

RAILCAR COATINGS of AMERICA

THE RIGHT CHEMISTRY

AC99 HIGH BAKE PHENOLIC LINING

DESCRIPTION & USES

AC99 is a high performance, high bake phenolic coating with excellent chemical resistance to acids, solvents, inorganic salts and water, AC99 meets FDA 21 CFR 175.300

SURFACE PREPARATION

BLAST: NACE #1/SSPC-SP 5

PROFILE: Avg. depth 2.0 – 2.5 mils

APPLICATION SUMMARY*

EQUIPMENT: 45:1 ratio pump with 0.017(615) to 0.019 (619) inch diameter orifice for airless spray gun tip at a 1800 psi minimum fluid pressure at tip to obtain proper atomization.

REQUIRED CONDITIONS:

Noncontaminated profile
Dry, dust-free metal surface
Metal temperature above 60 F
Metal temperature 5 degrees above dew point
Ambient temperature above 50 F
Humidity less than 90%
Material temperature between 70 and 90 F

SAFETY: Consult MSDS for proper handling, cleanup, disposal and use of personal protective equipment before use.

***NOTE:** See detailed application instructions on separate sheet before application

PHYSICAL DATA

Finish -----Low semi-gloss
Color ----- Cream (changing to Dark Tan after baking)
A single component product
Volume Solids ----- 46% ±2 (mixed)
VOC ----- 2.99 lbs/gal (358 g/l) mixed
Flash Point ----- >73 °F
Recommended Wet Film Thickness ---- 5.4 –7.6 mils per coat (2 coats)
Dry Film Thickness ----- 2.5-3.5 mils per coat (2 coats) producing the recommended DFT of 5-7 mils
Theo. Coverage at Proper Thickness – 105-148 sq ft/gal
Thinner -----Not recommended but if necessary use TH334
Clean up Thinner-----TH334
Baking Schedule
First Coat-----30 minutes @ 225-250 °F (metal temperature)
***Over baking between coats will result in loss of Intercoat adhesion.**

Second Coat (Final Bake)-----1 ½ hours at a minimum of 375-400 °F (metal temperature)

Concentrated Sulfuric Acid requires a final bake at a minimum 400 °F

Final Bake Color -----Dark Tan (color standards available)

Storage Conditions --- Store between 50-75 °F under dry conditions out of direct sunlight. Do not freeze.

Shelf Life ----- 3 months in the original, unopened containers.

Consult MSDS before use

DISCLAIMER

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