

SELECTION & SPECIFICATION DATA

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| Generic Type | A low temperature bake high solids modified epoxy cured with an amine curing agent. PLASITE 9570HAR is specifically formulated for excellent abrasion resistance while retaining temperature, chemical and other physical properties of PLASITE 9570. PLASITE 9570TFE is specifically formulated to provide greater release properties to aid in the prevention of product hang-up or bridging problems. |
| Description | INTENDED USE: As a highly resistant film for chemical tank lining service. |
| Color | Iron Oxide Yellow; Olive Oxide; *Cream Note: Will discolor when exposed to UV. * for use of prime coat |
| Finish | N/A |
| Dry Film Thickness | 152 - 178 microns (6 - 7 mils) per coat |
| VOC Values | As Supplied : 144 ± 2% As Supplied : 203 ± 2% VOC content varies between colors. Contact Carboline Technical Service Department for VOC of specific colors. |
| Topcoats | Not Applicable |

SUBSTRATES & SURFACE PREPARATION

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| 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. Note: On metallic surfaces prepared only by chemical etching, the total coating film thickness applied should be restricted to only half the film normally applied to blasted surfaces. This reduced film thickness should be considered during selection of the coating for the service and the type of surface preparation performed. |
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MIXING & THINNING

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| 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 | Thinner #71 is recommended for thinning and clean-up. It will always be necessary to thin the coating. The applicator must make exact thinner adjustments based on his equipment and air and surface temperatures. The following thinning guidelines are appropriate: Normal application temperatures and conditions will require the addition of approximately 10 to 20% thinner by volume with approximately 5% additional thinner added for each 5°F of increased temperature. It is recommended that the amount of thinner included on each order amount to approximately 20% of the coating order. |

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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 should be thoroughly cleaned and the hose, in particular, should 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. Note: Be aware that PLASITE 9570HAR will cause accelerated wear to airless equipment lower units and spray tips due to abrasion resistant pigment. Air supply shall be uncontaminated. Adjust air pressure to approximately 60 to 80 lbs. at the gun and provide 30 to 35 lbs. of pot pressure. Adjust spray gun by first opening liquid valve and then adjusting air valve to give an 8" to 12" wide spray pattern with best possible atomization. Apply a "mist" bonding pass. Allow to dry approximately one minute but not long enough to allow film to completely dry. Note: When applying the PLASITE 9570TFE system, use the standard PLASITE 9570 as the base coat. Apply crisscross multi-passes, moving gun at fairly rapid rate, maintaining a wet appearing film. Observe the coating surface and when it appears to be flowing together, you will have an average of 4 to 5 mils wet film. By allowing the solvents to flash-off for a few minutes, several more fast multipasses may be applied until you have a film thickness of approximately 5 to 7 mils DFT (approximately 8 to 10 wet mils). Repeat this procedure for the second coat to obtain a 12 to 15 mill DFT. Overcoat time will vary both with temperature and ventilation and will require from 16 to 24 hours at 70 to 90°F for enclosed spaces. Refer to DRYING TIME section. Remove all overspray by dry brushing or scraping if required. Air dry with ventilation a minimum of 60 minutes prior to introducing heat. After the air dry period has elapsed, the temperature should be raised approximately 30°F in increments of 30 minutes until the desired temperature is reached. Refer to FINAL BAKE. Equipment must be thoroughly cleaned immediately after use with Plasite thinner to prevent the setting of the coating. Note: Prior to spray application, stripe brush all welds, attachments and surface irregularities using PLASITE 9570 thinned a minimum of 50% by volume with Thinner #71.

Brush | Normally not recommended except for touch-up, repairs or at weld areas prior to spraying.

CURING SCHEDULE

| Surface Temp. | Tack Free |
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| 21°C (70°F) | 24 Hours |
| 32°C (90°F) | 16 Hours |

FINAL BAKE The final bake is based on metal temperatures. 4 Hours at 200°F Minimum (Metal Temperature) 2 Hours at 250°F Minimum (Metal Temperature) A final bake of 250°F will increase resistance to certain exposures and is generally recommended when the exposure is considered to be extremely severe.

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. **FIRE AND EXPLOSION HAZARDS: PRODUCT CONTAINS LESS THAN 1% VOLATILE COMPONENTS. HOWEVER, VAPORS ARE HEAVIER THAN AIR AND COULD TRAVEL LONG DISTANCES, IGNITE, AND FLASHBACK. ELIMINATE ALL IGNITION SOURCES.** 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. Respirators or fresh air supplied hoods may be required. Refer to Plasite Bulletin PA-3. Keep out of the reach of children.



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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.