CORCHEM®

INFORMATION BULLETIN

CORCHEM® 256 SEPARATOR LINING
FORCED CURE PROCEDURE

AMBIENT CURING TIME

This curing schedule is predicated upon application conditions where the mixed product, substrate, and ambient air temperatures are the same:

Temperature	50°F	70°F	90°F
Minimum Recoat Time	8 Hours	4 Hours	2 Hours
Maximum Recoat Time	72 Hours	48 Hours	24 Hours
Immersion – Final Cure	7 days	5 days	3 days

Curing times are significantly shorter for higher temperatures or lower thickness and are longer for lower temperatures or higher thickness. Curing times are affected by the method of application; thickness of applied film; the quantity of thinner (if used); the amount of ventilation and air circulation; relative humidity; etc. *Refer to RECOAT AND REPAIR Section in the CORCHEM® 256 Separator Lining Technical Bulletin for extended recoat instructions, if subjected to extended exposure to sunlight, or if coating reaches complete cure and hardness.*

NOTICE!

For faster curing and lower temperature applications CORCHEM® 256-WA-0C0, Component A, WINTER CURE curing agent may be desired.

VENTILATION

Proper ventilation during the curative process is vital for the evacuation of solvent vapors. Warm dry air should be circulated across the entire coated surface throughout the curative process. Solvent fumes are heaver than air and should be exhausted through lower openings while fresh dry air is supplied through upper openings.

FORCED CURE

When CORCHEM® 256 Separator Lining is properly force cured the resulting lining may achieve improved physical and chemical resistance properties.

WARNING!

DO NOT allow potential sources of spark or ignition near vessels containing explosive vapors!

FORCED CURING SCHEDULE

Air dry with continuous ventilation in ambient conditions for a minimum of 3 hours at 50°F or a minimum of 1 hour at 70°F, and until flash off/drying time necessary to prevent blistering and defects is achieved, then gradually raise the temperature not more than 50°F every 30 minutes until the coated surface reaches 125°F - 150°F and hold for a period of 30 minutes. Allow the coated surface to cool and then repeat each of the application procedures described in the CORCHEM® 256 Separator Lining Technical Bulletin until the desired total dry film thickness is achieved.

After the final coat has been applied, allow the minimum flash off/drying time necessary to prevent blistering and defects, then:

1. Gradually raise the temperature not more than 50°F every 30 minutes until the substrate reaches 125°F - 150°F and hold for 1-hour.
2. Gradually raise the temperature not more than 50°F every 30 minutes until the substrate reaches 200°F - 225°F and hold for 2-hours.

Caution: Exceeding the times and/or temperatures indicated above may result in reduced performance or damage to the coating.

C256 SEPARATOR LINING
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MADE IN TEXAS, USA

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