

Protecto-Coat 325HB

SYSTEM INFORMATION SHEET



53 to 64-mils (1,346 to 1,625 microns)

SYSTEM STEPS

- ① Primer 67
- ② Protecto-Coat 325HB
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ABRASION RESISTANT

The glass-flake reinforcement in the Protecto-Coat series linings provides better abrasion resistance and extends service life.



CHEMICAL RESISTANCE

This system is broadly chemical resistant and withstands exposure to various fuels, fluids, lubricants, and cleaning agents.



BETTER RECOAT TIMES

With a very short minimum primer recoat time to longer than average maximums, Protecto series linings can be installed on your terms.

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PERFORMANCE DATA	TEST METHOD	RESULTS
	Compressive Strength (ASTM C579)	9,000-9,500 psi (62-66 MPa)
	Flexural Strength (ASTM C580)	5,000-5,200 psi (34-36 MPa)
	Shore D Hardness (ASTM D2240)	75-80
	Taber Abrasion* (ASTM D4060)	90 mg
	Tensile Strength (ASTM C307)	2,500-3,000 psi (17-20.7 MPa)

*CS-17 wheel, 1000 cycles, 1000 gram load

SYSTEM STEPS	PRODUCT	THICKNESS	THEORETICAL COVERAGE RATE	PACKAGING	APPLICATION EQUIPMENT	RECOAT TIME*
Primer	Primer 67	3-4 mils (76.2-101.6 microns)	341-454 ft ² /gal (8.4-11.3 m ² /l)	Part A Part B	Short nap mohair roller / Brush / Spray	6 hours (min) 5 days (max)
Basecoat	Protecto-Coat 325HB	25-30 mils (625-750 microns)	53-64 ft ² /gal (1.3-1.6 m ² /l)	Part A Part B	Short nap mohair roller / Brush / Spray	5 hours (min) 72 hours (max)
Contact your Dudick Subject Matter Expert or Carboline Technical Service Representative for recommendations based on chemical service.						
Topcoat	Protecto-Coat 325HB	25-30 mils (625-750 microns)	53-64 ft ² /gal (1.3-1.6 m ² /l)	Part A Part B	Short nap mohair roller / Brush / Spray	5 hours (min) 72 hours (max)

*Recoat time at 75°F [24°C].

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INSTALL

This document is meant as a guideline for the installation of the system. Contact Dudick for further assistance prior to the installation of the system.

Apply Primer 67 at 3-4 mils without allowing it to puddle around welds or in pitted areas via brush, roll, or spray at the specified film thickness observing the specific application and recoat information found on the data page.

Hand trowel Scratch-Coat 800 as needed into pitted areas or transition and smooth a high weld.

Good linings application practice dictates that all sharp angles and welds be stripe coated before the final coat is applied. Once a stripe coat has been applied, two full coats of Protecto-Coat 325HB should be applied via brush, roll, or spray to achieve the specified thickness of the system.

SURFACE PREPARATION

Ferrous Metal: Primer 67 is recommended to be used to promote better adhesion or as a holding primer in immersion service.

Immersion and heavy spillage service: White Metal, SSPC SP 5 or NACE No.1, minimum 3.0 mil profile.

Heavy non-immersion service (i.e. fumes and spillage): Near white, SSPC SP 10 or NACE No.2, minimum 2.0 mil profile.

Atmospheric service: Commercial SSPC SP 6 or NACE No.3, minimum 2.0 mil profile

Non-Ferrous Metal: Must be primed with Primer 67 for immersion service. Prepare by abrasive blasting to SSPC-SP 17 thorough Abrasive Blast to a minimum of 3 mils (75 microns) dense angular anchor profile.

MIXING

All mixing should follow the mixing instructions on the specific Product Data pages.



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NOTE: The technical data presented in this document is accurate to the best of Dudick and Carboline's knowledge based on laboratory testing of the product(s) or system(s) described. Actual results in the field may vary depending on field conditions and application methods. The performance characteristics stated do not constitute a guarantee or warranty that the products will meet the stated results under all circumstances. Contact Dudick or Carboline Tech Service with questions.