

SELECTION & SPECIFICATION DATA

Generic Type	Low bake, high solids modified epoxy
Description	Phenoline 333 is a low bake, high solids, modified epoxy formulated for use as a protective lining with excellent resistance to molten sulfur. Excellent chemical and thermal shock resistance.
Color	Black
Finish	Gloss
Primer	Self-Priming – one coat application only
Weld Preparation	NACE RP0178-89, Weld Prep Designation C
Wet Film Thickness	7 to 10 mils (178 to 254 microns)
Dry Film Thickness	5 - 7 mils (127 - 178 microns) per coat 1 coat only (do not apply dress coat)
Typical Uses	Lining for corrosive immersion environments, where commodities may contain sulfates. Formulated as an interior lining for resistance to molten sulfur with effective heat distribution and heat dissipation.
Solids Content	By Volume 72% (mixed)
Theoretical Coverage Rate	1155 ft ² /gal at 1.0 mils (28.3 m ² /l at 25 microns) 231 ft ² /gal at 5.0 mils (5.7 m ² /l at 125 microns) 165 ft ² /gal at 7.0 mils (4.0 m ² /l at 175 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 2.0 lbs./gal. (238 g/l) mixed
Dry Temp. Resistance	Continuous: 325°F (163°C) Non-Continuous: 350°F (177°C) Loading temperatures should be limited to 300 °F (149 °C) and unloading to 325°F (163 °C). Steel car should be greater than 0 °F (-18 °C) when loaded.

SUBSTRATES & SURFACE PREPARATION

General	NACE No.2/SSPC-SP 10 Near White Metal Blast. Anchor (surface) profile should be a sharp, angular and dense 2.5 to 3.0 mil (visual comparator) profile.
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MIXING & THINNING

Mixing	4:1 by volume
Thinning	Thinner 231

Phenoline[®] 333

PRODUCT DATA SHEET



MIXING & THINNING

Pot Life | 1 Gallon Kit (mixed) - 70 min. at 77 °F (25 °C)
5 Gallon Kit (mixed) - 35 min. at 77 °F (25 °C)

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.

Airless Spray | Pump Ratio: 45:1
Tip Size: 0.017-0.019" (617-619)
Output PSI: 2,800
recommended minimum to obtain proper atomization

Brush | A small brush can be used for touchup of WFT marks and other small repair areas.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	70°F (21°C)	60°F (16°C)	50°F (10°C)	0%
Maximum	90°F (32°C)		50°F (10°C)	90%

Non-contaminated profile (pretreat and blast contaminated surfaces)
Dry, dust-free metal surface

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry to Recoat
77°F (25°C)	4 Hours	6 Hours	10 Hours

Air Dry Schedule:

- Circulate warm air at 85-90 °F (29-32 °C) for 12 hours minimum. All touch-ups must be made before force cure.

Force Cure | Ramp rate at 50 °F (10 °C) every 30 minutes
150 °F (66 °C) soak temperature for 4 hours

CLEANUP & SAFETY

Cleanup | Thinner 2 or Acetone

Safety | Read and follow all caution statements on this product data sheet and on the SDS for this product.
Employ normal workmanlike safety precautions. Use adequate ventilation. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life | 24 months

Flash Point (Setaflash) | 63 °F (17 °C)

WARRANTY

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