

SELECTION & SPECIFICATION DATA

Generic Type	PLASITE 4006: A vinyl ester resin combined with pigments to provide a high build coating with excellent chemical resistance. PLASITE 4006HAR: A high build vinyl ester coating specially formulated for excellent abrasion resistance.
Description	As a chemical-resistant coating for tank lining service and as a maintenance coating to protect against corrosive conditions encountered in waste treatment, chemical/food processing and carbon filters. When combined with abrasive conditions, use PLASITE 4006HAR.
Color	PLASITE 4006: Off White; Gray; Yellow Oxide. PLASITE 4006HAR: Off White, Gray.
Finish	N/A
VOC Values	As Supplied : 42 +/- 2% As Supplied : 77 +/- 2%
Topcoats	Not Applicable

SUBSTRATES & SURFACE PREPARATION

Concrete or CMU	Immersion Service: All concrete surfaces require whip blasting for immersion service. Fully cured concrete minimum 28 day cure) must be blasted to provide a hard, firm, clean and neutral surface for coating. All concrete surfaces must be filled and sealed with the appropriate Carboline filler sealer, applied in accordance with the corresponding Carboline product data sheet. All surface imperfections, "bug holes," etc. must be completely repaired before application of PLASITE 4006.
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PERFORMANCE DATA

Test Method	Results
*Surface Hardness	(ASTM D2240) Shore D: 91
Abrasion Resistance	87.6 mg (ASTM D-4060, PLASITE 4006HAR: 37.5 mg, CS-17 wheel)
Gloss	Low sheen
Spray Viscosity	At 70°F/21°C, 17 ± 5 seconds Ford Cup #4.
Thermal Shock	Unaffected in 5 cycles, minus 70°F/21°C to plus 212°F

*Note: Above tests were conducted on film cured at 150°F.

MIXING & THINNING

Mixing	The promotor (Part B) and catalyst (Part C) are supplied in separate containers and are premeasured for the coating unit supplied. Thoroughly mix the coating (Part A). After the pigments and liquid are thoroughly mixed, add the entire amount of the measured liquid promotor (Part B). MIX COMPLETELY! NO COLOR STREAKING OR RESIDUE OF PART B SHOULD REMAIN ON CONTAINER SIDE-WALLS. Add the catalyst (Part C) and mix completely with the coating. Warning! The promotor (Part B) and the catalyst (Part C) must be separately mixed into the coating (Part A). Any contact of unmixed Part B with Part C may lead to a fire or explosion!
Thinning	Use PLASITE Thinner #20. 2 to 5% thinning may be required to adjust coating for higher temperatures and various application conditions. Topcoating of previously applied films will require the addition of 2 to 5% thinner. Consult Carboline Technical Service Department for unusual thinning requirements. See RECOATING TIME section. CLEANUP THINNER: Thinner #71
Pot Life	1 hour @ 70-80°F

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** | Airless spray system requires a large capacity pump with a capacity of 3 g.p.m./11 l.p.m. similar or equal to Graco Bulldog with 0.025 in./0.63 mm or larger fluid nozzle. A 12 in. minimum spray width is recommended. Use liquid pressure of approximately 1600-1800 psi/110-120 bars. All screens should be removed from pump and gun. A 3/8 in. diameter fluid line is recommended. Continuous mixing during use is required. Note: Airless spray is NOT recommended for PLASITE 4006HAR. A minimum surface temperature of 70°F/21°C is required to obtain polymerization of the coating system. Coating can be applied at a surface temperature as low as 60°F/16°C but polymerization will not take place. Succeeding coats cannot be applied without damaging the system until the surface temperature rises sufficiently to obtain polymerization. Refer to CURING. When surface temperatures are over 100°F/38°C, consult the laboratory for special thinner and thinning instructions. The mixed coating shall be applied utilizing a multi-pass spray system. Apply horizontal and vertical passes with 50% overlap. Special precautions are required at overlaps and welds to eliminate excessive film build. Spray gun should be perpendicular to surface at all times, approximately 14 in./36 cm from surface. Coating may be overcoated after initial "set" which will occur normally in 3 to 6 hours at 70°F/21°C with proper ventilation. Initial "set" time will decrease as surface temperature increases. Warning! Refer to RECOATING TIME. When physical contact (foot traffic, scaffolding, etc.) with the previously applied coating is required, a minimum of 10 hours at 70°F/21°C substrate and air temperature with ventilation is normally required before proceeding. Previously applied coats must have reached a "non-tacky" state before being exposed to physical contact. This condition will occur in less time as surface temperature increases. Over coating shall be performed as soon as possible to prevent contamination.
- Brush** | Brush application is not recommended, but may be used for repairs or touch-up. Continuous mixing during use is required.

CURING SCHEDULE

Surface Temp.	Cure Time
21°C (70°F)	7 Days
32°C (90°F)	5 Days

CLEANUP & SAFETY

- Safety** | For tank lining work it is recommended that the operator provide himself with clean coveralls and rubber soled shoes and observe good personal hygiene. Certain personnel may be sensitive to various types of resins which may cause dermatitis. THE SOLVENT IN THIS COATING IS FLAMMABLE AND CARE AS DEMANDED BY GOOD PRACTICE, OSHA, STATE AND LOCAL SAFETY CODES, ETC. MUST BE FOLLOWED CLOSELY. Keep away from heat, sparks, and open flame and use necessary safety equipment such as air mask, explosion-proof electrical equipment, non-sparking tools and ladders, etc. Avoid contact with skin and breathing of vapor or spray mist. When working in tanks, rooms, and other enclosed spaces adequate ventilation must be provided. Refer to Plasite Bulletin PA-3. Keep out of the reach of children. The catalyst or curing agent is relatively stable at room temperatures but must be protected from contamination, heat and fire and is classified by the Interstate Commerce Commission as an "oxidizing material." Subsequently, all shipping containers bear a yellow caution label. The catalyst is highly irritating if it gets into the eyes. Immediately rinse eyes thoroughly with water and get medical attention. The catalyst also can be a skin irritant and should be removed with large quantities of soap and water. Since this is an oxidizing material, it should not be allowed to accumulate or remain in soaked rags or clothing.



PACKAGING, HANDLING & STORAGE

Shelf Life | 60 days at 70°F

**Shipping Weight
(Approximate)** | Approximately 13 lbs./gallon

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.