

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Phenolic
<b>Description</b>	A high solids phenolic lining offering superior resistance to acids, chemicals, solvents and salts. Conforms to FDA Title 21 CFR 175.300.
<b>Features</b>	<ul style="list-style-type: none"> <li>• High solids, Low VOC formula</li> <li>• Excellent abrasion resistance</li> <li>• Resistant to a wide range of acids, chemicals, and solvents</li> <li>• Excellent thermal shock resistance</li> <li>• Resistant to concentrated sulfuric acid</li> <li>• Excellent for transportation equipment</li> </ul>
<b>Color</b>	Brownish-Red (B500) and Green (0300) (both colors darken after final cure)
<b>Finish</b>	Eggshell
<b>Dry Film Thickness</b>	2 - 3 mils (51 - 76 microns) per coat <b>5-7 mils/125-175 microns total dry film thickness</b>
<b>Solids Content</b>	By Volume 56% +/- 2%
<b>Theoretical Coverage Rate</b>	898 ft <sup>2</sup> /gal at 1.0 mils (22.0 m <sup>2</sup> /l at 25 microns) 449 ft <sup>2</sup> /gal at 2.0 mils (11.0 m <sup>2</sup> /l at 50 microns) 299 ft <sup>2</sup> /gal at 3.0 mils (7.3 m <sup>2</sup> /l at 75 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 2.10 lbs/gal (255 g/l)
<b>Dry Temp. Resistance</b>	Continuous: 350°F (177°C) Non-Continuous: 450°F (232°C)

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	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.
<b>Steel</b>	Immersion: SSPC-SP 5/ NACE No.1 Surface Profile 2.0-3.0 mils (50-75 microns)
<b>Aluminum</b>	Consult Carboline Technical Service
<b>Special Instruction</b>	When Plasite 3073 is to be applied to a existing sulfuric acid vessel, it is recommended that the surface be flushed with PLASKLEEN-A. Contact Carboline Technical Service Department for specific details regarding PLASKLEEN-A

## PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	System	Results
Abrasion Resistance	2 coats 5-7 mils /125-175 microns	49 milligrams average loss per 1000 cycles, Taber CS-17 Wheel, 1000 gram weight
Surface Hardness	2 coats 5-7 mils/125-175 microns	Konig Pendulum Hardness of 170 seconds Glass Standard = 250 seconds); ASTM Method D4366-84
Thermal Shock	2 coats 5-7 mils/125-175 microns	Unaffected 5 cycles, minus 70°F/-56°C to plus 200°F/93°C

## MIXING & THINNING

**Mixing** | Plasite 3073 is formulated as a single package product for standard production spray equipment.

**Thinning** | If additional thinner is required, use up to 5% thinner #76. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

## 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: 30:1 (min)
- GPM Output: 2.5 (min)
- Material Hose: 3/8 I.D. (min)
- Tip Size: .015"-.019"
- Output: 1500-1800 PSI (103-124 bars)
- Filter Size: 60 mesh
- PTFE packings are recommended

**Apply a "mist" bonding pass. Allow to flash off for several minutes but not long enough to allow film to completely dry. Apply 3 to 4 wet mils (75-100 microns) using 2 to 3 crisscross multi-passes, maintaining a wet appearing film. This will dry to approximately 1.5- 2 mils (38-50 microns DFT). Repeat to achieve 2.5-3.5 mils (63-88 microns) DFT per coat.**

**Brush** | Recommended for striping of welds and touch up only. Use a natural bristle brush with full strokes, avoid rebrushing.

**Roller** | Not recommended

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	90°F (32°C)	100°F (38°C)	100°F (38°C)	80%

Substrate temperature should be 5°F (3°C) above the dew point

## CURING SCHEDULE

<b>Curing Details</b>	<p><b>1st INTERMEDIATE BAKE</b> : After application of first coat, ventilate with clean fresh air a minimum of 60 minutes prior to introducing heat. Increase heated air circulated throughout the tank, raising the substrate temperature a maximum of 40°F (23°C) per hour until intermediate bake substrate temperature of 225°F-250°F (107°-121°C) has been obtained, then hold for 30 minutes. To help ensure accurate metal temperature, readings should be taken in several areas of the tank to assure uniform heating. <b>Caution</b> : Over-baking will result in loss of adhesion between coats. Allow to cool prior to application of next coat.</p> <p><b>2nd INTERMEDIATE BAKE</b> : Repeat the above procedure after each separate coat.</p> <p><b>INSPECTION</b> : After final intermediate bake inspect lining for appearance, DFT, holidays and repair as necessary prior to final cure.</p> <p><b>FINAL CURE</b> : Raise tank temperature, approximately 40°F (23°C) per hour until 400°F (203°C) minimum steel temperature has been obtained. Hold temperature for 1 1/2 hours (90 minutes) minimum or until minimum cure color has been achieved.</p>
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## CLEANUP & SAFETY

<b>Cleanup</b>	Thinner #2, #76, or Acetone. In case of spillage, absorb and dispose of in accordance with local regulations.
<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 including personnel protection equipment.
<b>Ventilation</b>	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. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.
<b>Caution</b>	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, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	9 months at 70 °F (21 °C) . Higher temperatures will reduce shelf life.
<b>Storage Temperature &amp; Humidity</b>	Store all components between 50-75°F (10-24°C) in a dry area. Keep out of direct sunlight. Avoid excessive heat and do not freeze.
<b>Shipping Weight (Approximate)</b>	5 gallon Kit: 63 Lbs. (28.6 Kg.)

## WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.