

**TYPE**

PLASITE 5325 is a 1/8 inch/3mm. vinyl ester monolithic liner formulated for chemical and abrasion resistance in corrosive atmospheres or continuous immersion.

**INTENDED USE**

Heavy duty lining for:

Tanks	Conveyor Troughs
Foundations	Trenches
Pumps	Chutes
Acid Pits	Conveyor Tunnels
Trough Walls	

**ADVANTAGES**

Cures quickly to form an exceptionally tough, abrasion resistant surface. Excellent adhesion to concrete and steel. Minimum down time. Non-shrinking.

**COLOR:** Gray

**SURFACE PREPARATION****Concrete**

New concrete must have a minimum of 28 days cure, and no curing agents or sealers shall be used unless approved by Carboline. Remove oil, grease or other loose or foreign materials and contaminants. A good bonding tooth, the texture of 40 to 60 grit sandpaper, is desired with the removal of all glaze. To provide the foregoing bonding tooth, it is necessary to prepare the surface using one of the following methods: sandblast with fine sand and reduced pressure, scarify or rotary shot blast such as Blastrac®.

For immersion service, all concrete surfaces must be blasted to provide a hard, firm, clean and a neutral surface.

**Metal Surfaces**

Degrease surface prior to sandblasting. Use organic solvents, alkaline solutions, steam, hot water with detergents or other systems that will completely remove dirt, oil, grease, etc.

Blast the surface to near white SSPC-SP10 or NACE No. 2 using a Venturi blast nozzle with 100 psi air. To produce the 4 mil minimum anchor pattern or "tooth", the blasting media used shall be a properly graded, clean, sharp angular abrasive similar to Humble Abrasive Flint S7 (6-30 mesh), Steel Grit (HG25) or BLACK BEAUTY® (BB1040).

**APPLICATION TEMPERATURE**

Do not apply when surface temperature is below 60°F. The warmer the temperature the faster the cure. High humidity will increase the cure time. For application, the material must be 70 to 85°F.

**COVERAGE**

Coverage based on a normal surface.

A standard unit of 5325 will cover 132 ft<sup>2</sup> at 1/8" thick.

**Primer**

One Part A and one Part B is sufficient for priming a surface area of 60 to 80 ft<sup>2</sup>.

**Liner**

One Part A, one Part B and one Part C covers 11ft<sup>2</sup> at 1/8" thickness.

**Gel Coat**

One Part A one Part B covers a surface area of 66ft<sup>2</sup>.

**PHYSICAL SPECIFICATIONS**

**Solids:** Approximately 91% (mixed). Volume solids reflect some loss of reactive monomer from applied film. The amount of reactive monomer lost will vary depending upon temperature and air movement.

**Shelf Life @ 70°F:** Part A: 3 months  
Part B is 24 months  
Part C is 36 month

**CHEMICAL RESISTANCE**

Excellent broad range chemical resistance.

**PACKAGING**

Primer and gel coat are included with PLASITE 5325 liner. Refer to COVERAGE information.

A unit of PLASITE 5325 consist of:

2 cartons of primer liquids  
A carton contains:  
(1) can Part A  
(1) can Part B

12 cartons of liner liquids  
A carton contains:  
(1) can Part A  
(1) can Part B

12 cartons of Part C chemical resistant aggregate

1 carton of Sealer  
A carton contains:  
(1) can Part A  
(1) can Part B

**MIXING****Primer**

Mix Parts A and B thoroughly (the pot life or working life is approximately 45 minutes in the can). Always apply the entire unit as soon as blended.

**Mixer**

A mechanical mixer designed for quick, thorough mixing of aggregated coatings similar to those manufactured by:

KOL MIXAL Div. of Man U Fab, Inc.  
Minneapolis, MN

KENRICH PRODUCTS  
Portland, OR

**Important!** The pot life or working life of the liner blend is 45 minutes. Always pour and finish mixed batches as soon as blended.

**Liner**

Empty the contents of Part B into Part A and mix thoroughly. Then empty the mixture into a mixer, draining the can for about 1/2 minute. Start mixer and slowly add Part C and mix approximately 5 minutes, thoroughly wetting out all the aggregate.

**Note:** Person mixing should wear a dust mask or respirator.

# PLASITE® 5325

## Sealer

The promotor (Part B) and catalyst (Part C) are supplied in separate containers and are premeasured for the sealer unit supplied. Thoroughly mix the coating (Part A). After the pigments and liquids 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. Once the components are combined, the potlife is 1 hour at 70°F.

**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 an explosion.

## APPLICATION

Application in direct sunlight and rising surface temperatures may result in blistering of the materials due to expansion of entrapped air or moisture in the concrete.

Concrete surfaces that have been in direct sunlight must be shaded for 24 hours prior to application and remain shaded until the initial set has taken place. When the surface temperatures are rising, it may be necessary to postpone the application or apply during the cooler evening hours.

## Primer

Apply a thin coat of primer by brush or roller. Spread the liner immediately before primer has hardened, which will occur in approximately 1 to 1 1/2 hours at 70°F. If primer hardens before liner is applied, the area must be reprimed.

## Liner

Spread liner evenly over surface at 1/8" thickness. Finish each batch as you go. A 3 1/2" x 10" trowel with rounded corners (referred to as a "swimming pool trowel") is recommended for liner application.

**Note:** Reworking of liner after 10 to 15 minutes may result in liner pulling apart and sticking to the trowel.

## Sealer

The sealer may be applied by brush or a medium (3/8") nap roller once the liner has hardened enough to allow application without damaging the liner. Make sure all pores or trowel pulls are completely sealed.

## CURE TIME

Hardening and cure time are greatly affected by temperature and humidity.

PLASITE 5325 liner will harden in a few hours while complete cure will require 72 hours at 70°F.

## CLEAN UP

Hardened PLASITE 5325 is extremely difficult to remove. Clean tools immediately with thinner or MEK.

**CLEANUP THINNER:** Thinner #71

## INSPECTION

A pinhole-free film is essential for immersion service. Testing with a Tinker & Rasor Model AP-W, Stearns Model 14/20 or equivalent is required. 10,000 to 14,000 volts should be used. Allow a minimum of 48 hours at 70°F before holiday testing.

## SAFETY

### READ THIS NOTICE SAFETY AND MISCELLANEOUS EQUIPMENT

**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. When working in rooms and other enclosed spaces, adequate ventilation must be provided. Refer to Plasite Bulletin PA-3. Keep out of the reach of children.

The coating system may be handled safely by trained personnel following normal laboratory and plant standards for housekeeping and personal hygiene. In the event of skin contact complications, the affected areas should be washed with soap and water. Eye protection is recommended. Work in well ventilated areas away from flame. When working in confined areas adequate ventilation must be provided. Respirators or fresh air supplied hoods may be required.

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" and, 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.

**CAUTION** - Read and follow all caution statements on this product data sheet, material safety data sheet and container label for this product.

This data sheet provides standard information on the coating and application procedure. Since varying conditions may not be covered, consult with your local sales representative or Carboline Technical Service Department for further information.



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