

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Low temperature epoxy phenolic
<b>Description</b>	A low temperature bake, high solids, epoxy phenolic cured with an amine curing agent.
<b>Features</b>	Excellent resistance to caustic solution
<b>Color</b>	White and Light Gray
<b>Finish</b>	Gloss
<b>Dry Film Thickness</b>	6 - 7 mils (152 - 178 microns) per one multi-pass spray coat
<b>Typical Uses</b>	As a highly resistant tank lining for many caustic solutions up to 180 °F (82 °C).
<b>Solids Content</b>	By Volume 81% +/- 2%
<b>Theoretical Coverage Rate</b>	1298 ft <sup>2</sup> /gal at 1.0 mils (31.8 m <sup>2</sup> /l at 25 microns) 216 ft <sup>2</sup> /gal at 6.0 mils (5.3 m <sup>2</sup> /l at 150 microns) 185 ft <sup>2</sup> /gal at 7.0 mils (4.5 m <sup>2</sup> /l at 175 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 1.35 lbs./gal (162 g/l) Plasite Thinner #98 : 10%: 2.3 lbs/gal (275 g/l)
<b>Dry Temp. Resistance</b>	Continuous: 300°F (149°C)
<b>Chemical Resistance Tables</b>	At 150 °F (66 °C) Potassium Hydroxide, 50% Sodium Hydroxide, 10% Sodium Hydroxide, 50% Sodium Hydroxide, 73%
<b>Temperature Resistance (Immersion)</b>	Depends on particular reagent

## 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-SP10 Non-Immersion: SSPC-SP6 Surface Profile: 2.0-3.0 mils (50-75 micron)
<b>Aluminum</b>	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 747 LTS and Oakite Cryscoat Ultraseal produced by Oakite Products.

## PERFORMANCE DATA

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

Test Method	Results
Abrasion Resistance (ASTM D4060, CS-17 wheel)	42mg
Surface Hardness (ASTM D4366-84)	165 seconds
Thermal Shock	Unaffected after 5 cycles from minus 70-200+ °F (-57-93 °C)

## MIXING & THINNING

**Mixing** | The curing agent and coating are supplied in separate containers at a 4:1 ratio. Thoroughly mix coating, then add curing agent slowly and mix completely with coating.

**Thinning** | Plasite Thinner 98 is recommended for thinning. 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 to 20% thinner by volume with approximately 5% additional thinner added for each 5 °F (3 °C) of increased temperature.  
 It is recommended that the amount of thinner included on each order amount to approximately 20% of the coating order.

**Ratio** | 4:1 by volume

**Pot Life** | 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.

**General** | Before mixing and applying any material, make sure environmental conditions are satisfactory for application. Weather conditions, especially dew point, should be constantly monitored in light of the work being done.  
 Final blast cleaning and application of the lining system must only be performed when it is clear that the temperature of the steel substrate will not fall within 5 °F (3 °C) of the dew point. Dehumidification and/or temperature control may be necessary to meet this requirement. Use a surface thermometer to frequently monitor the temperature of the steel substrate.

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<b>Spray Application (General)</b>	<p>All spray equipment should be thoroughly cleaned and the hose, in particular, should be free of old paint film and other contaminants. Apply a "mist" bonding pass. Allow to dry approximately 1 minute, but not long enough to allow the film to completely dry. Apply crisscross multi-passes, moving gun at a 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 (100-125 microns) wet film thickness. By allowing the solvents to flashoff a few minutes, several more fast multi-passes may be applied until you have a film thickness of approximately 5-7 mils (125-175 microns) DFT (approximately 8-10 wet mils[200-250 microns]). Repeat this procedure for the second coat to obtain a 12-15 mil.(300-375 microns) DFT. Overcoat time will vary both with temperature and ventilation and will require from 16 to 24 hours at 70-90 °F (21-32 °C) for enclosed spaces. Refer to Curing Schedule. Remove all overspray by dry brushing or scraping if required.</p> <p>Note: Prior to spray application, stripe brush all welds, attachments and surface irregularities using Plasite 9571 thinned a minimum of 50% by volume with Plasite Thinner 98.</p>
<b>Airless Spray</b>	<p>Tip Size: 0.017-0.021 in (0.43-0.53 mm) Output Pressure: 1,500-1,800 psi (10.3-12.4 MPa) recommended Air supply shall be uncontaminated. Adjust air pressure to approximately 60-80 lbs. (0.414-0.552 MPa) at the gun and provide 30-35 lbs. (0.200-0.240 MPa) of pot pressure. Adjust the spray gun first by opening the liquid valve and then adjusting the air valve to give an 8-12 in. (20-30 cm) wide spray pattern with the best possible atomization.</p> <p>Thinning requirements are more than for conventional spray.</p>
<b>Spray Gun</b>	<ul style="list-style-type: none"> <li>• DeVilbiss JGA-510, E Fluid Tip, 797 Air Cap</li> <li>• Binks #2001, 66-SS Fluid Tip, 63-PB Air Cap</li> <li>• Graco P800, 04 Fluid Tip, 02 Air Cap</li> </ul>
<b>Brush</b>	<p>Normally not recommended except for touch-up, repairs or at weld areas prior to spraying.</p>

## CURING SCHEDULE

Surface Temp.	Final Cure	Tack Free
70°F (21°C)	NR	24 Hours
90°F (32°C)	NR	16 Hours
200°F (93°C)	4 Hours	NR

Drying time between coats may be decreased by force curing.

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 (17 °C) in increments of 30 minutes until the desired temperature is reached.

The final bake is based on metal temperatures and coating on 18 gauge steel.

**Caution:** Overbaking between coats will result in loss of adhesion.

<b>Force Cure</b>	<p>Do not force cure at temperatures in excess of 150 °F (66 °C). When force curing at temperature between 120-150 °F (49-66 °C), the length of cure must not exceed 12 hours.</p> <p><b>Caution:</b> Overbaking between coats will result in loss of adhesion.</p>
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## CLEANUP & SAFETY

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<b>Cleanup</b>	Equipment must be thoroughly cleaned immediately after use with Plasite Thinner 71 to prevent the setting of the coating.
<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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<b>Packaging</b>	<u>1 Gallon Unit:</u> 1 - 1 gallon can of Part A (partially filled) 1 - 1 quart can of Part B (partially filled) <u>5 Gallon Unit:</u> 1 - 5 gallon pail of Part A (partially filled) 1 - 1 gallon can of Part B (partially filled)
<b>Shelf Life</b>	Part A: 12 months at 70 °F (21 °C) Part B: 24 months at 70 °F (21 °C)
<b>Shipping Weight (Approximate)</b>	1 Gallon Unit: 13 lbs (49.2 liters) 5 Gallon Unit: 65 lbs (246 liters)
<b>Flash Point (Setaflash)</b>	Part A & Part B: 41 °F (5 °C)

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## WARRANTY

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