

PLURAL COMPONENT APPLICATION EQUIPMENT GUIDE

CORCHEM 259 SOLVENTLESS NOVOLAC

- Mixing Material is supplied in containers as a unit. Complete units should be stored, mixed and applied in accordance with Application Guidelines.
- Mix Ratio 4 Parts component A (Resin) to 1 part component B (Catalyst)
- Working Pot Life 60 minutes at 25°C (70°F)
- Plural Spray Recommended
 Use a fixed ratio (4:1 by volume) plural component spray application system
 Typical Systems provided by Spray-Quip, Inc. as described below:
 For Material Supplied in Pails = 398-273 (skid) or 398-272 (wagon) XP50 system or equal
 For Material Supplied in Drums = 398-287 (skid) or 398-276 (cart) XP50 system or equal

- Plural System Components
- A&B 25 gallon double wall SS heated tanks with temperature control (pail supplied systems), (2) 5:1 feed pumps with regulators and pressure gages, A&B agitators, A&B 30 mesh low pressure WYE filters between tanks and XP pump lowers, A&B ¾" fluid lines from the feed pumps to the proportioning pumps and (4) ½" air lines for the feed pumps and agitators. NOTE: If using inline pump filters, use 30 mesh screens.
 - The pump mix ratio needs to be 4:1 (4 epoxy/resin : 1 amine/catalyst).
 - Two 4000 watt Viscon HP inline fluid heaters with temperature gages.
 - One 23:1 or larger solvent pump with fluid line to the mix manifold.
 - 100' Heated hose bundle (200' maximum) with (1) ⅜" ID paint line for the (amine/catalyst), (1) ½" paint line for the (epoxy/resin), and hose heat controller unit with temperature sensor.
 - Use a mix manifold with split nosed mixing manifold block.
 - The static mixers and paint line forward of the remote mix manifold should be set as follows. **NOTE: Do not use plastic static mixers.**
 - Drum feed systems require Blanket heaters for preheat and recirculation.

Two ¾" ID x 12 fold SST stainless steel static mixers	One 25' – 50' x ⅜" ID diameter paint line	One 6' – 10' x ¼" ID diameter whip line	WIWA 500 or Graco XTR-7 spray gun
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- Material should be preconditioned to 80°-90° F prior to use. NOTE: In the heated hoppers, the "A" side should be at a minimum of 110° F and the "B" side at 90-100° F. **Failure to heat the material prior to proportioning may cause air ingestion and/or cavitation of the pumps resulting in the application of off-ratio material.**
- Set "A" inline heater to 120° F and set "B" inline heater to 100° F.
- Material temperature must be 120°-130° F before being sprayed.
- Hose heat should be set at 120°-130° F.
- Material temperature at the gun should be 110°-120° F.
- Dynamic pressure (while spraying) 2800-3000 psi.
- The size of airless spray tip will depend on the area being sprayed, the viscosity, and the temperature of the materials. Use a Graco XHD RAC tip sized between 0.023"-0.027".
- Mixed spray life is 10 to 15 minutes at 21°C (70°F)
- Static mixers, whip lines and gun should be flushed clean within 1-2 minutes after spraying has stopped, close dual valve for A & B, open flush valve(s) and trigger gun to start the flow of MEK or CORCHEM 4 thinner. Failure to flush material after 1-2 minutes can result in build-up or clogging of the static mixer, whip line and spray gun.

Please recognize that this is the basic configuration for a PC Unit and depending upon which decisions on equipment components and coatings that are selected, the full configuration of the unit may need to be further modified and changed. If other forms of assistance are required, please contact CORCHEM.

Airless Spray	Suitable	
Air Spray (Pressure Pot)	Not suitable	
Brush	Suitable	Can be used for the touch-up of small areas or for stripe coating of welds and edges.
Thinner	Do not thin	
Cleaner	MEK or CORCHEM 4 thinner	
Work Stoppages	Do not allow mixed material to remain in static mixers, whip hose and tip. Thoroughly flush these with MEK or CORCHEM 4 thinner.	
Clean Up	Flush, disassemble and clean static mixers as needed (1-2 times/day). A second set of static mixers, whip line and gun on-site is recommended to decrease down time. Frequency should depend upon amount sprayed, temperature and elapsed time, including any delays.	
	All surplus material and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.	
To Rent or Purchase Plural Component Equipment Contact	Spray-Quip, Inc. 1754 Des Jardines Houston, TX 77023 (713) 923-2771 – Phone (713) 923-7822 – Fax sq@sprayquip.com www.sprayquip.com Reference: Plural Component Equipment for CORCHEM	