

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Modified phenolic
<b>Description</b>	Phenoline 305 Primer is a heavy-duty, high build primer having excellent adhesion to steel. Phenoline 305 Primer has excellent resistance to a wide range of solvents, alkalies and entrained acid vapours when topcoated with Phenoline 305 Finish. Phenoline 305 Primer is easily repaired and has excellent resistance to hydraulic fluids. A system of Phenoline 305 Primer / Phenoline 305 Finish meets the applicable performance criteria of ANSI N5.12-1974.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Phenoline 305 Primer is excellent for severe chemical environments and is a high build primer for structural steel and tank exteriors in highly corrosive areas</li> <li>• Fair flexibility</li> <li>• Good weathering (chalks)</li> <li>• Very good abrasion resistance</li> <li>• Not recommended for general immersion service or continuous spillage of hot or concentrated acids</li> </ul>
<b>Color</b>	Ivory
<b>Dry Film Thickness</b>	100 Microns
<b>Solid(s) Content</b>	By Volume 60% ± 2%
<b>Theoretical Coverage Rates</b>	6.0m <sup>2</sup> /litre at 100 microns <b>NOTE:</b> Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
<b>Dry Temp. Resistance</b>	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F)
<b>Topcoats</b>	Topcoat with Phenoline 305 Finish, epoxies or others as recommended.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Remove any oil or grease from surface to be coated prior to abrasive blast cleaning.
<b>Steel</b>	Dry abrasive blast to a near white metal finish in accordance with ISO 8501 Sa2½ to obtain a 50 to 75 micron blast profile.

## MIXING & THINNING

<b>Mixing</b>	Power mix separately, then combine and mix in the following proportions: Part A: 4 litre Part B: 1 litre
<b>Thinning</b>	Thin as required up to 20% by volume with Phenoline Thinner. Amount of thinner will vary depending on weather conditions. <b>NOTE:</b> 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.
<b>Pot Life</b>	1½ Hour at 25°C and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

# Phenoline 305 Primer

## 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.

**General** | **Repair Procedure:**  
Small surface defects can be repaired by hand sanding. Small areas damaged to substrate require power sanding or grinding. In both cases, feather edge to surrounding coating, solvent wipe and touch-up with brush. Avoid rebrushing. Large damaged areas require reblasting or mechanical cleaning to original specifications, feather edging and reapplication of the original system.

**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 pump manufacturer.  
Use a .019 to .023" tip with 2200 psi (152 bar)

**Brush & Roller (General)** | Use natural bristle brush. For touch-up only. For roller application, use a lambs-wool roller with phenolic core. Two coats may be required to obtain proper film thickness.

### 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)	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.

### 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 Details | Relative Humidity: 50%

### CLEANUP & SAFETY

Cleanup | Use Carboline Thinner # 2

### CLEANUP & SAFETY

<b>Safety</b>	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.
<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 ensure all personnel are below guidelines. If not able to monitor levels, use MSHA / NIOSH approved respirator.

### PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	24 Months minimum when stored at 25°C  <b>*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.</b>
<b>Shipping Weight (Approximate)</b>	<b>5 Litre Kit:</b> Phenoline 305 Primer: 7.9kg Phenoline Thinner: 4.8kg
<b>Storage Temperature &amp; Humidity</b>	7 to 43°C 0 to 100%
<b>Flash Point (Pensky Martens Closed Cup)</b>	Part A: 36°C Part B: 12°C Phenoline Thinner: 25°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.