

# Heresite L-66L

## Our 50 years of coating history speaks for itself.

In 1964, Heresite was the first company to apply coatings to aluminum-finned, copper-tubed heat exchangers. The Heresite coating became then, and still remains a standard in the industrial coatings industry. We provide the highest quality protective coatings to protect components that operate in moderate to severely corrosive environments, including both coastal and/or industrial applications.

## A high performance baked phenolic coating.

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

## Product Description

Baking Phenolic

## Recommended Uses

Typically, Heresite L-66L is used over Heresite P-403L brown baking phenolic coating. It provides improved release properties and/or prevent some products from contacting the pigment of Heresite P-403L brown coating. Heresite L-66L is also used as an electrical insulator.

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

## Chemical Resistance

L-66L is chemically resistant to a wide range of acids, solvents, and salts. Please review chemical resistance guide for further information.

## Temperature Limitation

Heresite L-66L accepts dry heat temperatures up to 400°F (204°C)

## Packaging Information

L-66L series is available in one gallon, five gallon and 54 gallon drum quantities.

## Thinners and Cleanup

Recommended use of Heresite S-275

## Storage Conditions

Coating should not be stored longer than 6 months. Coating should be stored in a clean, dry environment at 50-75°F. Keep out of direct sunlight. Avoid excessive heat and keep from freezing.



### Physical Properties

Solids by weight: Approximately 30%  
Solids by volume: Approximately 22%  
Induction Time: NA  
Mixing Ratio by Volume: NA  
Color: Clear

### VOC Content

5.42 lbs/gal (649 g/L) as supplied

### Film Thickness

As a topcoat for P-403L:  
Recommended total dry film thickness (DFT) is 1.5 to 3.0 mils (38 – 75 microns) in a 1 to 3 coat system.

### Coverage

Theoretical coverage is approximately 362 square feet per gallon per dry mil. Coverage rates are estimates and make no allowance for material loss. Actual rates will vary dependent on application method, surfaces, etc.

### Surface Preparation

All surfaces must be clean, sound, and free of any oils, dirt, grease, wax and any other contamination that may interfere with coating adhesion. For best results all bare surfaces must be properly prepared prior to application of this product.

If applying to bare steel, it is recommended to commercially blast in accordance with NACE #1 or SSPC-SP-5 specifications. Surface profile or anchor pattern shall be 20-25% of the recommended dry film thickness.

If applying as a topcoat over P-403L, ensure P-403L has undergone an intermediate bake prior to applying L-66L (see P-403L TDS for further application instructions).

### Thinning

L-66L is provided at spray viscosity for most applications. If additional adjustments are needed, reduce with Heresite S-275.

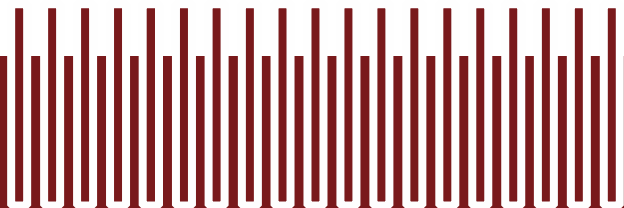
The amount of thinner required is dependent upon temperature, ventilation, humidity, application type and desired film thickness.

### Spray Application

1. Consult SDS prior to use.
2. Do not apply if temperature is less than 5°F above dew point, or if temperature is below 45°F.
3. Use standard production type spray equipment (conventional, HVLP, airless, etc.). A few starting recommendations can be found below:

Guns	Fluid	Air
DeVilbiss JGA-510	E	46MP
Binks #2100	67-SS	46-21MD-2 or 3
Binks #95	66-SS	66-SD

Graco Air Pro HVLP  
Airless spray equipment, 1500-1800 psi liquid pressure.  
Tip size from 0.013" to 0.018".
4. Spray viscosity will be dependent on type of equipment being used. It has been seen that spraying at dip viscosity is very effective.
5. Spray equipment: always flush spray equipment with solvent to clean prior to applying coating.
6. Air supply must be uncontaminated. Adjust air pressure to approximately 80 pounds at the gun and provide 15-20 pounds at pressure pot. Adjust spray gun by first opening liquid valve and then adjust air valve to give approximately an 8"-12" fan, holding gun perpendicular to the surface at a distance of 12".
7. Apply a mist bonding pass.
8. Allow to flash off for approximately a minute, but not long enough to allow film to completely dry.



9. Apply 3-4 crisscross multi-passes maintaining a wet appearing film approximately 2-4 wet mils. This will achieve a dry film thickness of approximately 0.5-1.5 mils.
10. Air dry a minimum of 60 minutes with ventilation prior to introducing heat.
11. Typically, a one to three coat process is required to achieve 1.5 to 3.0 mil DFT. An intermediate bake is required between each coat, allowing to cool to room temperature before next coat is applied – see baking schedule.

### Bake Schedule

#### Intermediate Bake:

1. 90°C (metal temperature) held for 15 minutes

#### Final Bake:

For Maximum Chemical Resistance:

1. Starting from room temperature, the temperature should then be raised approximately 22°C (30°F) in increments of 30 minutes until 204°C has been reached. Hold 204°C (metal temperature) for 90 minutes.
2. To determine correct bake, saturate a cloth with S-275, rub coating lightly. Coating should wipe off between coats, but should not after final bake (cure).

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 WORKERS MUST WEAR FRESH AIR LINE RESPIRATORS. 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, WORKMERS SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.**

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