

Selection & Specification Data

Generic Type	Modified phenolic						
Description	Phenoline 305 Primer is a heavy-duty, high build primer having excellent adhesion to steel. Phenoline 305 Primer has excellent resistance to a wide range of solvents, alkalies and entrained acid vapours when topcoated with Phenoline 305 Finish. Phenoline 305 Primer is easily repaired and has excellent resistance to hydraulic fluids. A system of Phenoline 305 Primer / Phenoline 305 Finish meets the applicable performance criteria of ANSI N5.12-1974.						
Features	<ul style="list-style-type: none"> - Phenoline 305 Primer is excellent for severe chemical environments and is a high build primer for structural steel and tank exteriors in highly corrosive areas - Fair flexibility - Good weathering (chalks) - Very good abrasion resistance - Not recommended for general immersion service or continuous spillage of hot or concentrated acids 						
Colour	Ivory						
Topcoat	Topcoat with Phenoline 305 Finish, epoxies or others as recommended.						
Dry Film Thickness	100 Microns						
Solids Content	By Volume 60% ± 2%						
Theoretical Coverage Rate	6.0m 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> <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 prior to abrasive blast cleaning.
Steel	Dry abrasive blast to a near white metal finish in accordance with ISO 8501 Sa2½ to obtain a 50 to 75 micron blast profile.

November 2016 replaces August 2016

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Phenoline® 305 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.

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 # 32	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	Mercury 5C or B8-36 37:1

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

Use a .019 to .023" tip with 2200 psi (152 bar)

Brush or Roller Use natural bristle brush. For touch-up only. For roller application, use a lambs-wool roller with phenolic core. Two coats may be required to obtain proper film thickness.

Repair Procedure Small surface defects can be repaired by hand sanding. Small areas damaged to substrate require power sanding or grinding. In both cases, feather edge to surrounding coating, solvent wipe and touch-up with brush. Avoid rebrushing. Large damaged areas require reblasting or mechanical cleaning to original specifications, feather edging and reapplication of the original system.

Mixing & Thinning

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

	<u>5 Litre kit</u>
Part A	4 litre
Part B	1 litre

Thinning Thin as required up to 20% by volume with Phenoline Thinner. Amount of thinner will vary depending on weather conditions.

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 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	N/A
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.

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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 Primer	<u>5 Litre kit</u> 7.9kg
	Phenoline Thinner	4.8kg
Flash Point (Pensky Martens Closed Cup)	Part A	36°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.



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