indoors
Peso de envío (Aproximado)	13 lbs/gal
Punto de ignición (Setaflash)	Part A: 95°F (35°C) Part B: 48°F (9°C)

GARANTÍA

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