

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Epoxy Phenolic
<b>Designation</b>	<p><b>This is a Carboline Specialty Product</b></p> <p>Minimum order quantities and special pricing will apply in North America. Contact your Carboline Sales Representative for more details.</p>
<b>Description</b>	Cross-linked epoxy-phenolic cured with an alkaline curing agent, formulated with a wide range of chemical resistance and ease of handling. Plasite 2310 is a two-coat system whereby the final coat is heated to 180°F (82°C) to complete the final cure.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Outstanding for caustic service</li> <li>• Good chemical resistance to solvents, acids and alkalis</li> <li>• Excellent flow and leveling</li> </ul>
<b>Color</b>	Grey 0700, white 0800
<b>Finish</b>	High Gloss
<b>Primer</b>	Self-priming
<b>Dry Film Thickness</b>	<p>6 - 7 mils (152 - 178 microns) per coat</p> <p>Two coats recommended</p>
<b>Solids Content</b>	By Volume 66% +/- 1%
<b>Theoretical Coverage Rate</b>	<p>1059 ft²/gal at 1.0 mils (26.0 m²/l at 25 microns)</p> <p>176 ft²/gal at 6.0 mils (4.3 m²/l at 150 microns)</p> <p>151 ft²/gal at 7.0 mils (3.7 m²/l at 175 microns)</p> <p>Allow for loss in mixing and application.</p>
<b>VOC Values</b>	<b>As Supplied</b> : 2.38 lbs/gal; 283 g/l
<b>Dry Temp. Resistance</b>	<p>Continuous: 225°F (107°C)</p> <p>Discoloration of epoxies at elevated temperatures is normal, but does not affect performance.</p>

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	<p>Prebake: Remove oil and grease (if present) by pre-baking at 450°F metal temperature for a minimum of two hours.</p> <p>Remove all oil or grease from the surface to be coated with clean rags soaked in Thinner 2 or Carboline Surface Cleaner 3 (refer to Surface Cleaner 3 instructions) in accordance with SSPC-SP1. For welds prepare per NACE RP0178-89, Weld Prep Designation C.</p>
<b>Steel</b>	<p><b>Immersion Service:</b></p> <p>Degrease surface prior to abrasive blasting. Organic solvents, alkaline solutions, steam, hot water with detergents or other systems that will completely remove dirt, oil, grease, etc. may be used. Pre-baking of used tanks is required. Additional decontamination may also be necessary.</p> <p>Cleanliness: SSPC SP-5/NACE No. 1 white metal blast grade.</p> <p>Profile: 2.4 mils minimum</p>

## SUBSTRATES & SURFACE PREPARATION

<b>Aluminum</b>	Surface shall be clean and grease free with a blast profile as described above. 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 Inc. OAKITE CRYSCOAT 747LTS and OAKITE CRYSCOAT ULTRASEAL - produced by Oakite Products
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## MIXING & THINNING

<b>Mixing</b>	Thoroughly agitate base portion to obtain smooth, homogeneous condition. Then mix 4 parts of Part A with 1 part of Part B. Allow ten minutes of induction time at 70°F (21°C).
<b>Ratio</b>	4:1 by volume (Part A to Part B)
<b>Pot Life</b>	2 hours @ 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.

<b>Spray Application (General)</b>	Product is formulated for standard production spray equipment. All spray equipment shall be thoroughly cleaned and the hoses shall be free of old paint film and other contaminants. The following spray equipment has been found suitable.
<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.070" I.D. fluid tip and appropriate air cap. Adjust air pressure to approximately 50 psi at the gun and provide 10-20 lbs. of pot pressure.
<b>Airless Spray</b>	Pump Ratio: 30:1 (min.)* GPM Output: 2.5 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.015"-0.019" Output PSI: 1500-2800 Filter Size: 60 mesh *PTFE packings are recommended  <b>Apply a "mist" bonding pass.</b> Allow to dry approximately one minute but not long enough to allow film to completely dry. Apply crisscross multi-passes, moving gun at fairly rapid rate, maintaining a wet appearing film. Fast multi-passes may be applied until you have achieved the appropriate wet film thickness (approximately 10-12 wet mil/250-300 microns). Repeat this procedure for the second coat.
<b>Brush</b>	Brush application should only be used for striping. Thin by 50% with Thinner 76. Stripe all areas where vertical and horizontal surfaces meet, edges, corners, seams and previously corroded areas. Wet the surface well and assure there are no runs or sags. Allow the material to dry for 10-20 minutes before applying a full primer coat.

## 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%

This product requires the substrate temperature to be 5°F (3°C) above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

## CURING SCHEDULE

<b>Force Cure</b>	Ventilate at 70°F (21°C) for two hours to exhaust solvent vapors from tank if repairs were made. If no repairs were made ramp up set point to 180°F (82°C) raising temperature 30 degrees over 30 minutes. Heat at 180°F (82°C) metal temperature for 6 hours and then cool to ambient temperature.
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## CLEANUP & SAFETY

<b>Cleanup</b>	Thinner #76
<b>Safety</b>	Read and follow all caution statements on this product data sheet and on the SDS for this product. Wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
<b>Ventilation</b>	When used 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 respirator.

## PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	Part A: 6 months Part B: 12 months
<b>Storage Temperature &amp; Humidity</b>	40° -110°F (4°-43°C) 0-100% Relative Humidity  Store indoors
<b>Shipping Weight (Approximate)</b>	Approximately 13 lbs/gal (NEED THIS)
<b>Flash Point (Setaflash)</b>	>200°F

## **WARRANTY**

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