



ESTABLISHED 1935

TECHNICAL BULLETIN P-413

November 2008

P-413 Baked Phenolic Coating

GENERIC TYPE: Baking Phenolic

Pot life: N/A

Shelf life: 6 months @ 70°F (21°C)

RECOMMENDED USAGE: HERESITE P-413 is a high performance coating used principally for products fabricated of light gauge metal and in those instances where thorough metal preparation such as blasting cannot be performed. The flexibility and corrosion resistance of HERESITE P-413 appreciably increases service life of equipment.

VISCOSITY: 80 K.U. (Kreb Units)

ABRASION RESISTANCE: A 30 mg loss is observed with a CS-17F wheel and 1000 g weight after 1000 cycles.

Some uses of this coating are: fan guard castings, replacement of critical metals in sea exposure and other related equipment.

TEMPERATURE LIMITATION: HERESITE P-413 accepts dry heat temperatures up to 400°F (205°C)

Specially formulated HERESITE P-413 coating is suitable for pail and drum application in a wide variety of services.

VOC: 3.3 lbs./gal. as supplied.

STANDARD COLOR: Brown, semi-gloss

CHEMICAL RESISTANCE GUIDE:

<u>Exposure</u>	<u>Immersion</u>	<u>Fumes</u>
Acids	Good	Excellent
Solvents	Excellent	Excellent
Inorganic Salts	Good	Excellent
Water	Excellent	Excellent

COVERAGE: Theoretical coverage - 578 mil. Sq ft per gallon. Recommended dry film thickness is 4.0 to 6.0 mils in a 4 to 5 coat system.

ORDERING INFORMATION:

Shipping Weight:

P-413	Approx. 12 lbs./gal.
S-215 Solvent	Approx. 7 lbs./gal.

PHYSICAL DATA:

Solid by wt: approx. 60%

Solid by vol: approx. 36%

Flashpoints (T.C.C):

P-413	62°F (17°C)
S-215 Solvent	62°F (17°C)

APPLICATION INSTRUCTION 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 or detergent.

STEEL:

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

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

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

PRIMER: When surface preparation is marginal the use of HERESITE P-700 primer is recommended.

THINNER: Recommend use of HERESITE S-215 solvent.

THINNING: The 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%. Adjust viscosity to 30 sec. Ford Cup #4.

MIXING: Mix thoroughly and adjust viscosity per manufacture's recommendations.

BAKE SCHEDULE

<u>Intermediate Bake</u>	<u>Surfaces</u>
Normal	175°F (79°C) to 250°F
	200°F (93°C) for 10 - 20 min.

<u>Final Bake</u>	<u>Surfaces</u>
Normal	400°F (204°C) 1-1½hr

Do not apply if temperature is less than 5°F (2°C) above dewpoint.

APPLICATION:

All spray equipment shall be thoroughly cleaned and the hoses in particular shall be free of old paint film and other contaminants.

2. Use standard production type spray guns:

Airless spray equipment: 1500-1800 PSI liquid pressure. Tip size from .015"-.019". Thinning requirements are less than for conventional spray applications.

3. Air supply shall be uncontaminated. Adjust air pressure to approx. 50 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".

4. Apply a mist bonding pass.

5. 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.

7. Air dry with ventilation 30 minutes, prior to introducing heat.

8. After the air dry period has elapsed, the temperature should be raised approx. 40°F (22°C) in increments of 30 minutes until the desired temperature is reached.

CLEAN UP: Use HERESITE S-215 solvent.
STORAGE CONDITIONS: Coating should not be stored longer than 6 months at 70°F (21°C). Cans should be turned upside down every 3 months.

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