

## Selection & Specification Data

<b>Generic Type</b>	Modified phenolic				
<b>Description</b>	Phenoline 302 is one of the most resistant topcoats of the Phenoline series for immersion service. It has very good resistance to abrasion, including slurries. After the final cure there is no leaching of resins or catalyst. Excellent general tank lining material because of its overall chemical resistance.				
<b>Features</b>	<ul style="list-style-type: none"> <li>- As a lining for tanks holding moderate concentration acids, alkalies, salts or solvents</li> <li>- Excellent tank lining material for acid-solvent and alkali-solvent solutions</li> <li>- Recommended as a heavy-duty maintenance coating for severe exposure to splash, spillage and fumes</li> <li>- Also for protection of floors exposed to chemical spillage</li> <li>- Generally used where other lining systems have proved unsuitable</li> <li>- Fair flexibility</li> <li>- Good weathering</li> <li>- Very good abrasion resistance</li> <li>- May be applied over recommended modified phenolics or catalyzed epoxy primers or surfacers</li> <li>- Not recommended for immersion in strong acids</li> </ul>				
<b>Colour</b>	Black and Charcoal only				
<b>Finish</b>	Flat				
<b>Topcoat</b>	Normally not required. May be topcoated with Phenoline 305 Finish for colour-coding in non-immersion service.				
<b>Dry Film Thickness</b>	100 Microns				
<b>Solids Content</b>	By Volume 78% ± 2%				
<b>Theoretical Coverage Rate</b>	7.8m <sup>2</sup> /litre at 100 microns				
	<b>NOTE:</b> Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.				
<b>Temp Resistance</b>	<p><b>Non-immersion</b></p> <table> <tr> <td>Continuous</td> <td>70°C</td> </tr> <tr> <td>Non-continuous</td> <td>93°C</td> </tr> </table> <p>Immersion temperature resistance is dependent on solution, but should not exceed 82°C. Metal tanks must be insulated when temperatures exceed 60°C.</p>	Continuous	70°C	Non-continuous	93°C
Continuous	70°C				
Non-continuous	93°C				

## Substrates & Surface Preparation

<b>General</b>	Remove any oil or grease from surface to be coated.
<b>Steel</b>	Apply to clean, dry, recommended primer.
<b>Concrete</b>	Apply over clean, dry, properly primed or surfaced concrete.

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## 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 equipment has been found suitable, however equivalent equipment may be substituted.

**Conventional Spray** Use 12mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface.

<b>Mfr &amp; Gun</b>	<b>Fluid Tip</b>	<b>Air Cap</b>
Binks # 18 or # 62	67	67PB
DeVilbiss P-MBC or JGA	D	64

**Airless Spray** **NOTE:** This material contains abrasive fillers which will abrade or block tips, and cause wear to other airless equipment parts with prolonged use. Applicators should conduct trials to verify if their airless spray equipment is suitable for use.

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

**Roller** Use phenolic core rollers. Pour material out and spread rapidly to required wet film thickness. Maintain wet edge and avoid re-rolling.

## Mixing & Thinning

**Mixing** Mix separately, then combine and mix in the following proportions:

	<b>5 Litre Kit</b>
Part A	4 litre
Part B	1 litre

**Thinning** Thin up to 25% by volume with Phenoline Thinner

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

**Pot Life** 1½ Hours 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	16-29°C	16-29°C	16-29°C	30-70%
Minimum	13°C	10°C	10°C	0%
Maximum	32°C	43°C	43°C	85%

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

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

## Curing Schedule

Surface Temp. & 50% Relative Humidity	Minimum Between Coats	Maximum Between Coats *	Final Cure
10°C	72 Hours	4 Days	28 Days
16°C	36 Hours	3 Days	14 Days
25°C	18 Hours	2 Days	7 Days
32°C	12 Hours	1 Day	5 Days

Force curing is suggested for all tank linings. Excessive film thickness or poor ventilation conditions require longer dry times and in extreme cases may cause premature failure.

\* If this time is exceeded, special surface preparation will be necessary before recoating. Excessive humidity or condensation on the surface during curing may result in a surface haze or blush; any haze or blush should be removed by water washing before recoating.

## Cleanup & Safety

**Cleanup** Carboline Thinner # 2

**Safety** Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions, including personnel protection equipment.

**Ventilation** 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 vapor 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 clean protective clothing, gloves and/or protective cream on face, hands and all exposed areas.

**Caution** This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## Packaging, Handling & Storage

<b>Shipping Weight (Approximate)</b>	Phenoline 302	<b>5 Litre Kit</b>
	Phenoline Thinner	7.8kg 4.8kg

<b>Flash Point (Pensky Martens Closed Cup)</b>	Part A	49°C
	Part B	12°C
	Phenoline Thinner	25°C

**Storage Temperature & Humidity** 7 to 43°C  
0 to 100%

**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.**



Co. Reg. No.: 1996/01848/07  
Tel No: +27 11 254 5500  
Website: [www.carboline.co.za](http://www.carboline.co.za)  
E-mail: [carbolinesa@carboline.com](mailto:carbolinesa@carboline.com)

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