

SELECTION & SPECIFICATION DATA

Description	A combination of epoxy and polyamide resins with selected pigments designed specifically as a high chemical resistant, non-toxic, odorless coating.
Features	<ul style="list-style-type: none"> • Plasite 7133 HS will not impart taste or odor to such products as sugar solutions, wine, beer, meat products and similar items. • This coating is resistant to the standard cleaning for sanitation purposes and will withstand normal atmospheric steam cleaning procedures. • Plasite 7133 HS meets the FDA requirements for 21 CFR 175.300 for direct aqueous food contact.
Color	White, Light Gray, Light Blue
Finish	N/A
Primer	Self Priming or others directed by Carboline Tech Service
Dry Film Thickness	4 - 5 mils (102 - 127 microns) per coat 8 - 10 mils (203 - 254 microns) in two or more coats
Solid(s) Content	61± 2% by volume
Coverage Rate	983 mil ft ² /gallon (theoretical). For estimating purposes, 78 ft ² /gallon will produce a 10 mil film (20% loss included). Two coats will produce an 8 to 12 mil film for immersion service.
VOC Values	<p>As Supplied : 2.46 (lbs/gal) 295 (g/L) Plasite Thinner #201 : Thinned 10%: 2.84 (lbs/gal) 341 (g/L)</p> <p>As supplied VOC content determined using EPA method 24. VOC information for Plasite 7133 HS containing 10% thinner was determined theoretically</p>
Dry Temp. Resistance	Non-Continuous: 300°F (149°C) Continuous immersion temperatures depend on particular reagent.
Topcoats	Not Applicable

SUBSTRATES & SURFACE PREPARATION

General	Surfaces 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.
Steel	Immersion: SSPC-SP10 Non-Immersion: SSPC-SP6 Surface Profile: 2.0-3.0 mils (50-75 micron)
Galvanized Steel	SSPC-SP16 or SSPC-SP11
Aluminum	Consult Carboline Technical Service

MIXING & THINNING

Mixing | The curing agent and coating are supplied in separate containers at a 7:1 ratio. For splitting purposes, use 1 part curing agent to 7 parts coating by volume. Thoroughly mix the coating, then slowly add the curing agent and mix completely. The coating should stand approximately 15 minutes after the curing agent has been thoroughly mixed.

Thinning | Use Plasite Thinner #201.
It may be necessary to thin the coating. The applicator must make exact thinner adjustments based on his equipment and air and surface temperatures. The following thinning guidelines are approximate.
Normal application temperatures and conditions may require the addition of approximately 5 to 15% thinner by volume with approximately 5% additional thinner added for each 5 °F of increased temperature. It is recommended that the amount of thinner included on each order amount to approximately 20% of the coating order.

Pot Life | 1 hour at 70 °F (21 °C)

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.

Spray Application (General) | All spray equipment should be thoroughly cleaned and the hose, in particular, should be free of old paint film and other contaminants. Use standard production-type spray guns: GUN DeVilbiss JGA-510 Binks #2001 Graco P800 FLUID E 66-SS 04 AIR 797 63-PB 02 When airless spray equipment is used, the recommended liquid pressure is 1500-1800 psi with tip size from 0.015-0.019 inches. Thinning requirements are more than for conventional spray. Air supply shall be uncontaminated. Adjust air pressure to approximately 50 lbs. at the gun and provide 5-10 lbs. of pot pressure. Adjust spray gun by first opening liquid valve and then adjusting air valve to give an 8-12 inch wide spray pattern with best possible atomization. Apply a "mist" bonding pass. Allow to dry approximately one minute but not long enough to allow film to completely dry. Apply crisscross multi-passes, moving gun at fairly rapid rate, maintaining a wet appearing film. Observe the coating surface, and when it appears to be flowing together you will have an average 3-4 mil/75-100 microns wet film. By allowing the solvents to flash-off for a few minutes, several more fast multi-passes may be applied until you have a dry film thickness of approximately 4-5 mil/100-125 microns (approximately 10 wet mil/250 microns). Repeat this procedure for the second coat to obtain an 8-10 mil/200-250 microns DFT. Overcoat time will vary both with temperature and ventilation and will require 8-12 hours at 70°F/21°C for enclosed spaces. Less time is required for exteriors. Remove all overspray by dry brushing or scraping if required. Equipment must be thoroughly cleaned immediately after use with Plasite thinner to prevent the setting of the coating. Note: Prior to spray application, stripe brush all welds, attachments and surface irregularities using Plasite 7133 previously thinned a minimum of 50% by volume with Plasite Thinner #71.

Brush | Recommended for small areas and repairs only. Use a high quality brush and apply a very light crisscross brush coat. Allow to dry for approximately 5 minutes. Then apply a heavy coat using a crisscross brush pattern. "Flow" the coating on rather than try to "brush out." Allow to dry tack-free. Repeat until sufficient film thickness is obtained. Normally, a film thickness of 2.5 to 3 mils can be obtained per coat by this method.

CURING SCHEDULE

Surface Temp.	Cure Time	Tack Free
70°F (21°C)	7 Days	8 Hours
90°F (32°C)	5 Days	NR

Normally, polymerization and curing will take place in 5 days at 90 °F or 7 days at 70 °F. This coating should not be applied when air temperature or temperature of surface to be coated is below 50°F. Within 24 hours after coating is applied, a minimum substrate temperature of 70 °F is required for proper polymerization. Force curing may be required for the Plasite 7133 HS when used in taste sensitive immersion service.

Force curing at elevated temperature is desirable for certain exposures. Where coating is to be subject to immersion in high temperature solutions, wine, beer and other severe exposures, it is recommended that the curing temperature be at 150 to 225 °F. In order to insure the complete removal of solvents and odor, force curing is generally recommended when coating is to be used in aqueous food service.

Listed are a few curing schedules that may be used for time and work planning. Prior to raising the metal to the force curing temperature, it is necessary that an air dry time of 2 to 5 hours at temperatures from 70 to 100 °F be allowed. After the air dry period has elapsed, the temperature should be raised approximately 30 °F each 30 minutes until the desired force curing metal temperatures are reached.

Surface Temp.	Chemical Exposure
150°F (66°C)	8 Hours
175°F (79°C)	6 Hours
200°F (93°C)	5 Hours
225°F (107°C)	4 Hours

Final cure may be checked by exposing coated surface to MIBK for ten minutes. If no dissolving and only minor softening of film occurs, the curing can be considered complete. The film should reharden after exposure if cured.

CLEANUP & SAFETY

Cleanup	Use Plasite Thinner #71. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life	12 months at 70 °F (21 °C) when stored in original unopened container
Storage Temperature & Humidity	Store all components between 40-110°F, (4-43°C) in a dry area. Keep out of direct sunlight. Avoid excessive heat and do not freeze.
Shipping Weight (Approximate)	Approximately 13 lbs./gal
Flash Point (Setaflash)	Part A: 41 °F (5 °C) Part B: 41 °F (5 °C)

Plasite[®] 7133 HS

PRODUCT DATA SHEET



WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.