

SELECTION & SPECIFICATION DATA

Generic Type	Finish Coat for Vinyl Ester Lining
Description	An optional pigmented gel coat that can be applied to the cured Protecto-Flake 800 lining to provide a very smooth surface sometimes required to prevent the vessel contents from adhering. It also provides an added measure of protection from product contamination.
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"> • Food processing vessels • Acid neutralization • Caustic handling tanks
Color	Medium Grey (0766), White (0800)
Primer	Protecto-Flake 800 System
Dry Film Thickness	8 - 12 mils (203 - 305 microns) DFT
Solids Content	By Volume 80%
Theoretical Coverage Rate	1283 ft ² /gal at 1.0 mils (31.5 m ² /l at 25 microns) 160 ft ² /gal at 8.0 mils (3.9 m ² /l at 200 microns) 107 ft ² /gal at 12.0 mils (2.6 m ² /l at 300 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 87 g/L
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

SUBSTRATES & SURFACE PREPARATION

Metal | Refer to Protecto-Flake 800 PDS.

MIXING & THINNING

Mixing	Add the correct amount of PH-1 Hardener to the Part A. Mix thoroughly for 2-3 minutes.
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)
Pot Life	60 minutes @ 50°F (10°C) 40 minutes @ 75°F (21°C) 25 minutes @ 90°F (32°C)

Gelcoat 800

PRODUCT DATA SHEET



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.

Airless Spray	<ul style="list-style-type: none">• Pump Ratio: 45:1 or greater, capable of at least 1 GPM. Hopper or siphon feed is preferred.• Filters: Ensure all filters are removed.• Material Hose: 1/2" I.D. (min.), 4500 psi or greater rated.• Tip Size: 0.25-0.31"• Output PSI: 3000-3500 psi (min.)• Gun: Airless gun rated for at least 4500 psi. Filter-free or front-fed gun is preferred
	PTFE packings are recommended and available from the pump manufacturer. When siphon feed is used, change the pail out as frequent as necessary to avoid exotherm of the catalyzed material.
Brush & Roller (General)	Brush or roller application may require additional coats to meet the specified dry film thickness.

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	2 Days	4 Days
90°F (32°C)	3 Hours	24 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 ignition 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	5 Gallon Kits: Part A: 4.85 Gallons (in a 5 gal pail) PH-1 Hardener: 18 oz (in a plastic bottle)
Shelf Life	6 months, when properly stored in original, unopened containers at 50°F-75°F (10°C-24°C). Exposure to heat in excess of this temperature may cause premature gelling, reduced working time and shortened shelf life. Material can not be returned after purchase.
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)	5 gallon kit: 49.5 lbs (22.5 kg)

WARRANTY

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