

## SELECTION & SPECIFICATION DATA

|                                   |  |
|-----------------------------------|--|
| <b>Generic Type</b>               | Two pack ultra-modern hybrid-resin based ceramic composite coating.  |
| <b>Description</b>                | Plasite 4660 provides outstanding chemical resistance, abrasion and corrosion protection to a wide variety of steel and concrete substrates in aggressive environments at elevated temperatures. It's application range includes internal coating for storage tanks for crude oil, hydrocarbons, chemicals and process & pressure vessels of all kinds. Approved for use in potable water tanks at temp. up to 85°C. |
| <b>Features</b>                   | <ul style="list-style-type: none"> <li>• Solvent free</li> <li>• Excellent chemical resistance</li> <li>• High abrasion resistance</li> <li>• Short curing times</li> <li>• 1-layer-system</li> </ul>  |
| <b>Color</b>                      | <p>Grey</p> <p>Other colors can be available on request</p>  |
| <b>Wet Film Thickness</b>         | <p>300 - 1000 µm per coat.</p> <p>Number of coats depending on specification.</p> <p>Maximum sagging limit. 1,0 mm per layer (at 20 °C).</p>   |
| <b>Dry Film Thickness</b>         | <p>300-1000 µm per coat.</p> <p>Number of coats depending on specification.</p>  |
| <b>Solid(s) Content</b>           | By volume: 100 ± 2%  |
| <b>Theoretical Coverage Rates</b> | <p>At 500 µm: 0,82 kg/m<sup>2</sup> (1.22 m<sup>2</sup>/kg) &lt;&gt; (2 m<sup>2</sup>/l)</p> <p>At 1000 µm: 1,64 kg/m<sup>2</sup> (0.61 m<sup>2</sup>/kg) &lt;&gt; (1 m<sup>2</sup>/l)</p>   |
| <b>VOC Values</b>                 | <b>As Supplied</b> : 0 g/l   |
| <b>Chemical Resistance Tables</b> | Excellent.   |
| <b>Abrasion Resistance</b>        | <65 mg loss (ASTM D4060)   |

## SUBSTRATES & SURFACE PREPARATION

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|----------------|--|
| <b>General</b> | Surface must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. |
| <b>Steel</b>   | Blast clean to min. Sa 2½ (ISO 8501-1) with a good profile of 50 – 100 µm roughness.   |

## PERFORMANCE DATA

**All test data was generated under laboratory conditions. Field testing results may vary.**

|                 |                                   |
|-----------------|-----------------------------------|
| <b>Adhesion</b> | > 27 N/mm <sup>2</sup> (ISO 4624) |
|-----------------|-----------------------------------|

# Plasite 4660

PRODUCT DATA SHEET



## MIXING & THINNING

|                 |  |
|-----------------|--|
| <b>Mixing</b>   | Part A (base) to be mixed thoroughly with part B (hardener).<br>Mixing time: Part A – premix 4 minutes; then Part A+B – mix 2 minutes; mixer cycles > 100 rpm. |
| <b>Thinning</b> | Thinners shall not be used   |
| <b>Ratio</b>    | Part A : Part B = 10 : 1 by weight (6.1 : 1 by volume)   |
| <b>Pot Life</b> | 30 min. v/20° C (material temp.)<br>25 min. v/25° C (material temp.)<br>20 min. v/30° C (material temp.)<br>10 min. v/40° C (material temp.)                   |
| <b>Density</b>  | 1,64 kg/ltr. mixed.  |

## APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

|                                     |   |
|-------------------------------------|---|
| <b>Airless Spray</b>                | <b>Std. &gt; 68:1 ratio or two-comp. equipment.</b><br>Tip size: 0,019-0,026" adjustable<br>Pressure: Min. 400 bar at tip<br>Hose: Max. ¾" diameter and length max. 20 m recommended.<br><br><b>Spray Material Temperature</b><br>Minimum spraying temperature 20 °C<br><b>Filters:</b> All filters to be removed. Material to be sucked without any strainer direct from bucket. |
| <b>Brush &amp; Roller (General)</b> | Recommended for small areas, repairs or to precoat edges (stripe-coat).<br>To obtain the required layer thickness, additional coating passes (wet-on-wet) may be necessary  |

## CURING SCHEDULE

| Surface Temp. | Cure Time | Immersion Service | Minimum Recoat Time | Maximum Recoat Time |
|---------------|-----------|-------------------|---------------------|---------------------|
| 20°C (68°F)   | 24 Hours  | 7 Days            | 10 Hours            | 96 Hours            |
| 25°C (77°F)   | 20 Hours  | 4 Days            | 9 Hours             | 84 Hours            |
| 30°C (86°F)   | 18 Hours  | 3 Days            | 7 Hours             | 72 Hours            |
| 40°C (104°F)  | 12 Hours  | 2 Days            | 5 Hours             | 48 Hours            |

### Substrate Temperature

Substrate temperature shall be min. 10 °C and min 3°C above the dew point.  
Relative humidity shall be below 85 %. Temp. and humidity shall be measured close to the substrate.

## CLEANUP & SAFETY

|                |   |
|----------------|---|
| <b>Cleanup</b> | Carboline Thinner No.2 or MEK for cleaning the Pump and the Spray equipment   |
| <b>Safety</b>  | Observe the precautionary notices on the container label, and read the Material Safety Data Sheet before use. This product is intended for use by properly qualified professional applicators in industrial conditions. The product is flammable and should be kept away from sparks, open flames and other sources of ignition. Smoking is prohibited in the application area. Wear suitable respiratory equipment and apply in well ventilated areas. Avoid contact with the skin and eyes. |

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## CLEANUP & SAFETY

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|--------------------|--|
| <b>Ventilation</b> | When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used.  |
| <b>Caution</b>     | This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with applicable regulations. In areas where explosion hazards exist, workmen should be required to use nonferrous tools and wear conductive and nonsparking shoes. |

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## PACKAGING, HANDLING & STORAGE

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|-------------------|--|
| <b>Shelf Life</b> | 2 years  |
| <b>Storage</b>    | Preferred storage conditions are to keep the containers in a dry and cool area below 35°C provided with adequate ventilation. The containers should be sealed tightly. |
| <b>Packaging</b>  | 16,3 lts. set (25,4 kg set)<br>Part A 14,0 lts. (23,1 kg)<br>Part B 2,3 lts. (2,3 kg)  |

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## WARRANTY

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