

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Baked Phenolic
<b>Description</b>	Straight baking phenolic formulated as a high-build chemical resistant coating.
<b>Features</b>	Excellent high temperature performance for production tubing in downhole environments.
<b>Color</b>	Iron Oxide Red - Changing to brown after final bake
<b>Dry Film Thickness</b>	5 - 7 mils (127 - 178 microns) .
<b>Typical Uses</b>	Interior of downhole production tubular goods exposed to high temperature corrosive atmospheres. A one or two coat application can produce 5-7 mils (127-178 microns) DFT on the interiors of drilling pipes.  <b>FOR INDUSTRIAL USE IN SHOP APPLICATIONS ONLY</b>
<b>Solids Content</b>	By Volume 40% +/- 2%
<b>Theoretical Coverage Rate</b>	642 ft <sup>2</sup> /gal at 1.0 mils (15.7 m <sup>2</sup> /l at 25 microns) 128 ft <sup>2</sup> /gal at 5.0 mils (3.1 m <sup>2</sup> /l at 125 microns) 92 ft <sup>2</sup> /gal at 7.0 mils (2.2 m <sup>2</sup> /l at 175 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 3.97 lb/gal (476 g/l)

## SUBSTRATES & SURFACE PREPARATION

<b>Steel</b>	Steel surfaces shall be blasted to an SSPC-SP5 or NACE No. 1 white metal surface. The anchor pattern in the metal shall correspond to approximately 20-25% of the total DFT of the coating.
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## MIXING & THINNING

<b>Thinning</b>	Normally does not require thinning. If necessary, use Plasite Thinner 30.
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## APPLICATION PROCEDURES

<b>Application</b>	Apply one spray pass obtaining approximately 2.5-3.5 mils (63.5-88.9 microns) DFT (approximately 7-9 mils/178-229 microns wet). Allow to air dry with ventilation a minimum of 60 minutes prior to intermediate bake. Intermediate bake 30-40 minutes at 200°F (93°C). Apply second 2.5-3.5 mil coat. Allow to air dry with ventilation a minimum of 60 minutes. Start final bake.
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## CURING SCHEDULE

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<b>Curing Details</b>	<b>Bake Schedule</b>
	<b>Intermediate Bake:</b> 30-40 minutes at 200°F (93°C) <b>Final Bake:</b> Start final bake at 200°F (93°C). Increase to final bake temperature of 400°F (204°C) for 1 1/2 hours.* After the air-dry time has elapsed, the substrate temperature should be increased at a time/temperature rate not to exceed 30 °F (17 °C) every 30 minutes until the intermediate baking temperature has been reached. Hold for 30 minutes.
	* <b>Note:</b> Overbaking between coats will result in loss of intercoat adhesion

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## CLEANUP & SAFETY

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<b>Safety</b>	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.
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## PACKAGING, HANDLING & STORAGE

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**Shelf Life** | 6 months at 70°F (21°C)

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## WARRANTY

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