

Selection & Specification Data

Generic Type	Epoxy Phenolic
Description	A heavy-duty primer with excellent bond to most surfaces including steel and concrete. Contains a special mica to give maximum internal strength and outstanding resistance to severe chemicals, alkalis, salts and solvents. Recommended as a primer for Phenoline topcoats in heavy-duty splash and spillage service, for lining of tanks, sumps and pits and protection of floors. Not recommended for lining steel tanks where the temperature exceeds 180°F (82°C) or where heating/cooling cycles occur. Not recommended for immersion service in strong oxidizing acids.
Features	<ul style="list-style-type: none"> ▪ Excellent resistance to sub-film corrosion ▪ Excellent wetting properties ▪ High build for irregular surfaces ▪ Excellent overall chemical resistance ▪ Tough, abrasion resistant, reinforced film ▪ Meets current VOC regulations
Color	Salmon (0400)
Finish	Semi-Gloss
Primers	Apply directly to substrate. Use as primer only.
Topcoats	Must be topcoated with phenolics, epoxies or others as recommended.
Dry Film Thickness	8 mils (200 microns) per coat. Do not exceed 12 mils (300 microns) per coat.
Solids Content	By Volume: 78% ± 2%
Theoretical Coverage Rate	1251 mil ft ² (30.7 m ² /l at 25 microns) 156 ft ² at 8 mils (3.9 m ² /l at 200 microns) Allow for loss in mixing and application.
VOC Values	As supplied: 1.5 lbs/gal (177 g/l) Thinned w/ 12 oz/gal Phenoline Thinner: 2.03 lbs/gal (243 g/l) Thinned w/ 20 oz/gal Phenoline Thinner: 2.31 lbs/gal (277 g/l) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Metal tanks must be insulated when temperature exceeds 140°F (60°C).

Substrates & Surface Preparation

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Or Remove all oil or grease from the surface to be coated with Thinner #2 or Surface Cleaner 3 (refer to Surface Cleaner 3 instructions) in accordance with SSPC-SP1.
Steel	Immersion service: Abrasive blast to a near white metal finish in accordance with SSPC-SP 10 and obtain a 2-3 mil (50-75 micron) angular blast profile. Non-immersion service: Abrasive blast to commercial grade finish in accordance with SSPC-SP 6 and obtain a 2-3 mil (50-75 micron) angular blast profile.
Concrete	Concrete must be cured at least 28 days at 70°F (21°F) and 50% RH or equivalent time. Remove fins and other protrusions by stoning, sanding or grinding. Abrasive blast to open all surface voids and remove all form oils, incompatible curing agents, hardeners, laitance, other foreign matter and produce a surface texture similar to that of a medium grit sandpaper. Voids in the concrete may require surfacing. Blow or vacuum off sand and dust with clean, dry air.

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Phenoline® 300 Primer

Application Equipment

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 Guidelines:

Spray Application (General) The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray Pressure pot equipped with dual regulators, ½" I.D. minimum material hose, 0.086" I.D. fluid tip and appropriate air cap.

Airless Spray* Pump Ratio: 30:1 (min.)**
GPM Output: 3.0 (min.)
Material Hose: ½" I.D. (min.)
Tip Size: .023"-.027"
Output PSI: 2200-2500
*This material contains abrasive fillers which will abrade tips and possibly cause wear to other airless equipment parts with prolonged use.
**Teflon packings are recommended and available from the pump manufacturer.

Brush For stripping of welds and touch-up of small areas only. Use a natural bristle brush, applying full strokes. Avoid rebrushing.

Roller Not recommended.

Mixing & Thinning

Mixing Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.

	<u>1 Gal Kit</u>	<u>4 Gal Kit</u>
Phenoline 300 Primer Part A	0.8 gals (1 gal can)	3.2 gals (5 gal can)
Phenoline 300 Primer Part B	0.2 gals (1 qt can)	0.8 gals (1 gal can)

Thinning May be thinned up to 12 oz/gal (10%) with Phenoline Thinner for airless spray application and up to 20 oz/gal (15%) for conventional spray application. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Pot Life 60 minutes at 75°F (24°C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

Cleanup & Safety

Cleanup Use Thinner #2. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	65°-85°F (18°-29°C)	65°-85°F (18°-29°C)	65°-85°F (18°-29°C)	30-60%
Minimum	60°F (16°C)	60°F (16°C)	50°F (10°C)	0%
Maximum	85°F (29°C)	100°F (38°C)	110°F (43°C)	85%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point. Special thinning and application techniques may be required above or below normal application conditions.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Minimum Recoat Time	Maximum Recoat Time
60°F (16°C)	36 Hours	10 Days
75°F (24°C)	18 Hours	5 Days
90°F (32°C)	12 Hours	3 Days

These times are based on a 8.0 mil (200 micron) dry film thickness. Higher film thicknesses, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Note: before topcoating, always scrub the surface with bristle brushes and clean potable water to remove any blush which may have occurred. Allow to dry thoroughly before topcoating. If the maximum recoat time is exceeded, the surface must be abraded by sweep blasting prior to the application of additional coats.

Packaging, Handling & Storage

Shipping Weight (Approximate)	<u>1 Gallon Kit</u>	<u>4 Gallon Kit</u>
	13.7 lbs (6.2 kg)	54 lbs (24.59 kg)
Phenoline Thinner	<u>1's</u>	<u>5's</u>
	9 lbs (4.1 kg)	45 lbs (20.4 kg)

Flash Point (Setaflash) Part A: 132°F (55°C)
Part B: 68°F (20°C)
Thinner: 77°F (25°C)

Storage (General) Store Indoors.

Storage Temperature & Humidity 45°- 110°F (4°-43°C)
0-100% Relative Humidity

Shelf Life 24 months at 75°F

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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