

SELECTION & SPECIFICATION DATA

Generic Type	Modified Epoxy Amine adduct
Description	A high solids modified epoxy cured with an amine adduct curing agent. Designed specifically as a highly chemical-resistant, non-toxic, tank lining.
Features	<ul style="list-style-type: none"> • Excellent overall chemical resistance to a wide range of acids, alkalies and solvents • Very good abrasion resistance and flexibility • Complies with FDA 21 CFR 175.300 criteria for food contact
Color	U80P (White), U74P (Light Gray)
Primer	Self-priming
Dry Film Thickness	6 - 7 mils (152 - 178 microns) per coat Two coats will produce a 12-15 mils (300-375 microns) film for immersion service.
Solids Content	By Volume 80% +/- 2%
Theoretical Coverage Rate	1283 ft ² /gal at 1.0 mils (31.5 m ² /l at 25 microns) 214 ft ² /gal at 6.0 mils (5.2 m ² /l at 150 microns) 183 ft ² /gal at 7.0 mils (4.5 m ² /l at 175 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 1.37 lbs/gal (165 g/l) ± 2% VOC Content varies between colors. Contact Carboline Technical Service Department for VOC of specific colors.
Temperature Resistance (Immersion)	Dry film resistance is 400°F (204°C) for short periods: 250°F (121°C) continuous. Immersion temperatures depend on particular chemical service.

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	<u>Immersion</u> : SSPC-SP10 <u>Non-Immersion</u> : SSPC-SP6 <u>Surface Profile</u> : 2.0-3.0 mils (50-75 micron)
Concrete or CMU	Consult Carboline Technical Service.

PERFORMANCE DATA

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

Test Method	System	Results
*Abrasion Resistance (Taber CS-17 Wheel, 1000 gram weight, 1000 cycles)	Plasite 9060 12-15 mils (300-375 microns)	70 milligrams average loss
*Surface Hardness (ASTM Method D4366-84) König Pendulum (Glass Standard = 250 seconds)	Plasite 9060 12-15 mils (300-375 microns)	152 seconds
NACE TM 0174 method-B, testing @ 100°F (38°C)	Plasite 9060 12-15 mils (300-375 microns)	Gasoline OK Methyl ethyl ketone OK Methyl Alcohol OK
NACE TM 0174 method-B, testing @ 150°F (65.5°C)	Plasite 9060 12-15 mils (300-375 microns)	Ethyl Alcohol OK Ammonium Nitrate 65% OK Green Liquor Sulfate Process OK
NACE TM 0174 method-B, testing @ 180°F (82°C)	Plasite 9060 12-15 mils (300-375 microns)	Sodium Hydroxide OK Potassium Chloride 50% OK Fatty Acid OK
NACE TM 0174 method-B, testing @ 210°F (99°C)	Plasite 9060 12-15 mils (300-375 microns)	Crude Oil OK Ethylene Glycol 30% OK 1,1,1,Trichloroethane OK
Thermal Shock	Plasite 9060 12-15 mils (300-375 microns)	Unaffected 5 cycles, minus -70°F (-57°C) to plus 200°F (93°C)

***Note:** Above tests were conducted on film cured at 150°F (65.5°C).

CHEMICAL RESISTANCE

These tests were conducted on mild steel panels.

The panels are one-half immersed in the solution for the noted time with no effect to the coating.

Plasite 9060 can also be used for more aggressive exposures (acids) for intermittent (splash or fume) use. Consult Carboline Technical Service for your specific needs.

MIXING & THINNING

Mixing | Power mix coating separately, then add curing agent slowly and mix completely. DO NOT MIX PARTIAL KITS.

Thinning | Thinner #225 E is the preferred thinner. Thinners #246, or Plasite Thinner #71 may also be used as alternates depending on temperatures. The amounts required will vary depending upon air and surface temperatures and application equipment. Normal application temperatures and conditions will require approximately 5 to 10% by volume.

Ratio | 4:1 (A to B)

Pot Life | Approximately 1 hour at 70°F (21°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.

Spray Application (General) | All spray equipment should be thoroughly cleaned of contaminants.

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Conventional Spray	Pressure pot equipped with dual regulators, 3/8" (9.5 mm) I.D. minimum material hose, 0.055-0.070" (0.38-0.53mm) I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.) Output: 3.0 GPM (11.5 LPM) (min.) Material Hose: 3/8" (9.5 mm) I.D. (min.) Tip Size: .015-.021" (0.38-0.53mm) Output PSI: 2100-2300 (145-160 bar) Filter Size: 60 mesh PTFE packings are recommended and available from the pump manufacturer.
Brush	Not recommended for tank lining applications except when striping welds and touching up. Use short-nap solvent resistant roller. Use medium bristle brush.

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)	105°F (41°C)	105°F (41°C)	80%

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

CURING SCHEDULE

Surface Temp.	Dry to Recoat	Immersion Service (Most Chemical Service)
70°F (21°C)	12 Hours	7 Days
90°F (32°C)	9 Hours	5 Days
105°F (41°C)	6 Hours	4.5 Days

DRYING TIME

Surface will normally be tack-free in 10 to 12 hours at 70°F (21°C). Curing will take place in 5 days at 90°F (32.2°C) and 7 days at 70°F (21°C). For food grade service contact Carboline Tech Service for specific cure instructions.

RECOAT TIME

Must be topcoated within two weeks for metal temperature exposure to 130°F (54.4°C). For temperature exposure of 131-150°F (55-66°C), must be topcoated in a maximum of 24 hours.

CURING

Normally curing will take place in 5 days at 90°F (32.2°C) and 7 days at 70°F (21°C). This coating should not be applied when air temperature or temperature of surface to be coated is below 50°F (10°C).

Within 24 hours after coating is applied, a minimum substrate temperature of 70°F (21°C) is required for proper polymerization.

Force Cure Instructions:

An air-dry time of 2 to 5 hours at temperatures from 70°F (21°C) to 100°F (37.8°C) should be allowed before force curing. After the air dry period substrate temperature should be raised approximately 30°F (18°C) each 30 minutes until the desired force curing metal temperature is reached. Curing time begins when the specific substrate temperature is reached.

For Non-Food Grade services Force Cure Schedule, refer to the Plasite 9060 Application Guide or contact Carboline Technical Service.

For Food Grade Services, use the force cure schedule below:

CURING SCHEDULE

Surface Temp.	Final Bake
150°F (66°C)	12 Hours
175°F (79°C)	10 Hours
200°F (93°C)	6 Hours
225°F (107°C)	4 Hours

The above force cure schedule is for Food Grade Service

In order to ensure the complete removal of solvents and odor, force curing is **required** when coating is to be used in food related service.

Final cure may be checked by exposing coated surface to MIBK for ten minutes. If no dissolving and only minor softening of film occurs, the curing can be considered complete. The film should reharden after exposure if cured.

Epoxy may form an amine blush under some conditions. Blush must be removed before coating or placing in some services.

CLEANUP & SAFETY

Cleanup	Use Thinner #2, #71, #225 E, or #246. 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 SDS 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. 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.
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.

PACKAGING, HANDLING & STORAGE

Shelf Life	12 months at 70°F (21°). Film build drops upon aging.
Storage	Store indoors
Shipping Weight (Approximate)	1 gal unit: 13 lbs (6 kg) 5 gal unit: 67 lbs (30.4 kg)
Flash Point (Setaflash)	Part A: 24.8°F (-4°C) Part B: 24.8°F (-4°C)

WARRANTY

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