

## Selection & Specification Data

<b>Generic Type</b>	Modified phenolic
<b>Description</b>	A heavy-duty primer with excellent bond to most surfaces, including steel and concrete. Outstanding resistance to severe chemicals, alkalis, salts and solvents. Excellent resistance to sub-film corrosion.
<b>Features</b>	<ul style="list-style-type: none"> <li>- Primer for Phenoline topcoats in heavy-duty splash and spillage service, for lining of tanks and protection of floors.</li> <li>- Fair flexibility</li> <li>- Good weathering (chalks)</li> <li>- Excellent abrasion resistance</li> <li>- Not recommended for lining steel tanks where the temperature exceeds 82°C or where heating-cooling cycles occur.</li> <li>- Not recommended for immersion service in strong oxidizing acids.</li> </ul>
<b>Colour</b>	Pink
<b>Finish</b>	Medium Gloss
<b>Topcoat</b>	May be topcoated with modified phenolics, catalyzed epoxies or others as recommended. Usually topcoated with Phenoline 302.
<b>Dry Film Thickness</b>	200 Microns
<b>Solids Content</b>	By Volume 78% ± 2%
<b>Theoretical Coverage Rate</b>	3.9m <sup>2</sup> /litre at 200 microns
	<b>NOTE:</b> Material losses during mixing and application may vary and must be taken into consideration when estimating job requirements.
<b>VOC Values</b>	The following are nominal values:
	As Supplied                      185 g/litre
	Thinned with Phenoline Thinner
	Thinned 15%                      270 g/litre
<b>Dry Temp Resistance</b>	<b>Non-immersion</b> Continuous                      93°C

## Substrates & Surface Preparation

<b>General</b>	Remove any oil or grease from surface to be coated prior to abrasive blast cleaning.
<b>Steel</b>	<p><b>For immersion service:</b> Dry abrasive blast to a white metal finish in accordance with ISO 8501 Sa3 to obtain a 50 to 75 micron blast profile. Weld slag must be removed and welds ground to a rounded contour.</p> <p><b>For non-immersion service:</b> Dry abrasive blast to a near white metal finish in accordance with ISO 8501 Sa2½ to obtain a 50 to 75 micron blast profile.</p>
<b>Concrete</b>	Remove fins and other protrusions by stoning, sanding or grinding. Concrete must be cured at least 28 days at 25°C and 50% RH or equivalent time. Remove form oils, incompatible curing agents and hardeners by abrasive blasting.
	<b>Immersion service:</b> Abrasive blast to open all voids and obtain a surface similar to medium grit sandpaper. Blow or vacuum off sand and dust. Extremely rough concrete surfaces may require surfacing. Consult StonCor Africa Technical Service for specific recommendations.
	<b>Non-immersion service:</b> Abrasive blast to remove laitance. For other surfaces, blow off with compressed air to remove dust.

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# Phenoline® 300 Primer

## Application Equipment

**Spray** Use sufficient air volume for correct operation of equipment. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

**NOTE:** The following spray equipment has been found suitable, however equivalent equipment may be substituted.

**Conventional** Pressure pot equipped with dual regulators, 12mm minimum I.D. material hose, .110" I.D. fluid top and appropriate air cap.

**Airless**

Pump Ratio	30:1 (min) *
Material Hose	12mm min I.D.
Tip Size	.035 to .041"
Output psi	2200 to 2500 (152 to 172 bar)

\* Teflon packings are recommended and are available from the pump manufacturer.

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

## Mixing & Thinning

**Mixing** Power mix Part A and Part B separately, then combine and mix in the below proportions.

**Ratio** 4:1, Part A to B

**Thinning** Thin up to 10% by volume for airless spray applications and up to 15% by volume for conventional spray application with Phenoline Thinner.

**NOTE:** Use of thinner other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether express or implied.

**Pot Life** 1 hour at 25°C and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	18-29°C	18-29°C	18-29°C	30-70%
Minimum	16°C	16°C	10°C	0%
Maximum	29°C	38°C	43°C	85%

Do not apply when the surface temperature is less than 3°C above the dew point.

Special thinning application techniques may be required above or below normal conditions.

## Curing Schedule

Surface Temp & 50% Relative Humidity	Minimum Recoat Time	Maximum Recoat Time
16°C	36 Hours	10 Days
24°C	18 Hours	5 Days
32°C	12 Hours	3 Days

These times are based on a 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.

## Cleanup & Safety

**Cleanup** Carboline Thinner # 2

**Ventilation** Vapours may cause explosion. When used as a tank lining or in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapour concentration from reaching the lower explosion limit for the solvents used. In addition to proper ventilation, fresh air respirators or fresh air hoods must be used by all application personnel. Where flammable solvents exist, explosion proof lighting equipment must be used. Hypersensitive persons should wear protective clothing, gloves and/or protective cream on face, hands and all exposed areas.

**Caution** Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product.

## Packaging, Handling & Storage

<b>Shipping Weight (Approximate)</b>		<b>5 Litre Kit</b>
	Phenoline 300	8.1kg
	Phenoline Thinner	4.8kg

<b>Flash Point (Pensky Martens Closed Cup)</b>	Part A	23°C
	Part B	20°C
	Phenoline Thinner	25°C

**Storage Temperature & Humidity** 4 to 43°C  
0 to 100%  
Store indoors

**Shelf Life** 24 Months minimum when stored at 25°C

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



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