

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy Phenolic
Description	A cross linked epoxy-phenolic cured with a polyamine curing agent. Formulated with particular attention to wide chemical resistance and ease of handling. Plasite 7122 VOC is used as a tank lining and for industrial maintenance.
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 21CFR 175.300 criteria for food contact
Color	Standard; White (U80P), and Light Blue (U11P). Note: Non-standard colors may not meet FDA requirements; consult Carboline Technical Service Department.
Gloss	Semi-Gloss
Dry Film Thickness	6 - 7 mils (152 - 178 microns) per coat Two multi-pass spray coats will produce a 12-15 mil/300-375 microns DFT film recommended for immersion service.
Solids Content	By Volume 75% +/- 2%
Theoretical Coverage Rate	1203 ft ² /gal at 1.0 mils (29.5 m ² /l at 25 microns) 200 ft ² /gal at 6.0 mils (4.9 m ² /l at 150 microns) 172 ft ² /gal at 7.0 mils (4.2 m ² /l at 175 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 1.76 lbs/gal (212 g/l)
Dry Temp. Resistance	Continuous: 300°F (149°C) Non-Continuous: 350°F (177°C) Immersion temperature depend on particular reagent. Epoxies lose gloss, discolor and eventually chalk in sunlight exposure.

SUBSTRATES & SURFACE PREPARATION

General	<ul style="list-style-type: none"> • 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	<ul style="list-style-type: none"> • Immersion: SSPC-SP10 • Non-Immersion: SSPC-SP6 • Surface Profile: 2.0-3.0 mils (50-75 micron)
Galvanized Steel	Consult Carboline Technical Service.
Concrete or CMU	Consult Carboline for use over concrete surfaces.

Plasite[®] 7122 VOC

PRODUCT DATA SHEET



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)	Two Coats	77 milligrams
Surface Hardness (ASTM Method D4366-84) König Pendulum (Glass Standard = 250 seconds)	Two Coats	135 seconds
Thermal Shock	Two Coats	Unaffected 5 cycles minus 70°F/21°C to plus 200°F/93°C.

CHEMICAL RESISTANCE: Specific information regarding the chemical resistance can be obtained by contacting Carboline's Technical Service Department.

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS. The coating should stand approximately 45 minutes after the curing agent has been thoroughly mixed.
Thinning	Thin as needed up to 20% with Plasite Thinner 71. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	<u>1 gallon (3.79 litres) kit:</u> 0.88 gallons (3.34 litres) of part A 0.12 gallons (0.44 litres) of part B <u>5 gallon (18.93 litres) kit:</u> 4.42 gallons (16.72 litres) of part A 0.58 gallons (2.21 litres) of part B
Pot Life	4-6 hours 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)	It is recommended to apply a "mist" bonding pass. Allow this to dry approximately one minute, but not long enough to allow film to completely dry. All future passes should be applied in a crisscross pattern and maintaining a wet appearing film. Repeat this procedure for the second coat to obtain the recommended dry film thickness.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.055-0.070" I.D. fluid tip and appropriate air cap.

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Airless Spray	Pump Ratio: 30:1 (min.) GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.015-0.021" Output PSI: 2100-2300 Filter Size: 60 mesh PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	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)	90°F (32°C)	90°F (32°C)	80%

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

CURING SCHEDULE

Surface Temp.	Dry to Recoat	Maximum Recoat Time	Cure for Service
70°F (21°C)	10 Hours	14 Days	7 Days
90°F (32°C)	5 Hours	7 Days	4 Days

Surface will normally be tack-free in 4-6 hours at 70°F (21°C).

Ambient Cure	Normal polymerization and curing will take place in 7 days at 70°F (21°C). This coating should not be applied when air or the surface temperature is below 50°F (10°C). A minimum substrate temperature of 70°F (21°C) is required for proper polymerization within 24 hours after the final coat is applied. This product should be force cured for all taste sensitive immersion services.
Force Cure	Force curing at elevated temperatures will increase resistance to certain exposures; therefore, when exposure is severe, force curing is recommended to obtain maximum resistance and service life. Allow an air dry time of 2-5 hours at temperatures from 70-100°F (21-37°C) before heat curing. After air drying, the substrate temperature should be raised by approximately 30°F (18°C) each 30 minutes until the desired force curing temperatures are reached. Final cure may be checked by exposing coated surface to MIBK for 10 minutes. If no dissolving and only minor softening of film occurs, the curing can be considered complete. The film should reharder after exposure if cured. Product should be force cured for all taste sensitive immersion services at any of the following substrate temperatures: 12 hours at 150°F (66°C) 6 hours at 175°F (79°C) 4 hours at 200°F (93°C)

CLEANUP & SAFETY

Cleanup	Use Thinner 2, 71, or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
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CLEANUP & SAFETY

Safety	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.
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. 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

Shelf Life	Part A - 6 months Part B - 24 months @ 70°F (21°C)
Storage Temperature & Humidity	Store all components between 50-90°F (10-32°C) in a dry area. Keep out of direct sunlight. Avoid excessive heat and do not freeze.
Shipping Weight (Approximate)	5 gallon Kit: 65 Lbs. (29.5 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.