



ESTABLISHED 1935

## TECHNICAL BULLETIN

### EP-6308

January 2009

# EP-6308 Epoxy Phenolic Coating

**GENERIC TYPE:** Baking cross-linked epoxy-phenolic.

**RECOMMENDED USAGE:** HERESITE EP-6308 coating is a high performance coating capable of providing economical protection in severe and chemically corrosive environments. It is formulated explicitly for sustained immersion for tank linings, heat transfer equipment, spiral heat exchangers, fans, blowers, filter plates, tank cars, tank trailers, duct work, exhaust hoods, and other industrial equipment.

EP-6308 meets the requirements of the 21 CFR 75.300. FDA for direct food contact.

#### CHEMICAL RESISTANCE GUIDE:

<u>Exposure</u>	<u>Immersion</u>	<u>Splash &amp; Spillage</u>
Acids	Good	Excellent
Alkalies	Excellent	Excellent
Solvents	Fair	Good
Inorganic Salts	Excellent	Excellent
Water	Excellent	Excellent

#### ORDERING INFORMATION:

##### Shipping Weight:

EP-6308      Approx. 10 lbs./gal.  
S-330 Solvent      Approx. 8 lbs./gal.

#### Flashpoint (T.C.C):

EP-6308      23°F (-5°C)  
S-330 Solvent      23°F (-5°C)

#### PHYSICAL DATA:

V.O.C.: 3.6 lbs. / gal. as supplied  
Solid by Wt.:      Approx. 62%  
Solid by Vol.:      Approx. 49%

Pot life:      N/A

Shelf life: 12 months @ 70°F (21°C)

Viscosity: 75-85 K.U. (Krebs Units)

**TEMPERATURE LIMITATION:** HERESITE EP-6308 accepts dry heat temperatures up to 400°F (204°C). Short excursions up to 450°F (232°C) will be tolerated.

**Direct Impact (ASTM D-2794):** 10 inch / lbs.

**Adhesion (ASTM D-3359):** 5

**STANDARD COLOR:** EP-6308 Tan

**COVERAGE:** Theoretical coverage - 784 square foot per gallon per mil. Recommended total dry film thickness is 5.0 to 7.0 mils in a 3-4 coat system.

At 6 mils DFT average coverage would be 105 square feet per gallon. This includes a 20% loss factor.

**APPLICATION INSTRUCTIONS**

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

**CAUTION:** CONTAINS FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIR LINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRICAL EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.

**SURFACE PREPARATION:** Remove all oil, grease and other contaminants with an appropriate solvent, such as Heresite S-330.

**STEEL:** Surface profile or anchor pattern shall be 20-25% of the recommended dry film thickness.

**IMMERSION:** A white metal blast is required in accordance with NACE #1 or SSPC-5 specifications.

**NON-IMMERSION:** A commercial blast is acceptable in accordance with NACE # 3 or SSPC-6 specifications

**PRIMER:** Not required.

**MIXING:** Mix thoroughly; making sure all settled pigments are re-dispersed.

**THINNER & CLEAN UP SOLVENT:** Heresite S-330 Solvent.

**THINNING:** The amount of thinner required is dependent upon temperature, ventilation, humidity; spray equipment used, and desired film thickness. Adjust viscosity to 30 to 40 Zahn Cup #2. Suggested thinning is 30-40% at 75°F (24°C).

**BAKE SCHEDULE:**

<b><u>Intermediate Bake</u></b>	<b><u>Surfaces</u></b>
Normal	200°F-250°F (93°C-121°C) For 10-20 min.

<b><u>Final Bake</u></b>	<b><u>Surfaces</u></b>
Minimum	400°F (205°C) for 1 hr.

**APPLICATION:**

1. Do not apply if temperature is less than 5°F (2°C) above dewpoint, or if temperature is below 45°F (7°C).
2. All spray equipment shall be thoroughly cleaned and the hoses in particular shall be free of old paint film and other contaminants.
3. Use standard production type spray guns. Airless spray equipment, 1800-2200 PSI liquid pressure. Tip size from .013" to .019".
4. Air supply shall be uncontaminated. Adjust air pressure to approximately 80 lbs. at the gun and provide 15-20 lbs. pot pressure. Adjust spray gun by first opening liquid valve and then adjust air valve to give approximately an 8" to 12" fan holding gun perpendicular to the surface at a distance of 12".
5. Apply a mist bonding pass. Allow to flash off for several minutes but not long enough to allow film to completely dry.
6. Apply 3-4 criss-cross multi-passes maintaining a wet appearing film approximately 3-4 mils. Wet film thickness equals 1.5-2.0 mils dry film thickness.
7. Air dry approximately 1 hour with ventilation, prior to introducing heat.
8. After the air dry period has elapsed, the temperature should be raised approximately 40°F (22°C) in increments of 30 minutes until the desired temperature is reached.

**RECOAT:** After intermediate bake has cooled to 70°F (21°C).

**STORAGE CONDITIONS:** Coating should not be stored longer than 12 months at 70°F (21°C).

To the best of our knowledge the technical data contained herein are true and accurate at the date of issuance and are subject to change without prior notice. No guarantee of accuracy is given or implied. We guarantee our products to conform to strict quality control. We assume no responsibility for coverage, performance or injuries resulting from use. Liability, if any, is limited to replacement of products. Prices are subject to change without prior notice. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY THE SELLER, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.