



TECHNICAL BULLETIN  
P-413C  
October 2014  
P-413C Baked Phenolic Coating

GENERIC TYPE: Baking Phenolic

RECOMMENDED USAGE: HERESITE P-413C 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-413C appreciably increases service life of equipment.

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

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

CHEMICAL RESISTANCE GUIDE:

EXPOSURE	IMMERSION	SPLASH /SPILLAGE
Acids	Good	Excellent
Solvents	Excellent	Excellent
Inorganic Salts	Good	Excellent
Water	Excellent	Excellent

ORDERING INFORMATION:

Shipping Weight:

P-413C Approx. 11 lbs./gal.  
S-215 Solvent Approx. 7 lbs./gal.  
S-275 Solvent Approx. 6.6 lbs./gal.

Flashpoint (T.C.C):

P-413C 57°F (13.9°C)  
S-215 Solvent 62°F (17°C)  
S-275 Solvent 2°F (-17°C)

PHYSICAL DATA:

Solid by wt: approx. 71%  
Solid by vol: approx. 59%  
Pot life: N/A  
Shelf life: 6 months @ 70°F (21°C)

VISCOSITY: 65-75 K.U. (Kreb Units)

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

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

VOC: 2.71 lbs./gal. as supplied.

STANDARD COLOR: Brown, semi-gloss

COVERAGE: Theoretical coverage - 951 sq ft per gallon per dry mil. Recommended dry film thickness is 4 to 6 mils in a 4 to 5 coat system.

#### 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-5-63 specifications.

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

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

**THINNER:** Recommend use of HERESITE S-215 or S-200 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 10-30%. Consult current VOC regulations.

#### BAKE SCHEDULE

##### Intermediate Bake Surfaces

Normal 200-250°F(93-121°C) for 10-20 min.

##### Final Bake Surfaces

Normal 400°F(204°C) 1 to 1-1/2hrs

**Metal temp. must reach 400°F (204°C)**

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

#### APPLICATION:

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

Use standard production type spray guns:

<u>Guns</u>	<u>Fluid</u>	<u>Air</u>
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 .015"-.019". Thinning requirements are more than for conventional spray.

- 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".
- Apply a mist bonding pass.
- Allow to flash off for several minutes, but not long enough to allow film to completely dry.
- Apply 3-4 criss-cross multi-passes maintaining a wet appearing film.
- Air dry with ventilation, prior to introducing heat.
- 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.

**CLEAN UP:** Use HERESITE S-215 or S-200 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 .