

## Selection & Specification Data

<b>Generic Type</b>	Polyamine cured, modified epoxy phenolic
<b>Description</b>	High solids epoxy lining with exceptional chemical resistance. Primarily as a tank lining, it is recommended for storage of crude oil (180°F/82°C), demineralized water (150°F/65°C), food and beverage industries, ethanol, and water and wastewater exposures. Is excellent as a protective coating under insulation, operating at (400°F/204°C). Outstanding resistance to wet/dry cycling conditions at these elevated temperatures.
<b>Features</b>	<ul style="list-style-type: none"> <li>▪ High solids; Low VOC formula</li> <li>▪ VOC compliant to current AIM regulations</li> <li>▪ Excellent overall chemical resistance</li> <li>▪ Excellent for crude-oil storage</li> <li>▪ Excellent resistance up to 400°F(204°C)</li> <li>▪ Excellent abrasion &amp; thermal shock resistance</li> <li>▪ Meets the FDA requirements for 21CFR 175.300 for direct food contact.</li> </ul>
<b>Colors</b>	Red (0500), Gray (0700); White (0800)
<b>Finish</b>	Semi-gloss
<b>Dry Film Thickness</b>	8.0-12.0 mils (200-300µ)
<b>Solids Content</b>	By Volume: 84% ± 2%
<b>Theoretical Coverage Rate</b>	1347mil ft <sup>2</sup> (32.5 m <sup>2</sup> /l at 25 µ) For estimating purposes, 120sq. ft. /gal. will produce a 9 mil (225 µ) film (20% loss included). Allow for loss in mixing and application
<b>VOC Values</b>	As supplied: 1.00 lbs/gal (119 g/l) Thinned: 25 oz/gal w/ #2: 1.96 lbs/gal (235 g/l) Thinned: 25 oz/gal w/ #76: 1.96 lbs/gal (235 g/l) These are nominal values and may vary slightly with color.
<b>Under Insulation Resistance</b>	Continuous: 400°F(204°C) Discoloration occurs above 200°F(93°C) but does not affect performance.
<b>Immersion Temperature Resistance</b>	Immersion temperature resistance depends upon exposure. Consult Carboline Technical Service for specific information.

## Substrates & Surface Preparation

<b>General</b>	Remove any oil or grease from surface to be coated in accordance with SSPC-SP1.
<b>Steel</b>	SSPC-SP10; Surface Profile: 1.5-3.0 mils (38-75 µ)
<b>Stainless Steel</b>	Profile should be dense angular 2.0-3.0 mils (50-75 µ). Remove all surface contaminants that would interfere with the performance of stainless steel for the intended service such as, but not limited to, imbedded iron or chlorides.

## Performance Data

Test	Method	Results
Abrasion	ASTM D4060 (CS17 Wheel, 1000 cycles, 1000 g load)	95 mg loss
Thermal Shock	5 cycles (-70°F to 200°F) (-57°C to 93°C)	Unaffected except for discoloration
Thermal Shock	3 cycles (-10°F to 410°F) (-23°C to 210°C)	Unaffected except for discoloration

### Immersion Data

Cargo	Method	Results
Crude Oil (180°F/82°C),	Modified NACE TM0174 Procedure B	Unaffected
Jet Fuel (150°F/65°C)	Modified NACE TM0174 Procedure B	Unaffected
Diesel (150°F/65°C)	Modified NACE TM0174 Procedure B	Unaffected
Ethyl Alcohol	1 year immersion 100°F (38°C)	Unaffected
Citric Acid 50%	1 year immersion 100°F (38°C)	Unaffected
Corn Syrup	1 year immersion 180°F (82°C)	Unaffected

## Application Equipment

**Conventional Spray** Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap. Adjust air pressure to approximately 50 psi at the gun and provide 10-20 lbs. of pot pressure.

**Airless Spray** Pump Ratio: 30:1 (min.)  
GPM Output: 2.5 (min.)  
Material Hose: 3/8" I.D. (min.)  
Tip Size: .017"-.021"  
Output PSI: 1500-2300  
Filter Size: 60 mesh  
Teflon packings are recommended

### Apply a "mist" bonding pass.

Allow to dry approximately one minute but not long enough to allow film to completely dry. Apply crisscross multi-passes, moving gun at fairly rapid rate, maintaining a wet appearing film. Fast multi-passes may be applied until you have a film thickness of approximately 4-6 mil (100-150 µ) (approximately 5-7 wet mil (125-175 µ)). Repeat this procedure for the second coat to obtain an 8-12 mil (200-300 µ) DFT. Call Tech. Service for Q&A

**Brush** Use medium bristle brush. Not recommended for tank lining applications except when striping welds. Avoid excessive re-brushing for best results.

**Roller** Not recommended for tank lining applications except when striping welds. Use a short-nap synthetic roller with phenolic core.

# Phenoline® 187 VOC

## Mixing & Thinning

<b>Mixing</b>	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS. Requires short 15 min sweat-in time.
<b>Ratio</b>	2:1 Ratio (A to B)
<b>Thinning</b>	Thinning will be required to properly atomize the mixed material. Thin up to 20% (25 oz/gal) with Thinner #2 or Thinner #76 (cooler conditions). Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
<b>Pot Life</b>	1 Hour at 75°F (24°C), 2 Hours at 60°F (15°C); less at higher temperatures. Pot life ends when coating loses body and begins to sag.

## Cleanup & Safety

<b>Cleanup</b>	Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	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.
<b>Ventilation</b>	When used as a tank lining or 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 insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.
<b>Caution</b>	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.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	90°F (32°C)	125°F (52°C)	110°F (43°C)	80%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

## Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Recoat	Final Cure for Immersion Service	Maximum Recoat Time
50°F (10°C)	36 Hours	14 Days	30 days
60°F (16°C)	24 Hours	10 Days	21 days
75°F (24°C)	12 Hours	7 Days	14 days
90°F (32°C)	6 Hours	5 Days	7 days

These times are based on a 4.0-6.0 mil (100-150 µ) dry film thickness. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats.

Food-grade exposures require force curing at 225°F (107°) for four hours. Raise temperature 30°F (17°C) for every 30 minutes until temperature is reached. (Other curing temperatures in table below)

METAL TEMPERATURE	CURING TIME
150°F/66°C	12 Hrs
175°F/79°C	10 Hrs
200°F/93°C	6 Hrs
225°F/107°C	4 Hrs

## Packaging, Handling & Storage

<b>Shipping Weight (Approximate)</b>	<u>1 Gallon Kit</u> 15 lbs (6.8 kg)	<u>5 Gallon Kit</u> 75 lbs (34 kg)
<b>Flash Point (Setflash)</b>	Part A: 24°F (-4.5°C) Part B: 41°F (5°C)	
<b>Storage (General)</b>	Store Indoors.	
<b>Storage Temperature &amp; Humidity</b>	40° - 110°F (4° - 43°C) 0-100% Relative Humidity	
<b>Shelf Life</b>	Part A: Min. 12 months at 75°F (24°C) Part B: Min. 6 months at 75°F (24°C)	

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

  
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