



ESTABLISHED 1935

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TECHNICAL BULLETIN

L-66L

January 2009

L-66L Clear Baked Phenolic Coating

GENERIC TYPE: Baking Phenolic

RECOMMENDED USAGE: HERESITE L-66L baking phenolic coating offers consistent, high-quality service in a wide range of applications in immersion service for most acids, solvents, and salts.

Typically HERESITE L-66L is used over HERESITE P-403L brown baking phenolic coating to provide improved release properties and/or prevent some products from contracting the pigment of the HERESITE P-403L brown coating. HERESITE L-66L is also used as an electrical insulator.

Applications include: tank linings, fans blowers filter plates, tank car, tank trailers, duct work, exhaust hoods, and other industrial equipment.

Heresite L-66L meets the requirements of FDA 21 CFR 175.300 for direct food contact.

CHEMICAL RESISTANCE GUIDE:

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

ORDERING INFORMATION:

Shipping Weight:

L-66-L - Approx. 10 lbs. /gal.
 S-215 Solvent - Approx. 7 lbs./gal.
 S-217 Solvent - Approx. 7 lbs. /gal.
 S-276 Solvent - Approx. 7 lbs. /gal.

Flashpoint (T.C.C):

L-66L – 62° (17°C)
 S-215 Solvent – 62°F (17°C)
 S-127 Solvent – 62°F (17°C)
 S-276 Solvent – 84°F (29°C)

PHYSICAL DATA:

Solid by wt: approx. 57%
 Solid by vol: approx. 56%
 Pot life: N/A
 Shelf life: 4 months @ 70°F (21°C)

ABRASION RESISTANCE: A 43 mg loss is observed with a CS-17F wheel and 1000 g weight after 1000 cycles.

TEMPERATURE LIMITATION: HERESITE L-66L accepts dry heat temperatures up to 400°F (204°C)

VOC: 2.1 lbs. /gal. as supplied

STANDARD COLOR: Amber

COVERAGE: Theoretical coverage - 896 sq. ft. per gallon per mil. Recommended total dry film thickness is 1.5-2.0 mils in a 1 to 2 coat system. (at 1.5 mils DFT, average coverage would be 478 sq. ft. 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 from the surface with an appropriate solvent

STEEL:

IMMERSION: A white metal blast is required in accordance with NACE #1 or SSPC-SP-6-63 specifications.

NON-IMMERSION: A commercial blast is acceptable in accordance with NACE #3 or SSPC-SP-6-63 specifications.

PRIMER: Normally L-66L is used as a top coat over HERESITE P-403L brown baking phenolic coating. L-66L may be used without a primer.

THINNER: Under normal conditions we recommend use of Heresite S-217 solvent. In hot weather or open rooms we suggest Heresite S-276. In confined spaces or cooler weather, use Heresite S-215.

THINNING: The type and amount of thinner required is dependent upon temperature, ventilation, humidity, spray equipment used and desired film thickness. Suggested thinning at 75°F (24°C) is 20-30%.

MIXING: Mix thoroughly and adjust viscosity per manufacturer's recommendations. (Approximately 20 seconds with a Zahn #2 cup at 72°F or 15 seconds with a Ford #4 at 72°F)

APPLICATION:

1. Do not apply if temperature is less than 5°F (2°C) above dewpoint.
2. All spray equipment shall be thoroughly cleaned and the hoses in particular shall be free of old paint and contaminants.
3. Use standard production type spray guns, conventional or airless.

Airless spray equipment: 1800-2200 PSI liquid pressure. Tip size from .013"-.019". Thinning requirements are more than for conventional spray.

4. Air supply shall be uncontaminated. Adjust air pressure to approx. 50 to 70 lbs. at the gun and provide 15-20# pot pressure. Adjust spray gun by first opening liquid valve and then adjust air valve to give approx. an 8"-12" fan, holding gun perpendicular to the surface at a distance of 12".
5. Apply a mist bonding pass.
6. Allow to flash off for several minutes, but not long enough to allow film to completely dry.
7. Apply 3-4 criss-cross multi-passes maintaining a wet appearing film.
8. Air dry with ventilation prior to introducing heat.
9. After the air dry period has elapsed, the temperature should be raised approx. 40°F (22°C) in increments of 30 mins, until the desired temperature is reached.

BAKE SCHEDULE

Intermediate Bake Surfaces

Normal 175°F-200°F (93°C) for 10-20 minutes.

10. After cooling to 70-90°F, repeat Steps 7-9 until desired DFT is obtained. Holiday test and repair if required. Final cure is done by raising the temperature in increments of 40°F (22°C) every 30 minutes until the desired temperature is reached.

<u>Final Bake</u>	<u>Surfaces</u>
Normal	400°F (204°C) 1.5 hr

CLEAN UP: Use HERESITE S-215

STORAGE CONDITIONS: Coating should not be stored longer than 4 months at 70°F (21°C).

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