

SELECTION & SPECIFICATION DATA

Generic Type	Advanced Baked Phenolic
Description	<p>A baked on coating using a phenolic resin (baked, unmodified) with superior resistance to sulfuric acid and solvents. Conforms to most VOC regulations. A lining for tanks containing solvent, concentrated sulfuric acid, hot water, and as a protective coating for machinery parts, filter press plates, fans, etc.</p> <p>Note: Prior to lining a used sulfuric acid tank or tank car, please refer to Surface Preparation - Steel section. DO NOT USE FOR DIRECT CONTACT WITH FOOD.</p>
Features	<ul style="list-style-type: none"> • Widely accepted polymer with successful history • VOC compliant • Improves productivity with lower bake temperature • Same familiar application as Plasite 3070 L • Batch mix ease
Color	Buff.
Dry Film Thickness	<p>5 - 7 mils (127 - 178 microns) total</p> <p>2 or 3 coats will produce the recommended dry film thickness of 5 to 7 mils (125-175 microns).</p>
Solids Content	By Volume 42% +/- 2%
Theoretical Coverage Rates	96 square feet per gal. at 7 mils DFT
Theoretical Coverage Rate	<p>667 ft²/gal at 1.0 mils (16.4 m²/l at 25 microns) 133 ft²/gal at 5.0 mils (3.3 m²/l at 125 microns) 95 ft²/gal at 7.0 mils (2.3 m²/l at 175 microns) Allow for loss in mixing and application.</p>
VOC Values	As Supplied : 3.17 lbs/gal (378 g/l)

SUBSTRATES & SURFACE PREPARATION

General	<p>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. Consult separate Carboline Application Specification for this product.</p>
Steel	<p>Immersion: SSPC-SP5 Non-Immersion: SSPC-SP10 Surface Profile: 1.5-2 mils (40-90 micron)</p> <p>When used to line a used sulfuric acid tank flush the surface with Plaskleen-A prior to abrasive blasting.</p>

Plasite 3070 LB

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)	Plasite 3070 LB	47.8 milligrams average loss per 1000 cycles
ASTM Method D4366-84 Surface Hardness	Plasite 3070 LB	Konig Pendulum Hardness of 169 seconds a Glass Standard = 250 seconds)
Gloss	Plasite 3070 LB	Low
Pigments	Plasite 3070 LB	Titanium dioxide and inert pigments
Thermal Shock	Plasite 3070 LB	Unaffected 5 cycles, minus 70 °F to plus 200 °F

CHEMICAL RESISTANCE

Plasite 3070 LB is formulated to line steel tanks containing concentrated sulfuric acid, solvents and a variety of chemicals and only requires a 250 F final bake temperature. For alcohol immersion raise bake temperature to 300F and hold for 4 hours. Contact Carboline Technical Service for specific lining cargo recommendations.

MIXING & THINNING

Mixing | Mix until uniform.

Thinning | Complying with local VOC regulations may require application without additional thinner. If addition of thinner is required, Plasite Thinner #68 or #71 are recommended.

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 | The following spray equipment has been found suitable and is available from manufacturers.

Airless Spray | Output: 1500 to 1800 psi
Tip size: 0.015" to 0.019"

APPLICATION PROCEDURES

General | All spray equipment shall be thoroughly cleaned and the hose, in particular, shall be free of old paint film and other contaminants.

Airless Spray | Experienced applicators may elect to apply the Plasite 3070 LB to the recommended 5 to 7 mil (125 to 175 microns) DFT in two multi-pass spray coats. The following application procedure describes the application of Plasite 3070 LB in three multi-pass spray coats.
Apply a "mist" bonding pass.
Allow to flash off for several minutes but not long enough to allow film to completely dry.
Apply 2 to 3 crisscross multi-passes maintaining a wet appearing film (approximately 3 to 4 wet mils/75 to 100 microns). This will dry to approximately 1.5 to 2 dry mils (38 to 50 microns).
See curing procedures for air dry and heat curing details before applying additional coats of material.

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

- Curing Details**
- Air dry with ventilation between 70°F and 110°F for 30 minutes prior to heat curing.
 - After the air-dry time has elapsed, slowly increase the substrate temperature at a rate of one half degree F per minute until the intermediate baking temperature of 200°F has been reached. Hold for 30 minutes then allow to cool.
 - After the substrate has cooled down to a good application temperature, prepare lining for succeeding coats.
 - Repeat the above for each separate coat and intermediate bake.
 - After second coat intermediate bake, check coating for DFT and holidays. Repair as needed. Apply third coat.
 - Final bake at 250°F (121°C), raise surface temperature by one degree F per minute until 250 F is attained then hold for 4 hours.

Confirm cure with 50 MEK double rubs - (no color pick-up). Check heat sink areas which may not have reached 250 F.

See detailed application and curing instructions. The temperatures and procedures for intermediate and final bake are unique to Plasite 3070 LB.

CLEANUP & SAFETY

- Cleanup** | Use Plasite Thinner #71. 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. Keep container closed when not in use.
- Ventilation** | When used in enclosed areas and product is thinned, 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 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, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

- Shelf Life** | 90 days from date of shipment at 70 °F (21 °C). Ship date is posted on the container lids.
Note: Warmer storage temperatures will reduce shelf life.
- Storage Temperature & Humidity** | Store all components between 50-75 °F (10-24 °C)

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PACKAGING, HANDLING & STORAGE

Storage | Store all components in a dry area. Keep out of direct sunlight.

Shipping Weight (Approximate) | 1 gallon - 12 lbs (5 kg)
5 gal. - 60 lbs (25 kg)

Flash Point (Setaflash) | 91 °F (33 °C)

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.