Phenoline 305 Finish

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Modified phenolic
Description	A heavy-duty topcoat, Phenoline 305 Finish sets to a hard, tough, smooth finish having very good abrasion resistance. The surface is glossy and easily cleaned. Has excellent resistance to a wide range of solvents, alkalies, cleaning solutions and acids entrained vapours of high concentration.
Features	• Excellent coating for the protection of steel surfaces in nuclear power plants • Used in chemical processing plants, pulp and paper mills for the protection of structural steel against severe splash, spillage and fume conditions • Fair flexibility • Very good weathering • Very good abrasion resistance • May be applied over inorganic zincs, catalyzed epoxies, modified phenolics or others as recommended • Acceptable primers are Carbozinc 11, Carboguard 193, Phenoline 305 Primer or others as recommended • A mist coat may be required when applied over inorganic zinc • Not recommended for immersion service or continuous spillage of hot or concentrated acids
Color	Available in a variety of colours. White and Pastel Shades may require multiple coats for adequate hiding. Deep Shades may have reduced chemical resistance. Consult your local StonCor Africa Sales or Customer Service Department for availability.
Finish	Gloss (70-85) Chalks
Dry Film Thickness	100 Microns
Solid(s) Content	By Volume 64% ± 2%
Theoretical Coverage Rates	6.4m²/litre at 100 microns **NOTE:** Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
Dry Temp. Resistance	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F)
Topcoats	Normally not required.

SUBSTRATES & SURFACE PREPARATION

General	Remove any oil or grease from surface to be coated.
Steel	Apply over clean, dry, recommended primer. Application over inorganic zincs may require a mist coat.

MIXING & THINNING

Mixing	Mix separately, then combine and mix thoroughly in the following proportions: **5 Litre Kit:** Part A: 4 litre Part B: 1 litre

Phenoline 305 Finish

PRODUCT DATA SHEET

MIXING & THINNING

Thinning	Thin up to 25% by volume with Phenoline Thinner **NOTE:** Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether express or implied.
Pot Life	1½ 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.

Spray Application	Use sufficient air volume for correct operation of equipment. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.
Conventional Spray	Use a 10mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface. **Gun:**905 Spray Gun **Fluid Tip:**1.8mm **Air Cap:**905-PV
Airless Spray	Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface. **Gun:**TRITECH T360 Spray Gun **Pump:**47:1 * Teflon packings are recommended and are available from the pump manufacturer. Use a .015 to .017” tip with 2200 psi (152 bar).
Brush & Roller (General)	For touch-up only. Use natural bristle brush, applying full coat. Avoid rebrushing. Use lambs-wool roller with phenolic core. Avoid rerolling. Two coats may be required for proper hiding and film build.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	13°C (55°F)	10°C (50°F)	10°C (50°F)	
Maximum	32°C (90°F)	43°C (109°F)	43°C (109°F)	90%
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 and when applying over inorganic zinc primers.

CURING SCHEDULE

Surface Temp.	Final Cure	Between Coats
10°C (50°F)	8 Days	24 Hours
16°C (61°F)	4 Days	10 Hours
25°C (77°F)	2 Days	5 Hours
32°C (90°F)	1 Day	3 Hours

CURING SCHEDULE

Curing Details	**Relative Humidity:** 50%

CLEANUP & SAFETY

Cleanup	Use Carboline Thinner # 2.
Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product and use personal protective equipment as directed.
Ventilation	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 ensure all personnel are below guidelines. If not able to monitor levels, use MSHA / NIOSH approved respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 Months minimum when stored at 25°C ***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**
Shipping Weight (Approximate)	**5 Litre Kit:** Phenoline 305 Finish: 7.5kg Phenoline Thinner: 4.8kg
Storage Temperature & Humidity	7 to 43°C 0 to 100%
Flash Point (Pensky Martens Closed Cup)	Part A: 20°C Part B: 12°C Phenoline Thinner: 25°C Thinner # 2: 22°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.