

SELECTION & SPECIFICATION DATA

Generic Type	Trowel applied vinyl ester lining
Description	A high-performance, highly chemical resistant lining that uses several layers of thermosetting, filled vinyl ester resin to build up protection on metal and concrete. It is well suited for chemical manufacturing or processing operations. Blended with different fillers and used as a component of a system with woven roving, the separate elements lose their individual identity and become a single, monolithic lining.
Features	<ul style="list-style-type: none"> • Exceptional resistance to inorganic and organic acids • Excellent caustic and alkaline solution resistance • Excellent abrasion resistance and hardness • FDA compliant • Low permeability
Typical Uses	<ul style="list-style-type: none"> • Plating room floors • Food processing • Concentrated acid spills • Acid neutralization • Caustic handling areas
Color	Clear (0000)
Primer	Primer 27 series
Application Thickness	When blended with the appropriate filler, mortar will yield a minimum thickness of 1/16".
Solids Content	By Volume 74%
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C)
Chemical Resistance	<ul style="list-style-type: none"> • Inorganic Acids • Organic Acids • Alkali Solutions • Oils • Salts
Application	For maximum performance, all metal surfaces should be primed. Concrete must be primed to aid in the "wetting out" required for good bonding.

Protecto-Line 800

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Concrete

Concrete must be mechanically prepared to remove surface laitance. Oils, grease or other contaminant must be removed prior to surface preparation. Concrete must be free of curing compounds and form release agents. Surface texture should be similar to 40-60-grit sandpaper or the visual standard, CSP-5 or higher from the International Concrete Repair Institute with exposed pea gravel. The prepared surface should have a nominal tensile strength of 250 PSI per ASTM D4541.

All concrete substrates must be checked for moisture prior to product application using the Plastic Sheet Test, ASTM D4263.

Additional surface preparation will be required if a 40-60 grit texture with exposed pea gravel is not achieved and the surface laitance not completely removed with the first mechanical preparation procedure.

Ferrous Metal

Primer 27 is recommended to be used to promote better adhesion or as a holding primer in immersion service.

Immersion and heavy spillage service: White Metal, SSPC SP 5 or NACE No.1, minimum 3.0 mil profile.

Heavy non-immersion service (i.e. fumes and spillage): Near white, SSPC SP 10 or NACE No.2, minimum 2.0 mil profile.

Atmospheric service: Commercial SSPC SP 6 or NACE No.3, minimum 2.0 mil profile

Non-Ferrous Metals

Must be primed with Primer 27 for immersion service.

Prepare by abrasive blasting to SSPC-SP 17 Thorough Abrasive Blast to a minimum of 3 mils (75 microns) dense angular anchor profile.

PERFORMANCE DATA

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

Test Method	Results
Coefficient of Expansion ASTM C531	12-15 x 10 ⁻⁶ in./in./°F
Compressive Strength ASTM C579	12,500 PSI
Flame Spread ASTM D635	<5 mm
Flexural Strength ASTM C580	8,600 PSI
Shore D Hardness ASTM D2240	85-90
Taber Abrasion, CS-17 wheel, 1000 cycles, 1000 gram load ASTM D4060	40 mg. (G-1), 20 mg. (AR)
Tensile Bond Strength ASTM D7234	Cohesive failure of concrete
Tensile Strength ASTM C307	2,400 PSI
Tensile Strength ASTM D638	3,400 PSI
WVT ASTM E96	0.0017 perm. in.

Tested as a full system.

MIXING & THINNING

Mixing	<p>Add the correct amount of PH- 1 Hardener to the Part A. Mix thoroughly for 2-3 minutes.</p> <p>For Protecto-Line 800: Add 18-25 lbs. of G-1 Filler/gal. Mix well and apply a 1/16" thick basecoat, using a plasterer's trowel.</p> <p>For Protecto-Line 805: Add 10-15 lbs. of G-9 Carbon Filler/gallon. Mix well and apply a 1/16" thick basecoat, using a plasterer's trowel.</p> <p>For Protecto-Line 800AR: Add 25-30 lbs. of AR Filler/gallon. Mix well and apply a 1/16" thick basecoat, using a plasterer's trowel.</p>
Ratio	<p>Protecto-Line 800 and 800AR PH-1 Hardener Ratio: 3-3.5 oz/gal of PH-1 @ 60°F-70°F (15°C-21°C) 2-3 oz/gal of PH-1 @ 70°F-90°F (21°C-32°C)</p>
Pot Life	<p>60 minutes @ 50°F (10°C) 40 minutes @ 75°F (21°C) 25 minutes @ 90°F (32°C)</p>

APPLICATION PROCEDURES

Trowel	<p>After mixing the Part A, Part B, and the appropriate filler per the mixing instructions, apply approximately 1/16" (~60 mils) thick basecoat to a smooth, even finish using a trowel.</p> <p>—</p> <p>Adding reinforcement and saturant: Before the basecoat begins to cure, press one layer of woven fiberglass roving mat into the wet basecoat. Overlap all edges by 1 inch. Use a stiff, natural bristle brush or short nap roller and press the mat firmly into the basecoat, using a technique similar to hanging wallpaper, to remove all air pockets and wrinkles. Saturate the reinforcement by mixing Part A and B only, do not add the filler, to make a neat resin mixture. Using a short nap roller, roll vigorously until the mat has lost its white color and turns translucent, paying special attention to overlaps and corners. Use enough resin to wet out the mat, but do not allow the saturant to puddle. If needed, roll the wet reinforcement with a ribbed roller to remove any trapped air or wrinkles. Allow the basecoat and reinforcement application to dry.</p> <p>—</p> <p>Topcoat Application: Before applying the topcoat, the troweled basecoat, woven fiberglass roving, and saturant layers must dry thoroughly to allow for the surface to be ground to provide profile for successive coats and remove any high spots or protrusions. Grinding must draw dust. Use caution not to grind through the reinforcing layer, then solvent wipe the entire surface. Examine the reinforcement for any air bubbles or blisters. If these are present, they must be cut out and repaired, using the procedure above. Rough overlaps and protruding reinforcement strands must be abraded and smoothed. The topcoat will emphasize any imperfections in the reinforcement. Excessive blistering of the basecoat reinforcement may indicate inadequate rolling or too little saturant. Apply the topcoat at approximately 1/16" (~60 mils). Immediately after the trowel application and before the topcoat has cured, dampen a natural bristle brush (thick bristle 4" wide) or roller with S-30 Smoothing Liquid. Lightly brush or roll the wet topcoat to remove trowel marks and pinholes. Never allow S-30 Smoothing Liquid to puddle on the topcoat.</p>
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PRODUCT DATA SHEET



APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	60°F (16°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	80°F (27°C)	110°F (43°C)	110°F (43°C)	90%

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

CURING SCHEDULE

Surface Temp.	Minimum Recoat Time	Chemical Service	Maximum Recoat Time
50°F (10°C)	12 Hours	4 Days	5 Days
75°F (24°C)	4 Hours	24 Hours	4 Days
90°F (32°C)	3 Hours	20 Hours	3 Days

CLEANUP & SAFETY

Cleanup | Use S-10 Cleaning Solvent or Carboline Thinner 2 to clean tools and equipment.

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

Ventilation | Ventilation 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. Use MSHA/NIOSH approved air respirators as needed.

Caution | Fire and explosion hazards: This product contains less than 1% volatile components, however, vapors are heavier than air and can travel long distances, ignite and flash back. Eliminate all Ignitions sources. 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, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Packaging | **1 Gallon Kits:**
Part A: 0.99 Gallons (in a 3.5 gal pail)
PH-1 Hardener: 4 oz (in a plastic bottle)

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5 Gallon Kits:
Part A: 4.96 Gallons (in a 5 gal pail)
PH-1 Hardener: 16 oz (in a plastic bottle)

G-1 Filler, G-9 Filler and AR Filler are sold separately in 50 lbs bags.

Shelf Life | Part A: 3 months
PH-1 Hardener: 6 months
G-1 Filler, G-9 Filler, AR Filler: 36 months

Material can not be returned after purchase.

PACKAGING, HANDLING & STORAGE

Storage	All Dudick products classified by DOT with either white, yellow or red labels must not be mixed or stored together as an explosive reaction can occur.
	All products should be stored in a cool, dry area, away from open flames, sparks, or other hazards.

Shipping Weight (Approximate)	1 gallon kit: 12.1 lbs 5 gallon kit: 47 lbs
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WARRANTY

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