

Selection & Specification Data

Generic Type	Modified phenolic						
Description	A heavy-duty topcoat, Phenoline 305 Finish sets to a hard, tough, smooth finish having very good abrasion resistance. The surface is glossy and easily cleaned. Has excellent resistance to a wide range of solvents, alkalies, cleaning solutions and acids entrained vapours of high concentration.						
Features	<ul style="list-style-type: none"> - Excellent coating for the protection of steel surfaces in nuclear power plants - Used in chemical processing plants, pulp and paper mills for the protection of structural steel against severe splash, spillage and fume conditions - Fair flexibility - Very good weathering - Very good abrasion resistance - May be applied over inorganic zincs, catalyzed epoxies, modified phenolics or others as recommended - Acceptable primers are Carbozinc 11, Carboguard 193, Phenoline 305 Primer or others as recommended - A mist coat may be required when applied over inorganic zinc - Not recommended for immersion service or continuous spillage of hot or concentrated acids 						
Colour	Available in a variety of colours. White and Pastel Shades may require multiple coats for adequate hiding. Deep Shades may have reduced chemical resistance. Consult your local StonCor Africa Sales or Customer Service Department for availability.						
Finish	Glossy (chalks)						
Topcoat	Normally not required						
Dry Film Thickness	100 Microns						
Solids Content	By Volume 64% ± 2%						
Theoretical Coverage Rate	6.4m ² /litre at 100 microns						
	NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.						
Temp Resistance	<table border="0"> <tr> <td>Non-immersion</td> <td></td> </tr> <tr> <td>Continuous</td> <td>93°C</td> </tr> <tr> <td>Non-continuous</td> <td>121°C</td> </tr> </table>	Non-immersion		Continuous	93°C	Non-continuous	121°C
Non-immersion							
Continuous	93°C						
Non-continuous	121°C						

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated.
Steel	Apply over clean, dry, recommended primer. Application over inorganic zincs may require a mist coat.

November 2016 replaces August 2016

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Phenoline® 305 Finish

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 Use a 10mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface.

<u>Mfr & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks # 18 or # 62	66	63PB
DeVilbiss P-MBC or JGA	E (approx. .070" I.D.)	704

Airless Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface.

<u>Mfr & Gun</u>	<u>Pump *</u>
DeVilbiss JGB-507	QFA-519
Graco 205-591	President 30:1 or Bulldog 30:1
Binks Model 700	B8-36 37:1

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

Use a .015 to .017" tip with 2200 psi (152 bar).

Brush or Roller For touch-up only. Use natural bristle brush, applying full coat. Avoid rebrushing. Use lambs-wool roller with phenolic core. Avoid rerolling. Two coats may be required for proper hiding and film build.

Mixing & Thinning

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

	<u>5 Litre Kit</u>
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	18-29°C	18-29°C	18-29°C	30-60%
Minimum	13°C	10°C	10°C	0%
Maximum	32°C	43°C	43°C	90%

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 and when applying over inorganic zinc primers.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Between Coats	Final Cure
10°C	24 Hours	8 Days
16°C	10 Hours	4 Days
25°C	5 Hours	2 Days
32°C	3 Hours	1 Day

Cleanup & Safety

Cleanup Use Carboline Thinner # 2

Safety Read and follow all caution statements on this product data sheet and on the MSDS for this product and use personal protective equipment as directed.

Ventilation When used in enclosed areas, thorough air circulation must be used 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. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not able to monitor levels, use MSHA / NIOSH approved respirator.

Packaging, Handling & Storage

Shipping Weight (Approximate)	Phenoline 305 Finish	<u>5 Litre Kit</u>
	Phenoline Thinner	7.5kg
		4.8kg

Flash Point (Pensky Martens Closed Cup)	Part A	20°C
	Part B	12°C
	Phenoline Thinner	25°C
	Thinner # 2	22°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.**



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