

SELECTION & SPECIFICATION DATA

Generic Type	A high temperature bake, high solids, modified epoxy cured with an amine curing agent.
Description	INTENDED USE: An easy-to-apply chemical resistant internal tank lining. Meets the FDA requirements for 21 CFR, 175.300. PLASITE 9500 has been accepted by the U.S. Environmental Protection Agency for surfaces which contact potable water. FOR INDUSTRIAL USE ONLY!
Color	Tile Red (changing to Dark Red after final bake) Oxide Yellow (changing to Tan after final bake) 9500HAR: Tan (changing to brown after final bake) Note: UV exposure may cause discoloration.
Finish	N/A
Dry Film Thickness	305 - 381 microns (12 - 15 mils) per coat
Solids Content	By Volume 80% +/- 2%
Theoretical Coverage Rate	31.5 m ² /l at 25 microns (1283 ft ² /gal at 1.0 mils) 2.6 m ² /l at 300 microns (107 ft ² /gal at 12.0 mils) 2.1 m ² /l at 375 microns (86 ft ² /gal at 15.0 mils) Allow for loss in mixing and application.
VOC Values	As Supplied : 175 ± 2%
Topcoats	Not Applicable

SUBSTRATES & SURFACE PREPARATION

Aluminum	Surface shall be clean and grease-free with a blast produced anchor pattern or “tooth” as described earlier under STEEL. 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 Incorporated OAKITE CRYSCOAT 747LTS and OAKITE CRYSCOAT ULTRASEAL produced by Oakite Products For immersion, blasting with a sharp grit followed by the chemical surface treatment is required. For immersion, blasting with sharp grit followed by the chemical surface treatment is required. Although coated, aluminum substrates should not be used in caustic immersion service. Contact Carboline Technical Service Department for further information.
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PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	Results
Abrasion Resistance	58 milligrams average loss per 1000 cycles, Taber CS-17 Wheel, 1000 gram weight.
Gloss	25 to 35 at 60°
Pigments	Iron oxide yellow, iron oxide red and inerts
Surface Hardness:	Konig Pendulum Hardness of 160 seconds (Glass Standard = 250 seconds); ASTM Method D4366-84.
Thermal Shock	Unaffected 5 cycles, minus 70°F to plus 212°F.

Plasite 9500 HAR

PRODUCT DATA SHEET



MIXING & THINNING

Mixing	The curing agent and coating are supplied in separate containers at a 4:1 ratio. For splitting purposes, use 1 part curing agent to 4 parts coating by volume. Thoroughly mix coating, then add curing agent slowly and mix completely with coating. The coating should stand approximately 30 minutes after the curing agent has been thoroughly mixed.
Thinning	PLASITE Thinner #46 is recommended for thinning. The amounts required will vary depending on air and surface temperatures and application equipment. Normal application temperatures and conditions will require the addition of approximately 10% by volume with approximately 5% additional thinner added for each 5°F of increased temperature. Airless spray equipment and above normal temperatures require additional thinning. It is recommended that the amount of thinner included on each order amount to approximately 20% of the coating order. CLEANUP THINNER: Thinner #71
Ratio	4:1
Pot Life	Approx. 6 to 8 hours at 70°F; 90 minutes at 90°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.

Spray Application (General)	All spray equipment shall be thoroughly cleaned and the hose, in particular, shall be free of old paint film and other contaminants. Use standard production-type spray guns: GUN DeVilbiss JGA-510 Binks #2001 Graco P800 FLUID E 66-SS 04 AIR 797 63-PB 02 When airless spray equipment is used, the recommended liquid pressure is 1500 to 1800 psi with tip size from .017" to .021". Thinning requirements are more than for conventional spray. Air supply shall be uncontaminated. Adjust air pressure to approximately 50 lbs. at the gun and provide 15 to 20 lbs. of pot pressure. Adjust spray gun by first opening liquid valve and then adjusting air valve to give approximately an 8" to 12" fan holding perpendicular to the surface at a distance of 12". Apply a "mist" bonding pass. Allow to flash off for several minutes, but not long enough to allow film to completely dry. Apply 3 to 4 crisscross multi-passes maintaining a wet appearing film (approximately 7 to 9 wet mils). This will dry to approximately 6 to 7 dry mils. Air dry with forced ventilation for 60 minutes. Intermediate bake using one of the following schedules: 90 minutes at 150°F (metal temperature) or 3 hours at 125°F (maximum metal temperature). Allow to cool. Apply second coat by repeating the above. Air dry with forced ventilation for 60 minutes. Bake at 375 to 400°F for 1 hour (metal temperature) for full cure.
Brush	Not suitable for brush application except for minor repairs and the striping of weld seams or other irregularities. Use brush of good quality.

CLEANUP & SAFETY

Safety	For tank lining work or enclosed spaces, 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.
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PACKAGING, HANDLING & STORAGE

Shelf Life | 12 months at 70°F. Material in stock should be turned upside down every 3 months.

**Shipping Weight
(Approximate)** | Approx. 13 1/2 lbs/gallon

Flash Point (Setaflash) | 81°F

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.