

SELECTION & SPECIFICATION DATA

Generic Type	A glass flake filled epoxy-novolac with amine curative.
Description	A dense cross-linked polymer which exhibits outstanding barrier protection against a variety of chemical exposures. Glass flake filled to provide excellent abrasion resistance, permeation resistance, and internal reinforcement
Features	<ul style="list-style-type: none"> • Excellent resistance to 232°C dry heat • Excellent resistance to deionised water up to 93°C • Excellent resistance to crude oil up to 82°C • Excellent abrasion resistance • Excellent overall chemical resistance • Excellent thermal shock resistance • May be used to line tanks or pipes in process facilities, where hot water solutions or abrasive conditions exist • Excellent as secondary containment lining for a variety of chemicals • As a one or two coat external system for pipes and tanks that will be insulated.
Color	White and Light Grey
Gloss	Low
Recommended Thickness	200 Microns per coat Two coats recommended for 400 microns total DFT.
Solid(s) Content	By Volume: 70% ± 2%
Theoretical Coverage Rates	3.5 m ² /l at 200 microns Mixing and application losses will vary and must be taken into consideration when estimating job requirements.
VOC Value(s)	As supplied: 255gm/l Thinned 10% with Phenoline Thinner: 307gm/l
Dry Temp. Resistance	Continuous: 218°C (424°F) Non-Continuous: 232°C (450°F) Metal tanks should be insulated if temperature exceeds 60°C. Coating discolouration may occur above 93°C
Substrates & Compatible Coatings	Apply over properly prepared steel or concrete. Normally applied directly to substrate. Consult StonCor Africa Technical Service Department for specific recommendations.

SUBSTRATES & SURFACE PREPARATION

General	Remove any oil or grease from surface to be coated prior to abrasive blast cleaning.
Steel	<p>Immersion Service: Abrasive blast to a White Metal Finish in accordance with ISO 8501 Sa3 to obtain a 50-75 micron blast profile. Weld slag must be removed and welds ground to a rounded contour. Striping of properly prepared welds with Phenoline 1205 by brush or spray is recommended prior to full coat application.</p> <p>Non-immersion Service: Abrasive blast to a near white metal finish in accordance with ISO 8502 Sa2½ to obtain a 50-75 micron blast profile.</p>

Phenoline 1205

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SUBSTRATES & SURFACE PREPARATION

Concrete | Remove fins and other protrusions by stoning, sanding or grinding. Concrete must be cured at least 28 days at 25°C and 50% R.H., or equivalent time. Remove form oils, incompatible curing agents and hardeners by abrasive blasting.

Immersion Service | Abrasive blast to open all surface voids and obtain a surface similar to medium grit sandpaper. Voids in the concrete may require surfacing with appropriate surfacer prior to application of the system.
Non-immersion Service: Horizontal surfaces must be abrasive blasted to remove laitance.

MIXING & THINNING

Mixing | Mix separately, then combine in the following proportions. Allow 30 minutes induction time at 25°C:
Part A: 4 Litre
Part B: 1 Litre

Thinning | Thin up to 15% with Phenoline Thinner.
Refer to Specification Data for VOC information.
NOTE: Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether expressed or implied.

Pot Life | 3 hours at 25°C and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

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.

Conventional Spray | Pressure pot equipped with dual regulators, 12mm minimum I.D. material hose, 1.8 to 2.0mm I.D. fluid tip and appropriate air cap, at 1,5 to 2,0 bar max pot pressure.

Airless Spray | **Pump Ratio:** 30 : 1 (min)*
Material Hose: 12 mm min I.D.
Tip Size: .021" - .035"
Output psi: 2200 - 2500 (152 - 172 Bar)

Teflon packing are recommended and are available from the pump manufacturer.

Brush | For striping of welds, touch-up of small areas only. Use a natural bristle brush, applying full strokes. Avoid rebrushing.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	13°C (55°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	32°C (90°F)	43°C (109°F)	38°C (100°F)	85%
Optimum	24°C (75°F)	24°C (75°F)	24°C (75°F)	45%

Do not apply when the surface temperature is less than 3°C above the dew point.
Special thinning and application techniques may be required above or below normal conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat	Final Cure
10°C (50°F)	18 Hours	48 Hours	21 Days
16°C (61°F)	12 Hours	32 Hours	14 Days
25°C (77°F)	6 Hours	16 Hours	7 Days
32°C (90°F)	3 Hours	8 Hours	4 Days

Final cure temperatures below 16°C are not recommended for tank linings. Final cure requirement varies depending on exposure. Force curing is recommended for all tank linings. Consult Carboline Tank Lining Guide or StonCor Africa Technical Service for advice.

Excessive film thickness or poor ventilating conditions require longer drying times and in extreme cases will cause premature failure.

EXCESSIVE HUMIDITY OR CONDENSATION ON THE SURFACE DURING CURING MAY RESULT IN A SURFACE HAZE OR BLUSH; ANY HAZE OR BLUSH MUST BE REMOVED BY WATER WASHING BEFORE RECOATING.

Curing Details | These times are at the recommended dry film thickness (200µ) per coat and 400µ total film thickness. Higher film thicknesses will lengthen cure times.

CLEANUP & SAFETY

Cleanup | Use Carboline Thinner #2

Ventilation | VAPOURS MAY CAUSE EXPLOSION. When used as a tank lining or in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapour concentration from reaching the lower explosion limit for the solvents used. In addition to proper ventilation, fresh air respirators or fresh air hoods must be used by all application personnel. Where flammable solvents exist, explosion proof lighting equipment must be used. Hypersensitive persons should wear protective clothing, gloves and/or protective cream on face, hands and all exposed areas.

Caution | Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product.

PACKAGING, HANDLING & STORAGE

Shelf Life | 24 Months minimum when stored at 25°C

Shipping Weight (Approximate) | **5 Litre Kit:**
Phenoline 1205: 7.3kg
Phenoline Thinner: 4.8kg

Flash Point (Pensky Martens Closed Cup) | Part A: 12°C
Part B: >93°C
Phenoline Thinner: 25°C

Phenoline 1205

PRODUCT DATA SHEET



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.