

CORCHEM[®] 203 HIGH BAKE PHENOLIC

GENERIC	Advanced technology, thermosetting densely cross-linked, reactive phenolic resin. The polymer structure is non-toxic, extremely chemically inert with a high heat deflection temperature.
DESCRIPTION	Heavy-duty bake phenolic coating to provide outstanding elevated temperature protection for surfaces in severe chemical and physical environments. It is formulated to be extremely adhesive, hard, tough and abrasion resistant. The cured film (free of solvents) conforms to Title 21 CFR 175.300 United States Food & Drug Administration and United States Department of Agriculture requirements for coatings in contact with food.
USE	Heat transfer equipment, fans, blowers, gas and vapor transfer duct work and exhaust hoods. Steel storage vessels, piping and processing equipment, handling drinking water and food products such as animal and vegetable oils, dairy products, wines, fruit juices and beverages. As well as petroleum ingredients such as sour crude, industrial waste and brine waters and water solutions containing salts, detergents, many acids, and other chemicals. Provides a high degree of protection for steel against corrosive moisture, fumes, carbon dioxide, hydrogen sulfide and methane gases. Also resistant to petroleum products such as kerosene, diesel, gasoline, aviation fuels, motor oils, lubrication materials, greases, hydraulic fluids, alcohols, aliphatic and aromatic hydrocarbon solvents. The principal use is in food contact problem areas such as agriculture and food handling facilities and in chemical problem areas such as oil field production, chemical manufacturing and power generating plants.
SERVICE LIMITATIONS	Temperature resistance up to 450°F depending upon the individual exposure. CONTACT CORCHEM [®] FOR SPECIFIC RECOMMENDATIONS BEFORE PROCEEDING for immersion service and exposure to corrosive chemicals, elevated temperatures and/or pressures, or use with cathodic protection systems. Avoid sudden depressurization of lining. NOTE: Exterior insulation of tanks, vessels and processing equipment is recommended to prevent "cold wall effect" if interior lining is subject to elevated temperatures.
COLORS	Tan (Off-White).
FINISH	Medium Gloss.
CAUTION!	Color and gloss variation may occur due to different heat/dry time cure cycles used. Color and gloss retention may be affected (yellowing, darkening and/or flattening) by exposure to elevated temperatures. Chalking will occur with extended exposure to sunlight.
VOLUME SOLIDS	41%
DRY COVERAGE	Theoretical (no loss): 656 sq. ft. per gallon for one mil (.001). When computing coverage allow for application loss and surface irregularities.

DRY FILM THICKNESS 1.0 to 2.0 mils per coat. Three or more coats to a dry film thickness of 5.0 to 7.0 mils. Multiple applications are recommended and may be necessary to achieve the specified or desired film thickness or due to variations in design configurations, application equipment, temperature and other factors.

COMPONENTS Two. By volume 1 to 1 (Base:Activator).

POT LIFE 8 hour @ 70°F (one gallon mixed quantity). Pot life is significantly shorter for higher temperatures or larger quantities and longer for lower temperatures or smaller quantities.

VOC CONTENT 500 gms/l or 4.2 lbs/gal. Conforms to United States National Volatile Organic Emission Standards.

THINNER CORCHEM® 8. Thin only as required for proper application. Do not exceed applicable volatile organic compound (VOC) regulations. Thinner added:

05% - 522 gms/lit or 4.35 lbs/gal	10% - 539 gms/lit or 4.49 lbs/gal
15% - 554 gms/lit or 4.62 lbs/gal	20% - 570 gms/lit or 4.75 lbs/gal

APPLICATION METHODS Air or airless spray and brush (small areas).

TEMPERATURES Apply at 40°F to 125°F (Air and Surfaces) and 5°F above the dew point. Sudden and/or substantial temperature change during in-service conditions can cause film defects.

CURING TIME Air dry with continuous ventilation for 1 hour minimum and until flash off/curing time necessary to prevent blistering and defects is achieved, then gradually raise the temperature until the coated surfaces reach 175°F to 200°F for a period of 15 minutes. **CAUTION!** Over-baking between coats will result in loss of adhesion. Allow the coated surfaces to cool and then repeat each of the above application procedures until the desired total dry film thickness is obtained. Recoat when material is relatively dry and firm, but before coating reaches complete cure and hardness (refer to RECOAT AND REPAIR Section if coating reaches complete cure and hardness). Curing times are significantly shorter for higher temperatures or lower thickness and longer for lower temperatures or higher thickness. Curing times are affected by the method of application; the quantity of thinner used; the amount of ventilation and air circulation; relative humidity; etc.

After the final coat has been applied, allow the minimum flash off/curing time necessary to prevent blistering and defects, then gradually raise the temperature not more than 50°F every 30 minutes until the substrate reaches 375°F to 400°F and bake for 1.5 hours.

NOTICE! Heat curing is required for this product. Contact CORCHEM® for additional instructions and heat cure times.

PACKAGING 2 gallon and 10 gallon premeasured packaged kits.

SHELF LIFE 6 months from shipment date protected between 40°F and 100°F.

DOT/FLASH POINT Flammable Liquid Classification.

PERFORMANCE DATA	Contact CORCHEM® for desired information.
SURFACE PREPARATION	All seams and joints of tanks and vessels must have continuous interior welds. Skip welds should be solid welded. Round off sharp edges and rough welds. Burrs and weld spatter should be completely removed. Eliminate pits and cavities by grinding or repair welding. Pre-bake and decontamination of used tanks is suggested. Perform substrate repair and degrease surfaces before abrasive blasting. Surfaces must be clean, dry and free of any dirt, chalk, grease, oils, salts, and deleterious materials before application is performed. Vacuum the topside of all horizontal and sloped surfaces.
CARBON STEEL	Immersion or Severe Exposures: SSPC-SP-5 (White Metal Blast Cleaning). Metal surfaces should have an anchor profile of 1.0 to 1.5 mils.
WELDING	Welding should precede coating. If already coated, follow instructions in U.S.A. Standard Z49.1 Safety in Welding and Cutting.
APPLICATION MIXING	All equipment should be cleaned and flushed with CORCHEM® 8 THINNER. Add Component A into Component B. Do not vary proportions. Power stir, until completely mixed and continue agitation during application. Strain only if required for proper application. <u>Do not allow catalyzed material to stand in equipment after use!</u> Clean immediately with CORCHEM® 8 THINNER.
APPLY	A thin or mist coat, allow the material to flash off several minutes but not dry completely, then apply crisscross multiple passes to produce an even wet coat to achieve a dry film thickness of 1.0 to 2.0 mils. Ensure seams and irregularities are completely covered. Application below minimum or above maximum suggested dry film thickness ranges might adversely affect performance.
RECOAT AND REPAIR	If material has reached complete cure and hardness, uniformly abrade the surface and feather the edges. The surface must be roughened sufficiently to provide a profile adequate to insure a mechanical bond. The use of CORCHEM® 11 ADHESION PROMOTER may be desired.
INSPECTION	Check for desired dry film thickness and for pinholes, holidays, bare areas, etc. <u>If subject to contact with food or potable water, disinfect the fully-cured-coated surface. All solvent vapors must be completely removed before placing in operating service.</u>
AIRLESS SPRAY	Graco or equal. Pump ratio 30:1 or higher, 206-718 gun with fluid tip of .015" or larger orifice size with Reverse-A-Clean tip, 3/8" I.D. or larger high-pressure solvent resistant fluid line, 1/2" I.D. or larger air supply line. Continuous air source capable of 80 to 100 psi inbound pressure at pump.
CONVENTIONAL SPRAY	Binks or equal. Pressure material pot with mechanical agitator, dual regulators, air- gages, and oil and moisture separators. No. 2001 gun (external mix), 66 fluid nozzle, 565 fluid needle, 66 SD air cap, heavy- duty fluid spring, Teflon fluid packing, 1/2" I.D. or larger high solvent resistant fluid line and 3/8" I.D. or larger air-supply line. Continuous air source capable of 20 cfm or more at 80 psi per nozzle and 60 psi to the pot.
GENERAL	Regulate pressure as required for proper application. Proportionally adjust pressure higher for smaller hose diameter and/or longer hose length and adjust pressure lower for larger hose diameter and/or shorter hose length. Select tip angles and orifice diameters according to application needs.

BRUSH	Short hair or natural bristle.
CLOTHING	Wear protective garments, shoes, goggles, and filter masks. Use protective barrier creams on exposed skin areas.
TANKS & VESSELS	Use explosion-proof lighting and electrical equipment, non-sparking tools, clothes and shoes. Ground all structures and equipment. Use procedures that prevent static electrical sparks. Wear properly fitted appropriate NIOSH/MSHA approved fresh air respirator such as MSA or equal with 1/4" I.D. or larger air supply line connected directly to proper air source during and after application unless air monitoring demonstrates vapor/mist levels are within safe limits. Use suction type exhaust fans and blowers with sufficient cfm capacity to keep solvent vapors below 20% of the explosive limit. CAUTION! Air circulation and exhausting of solvent vapors must be continued until the coatings have fully cured to insure that no potential for fire, explosion or health hazard remains.

SAFETY INFORMATION

THIS PRODUCT CONTAINS ALCOHOLS, ESTERS, KETONES, PETROLEUM DISTILLATES AND PHENOLIC RESINS. DO NOT USE IF YOU HAVE HAD A REACTION TO THESE MATERIALS.

WARNING! FLAMMABLE! VAPOR HARMFUL! CAUSES SEVERE EYE AND SKIN BURNS. MAY CAUSE SKIN SENSITIZATION OR OTHER ALLERGIC RESPONSES. HARMFUL OR FATAL IF SWALLOWED!

Keep away from heat, sparks, and open flame. Use only with adequate ventilation. Prevent breathing of vapor or spray mists. Wear a properly fitted appropriate respirator during application and until all vapors and spray mists are gone. Prevent contact with eyes and skin. Do not take internally. Keep closures tight and upright to prevent leakage. Keep container closed when not in use. In case of spillage, absorb and dispose of in accordance with local applicable regulations. **FIRST AID:** In case of skin contact, wash thoroughly with soap and water; for eyes, flush immediately with plenty of water for 15 minutes and call a physician. Remove and wash contaminated clothing before reuse. (Discard contaminated shoes). If inhaled, remove to fresh air. If breathing difficulty persists or occurs later, consult a physician and have label and MSDS information available. If swallowed, **CALL A PHYSICIAN IMMEDIATELY. DO NOT INDUCE VOMITING.**

IN CONFINED SPACES AND TANKS OBEY SPECIAL SAFETY AND EQUIPMENT INSTRUCTIONS!

FOR INDUSTRIAL USE BY PROFESSIONAL APPLICATORS ONLY. NOT INTENDED FOR SALE TO THE GENERAL PUBLIC. This product should not be sold or delivered to any person under 18 years of age. KEEP OUT OF THE REACH OF CHILDREN! IF, FOR ANY REASON, ADDITIONAL PRODUCT AND SAFETY INFORMATION, INSTRUCTIONS OR EXPLANATIONS ARE NEEDED, CONTACT CORCHEM® IMMEDIATELY!

LIMITED WARRANTY

WARRANTY & LIMITATION OF SELLER'S LIABILITY: CORCHEM® CORPORATION warrants only that its coatings represented herein meet the formulation standards of CORCHEM® CORPORATION.

THE ABOVE WARRANTY SHALL BE IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. THERE ARE NO WARRANTIES THAT EXTEND BEYOND THE DESCRIPTIONS ON THE FACE HEREOF.

The buyer's sole and exclusive remedy against CORCHEM® CORPORATION shall be for replacement of the product in the event, a defective condition of the product should be found to exist. NO OTHER REMEDY (INCLUDING, BUT NOT LIMITED TO, INCIDENTAL OR CONSEQUENTIAL DAMAGES FOR LOST PROFITS, LOST SALES, INJURY TO PERSON OR PROPERTY, OR ANY OTHER INCIDENTAL OR CONSEQUENTIAL LOSS) SHALL BE AVAILABLE TO THE BUYER. The sole purpose of this exclusive remedy shall be to provide buyer with replacement of the product if any defect in materials is found to exist. This exclusive remedy shall not be deemed to have failed its essential purpose so long as CORCHEM® CORPORATION is willing and able to replace the defective materials.

Technical and application information is provided for the purpose of establishing a general profile of the coating and proper coating application procedures. Test performance results were obtained in a controlled environment and CORCHEM® CORPORATION makes no claim these tests or any other tests, accurately represent all environments. As application, environmental and design factors can vary significantly, due care should be exercised in the selection and use of the coating.

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CONTACT YOUR CORCHEM® REPRESENTATIVE FOR CURRENT TECHNICAL DATA AND INSTRUCTIONS.

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