



KNS COMPANIES, INC.

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CONTAINER LININGS

PROPERTIES & APPLICATION DATA

CODE: 404-13-RS03

DESIGNATION: L-5X Red Phenolic

DESCRIPTION: Pigmented, heat reactive 100% phenolic container lining. Recommended for solvent and acid resistance. Formulated to give good impact resistance. Meets EPA VOC requirements of 4.2 lbs/gal or less.

TYPICAL PROPERTIES	SPECIFICATIONS
Viscosity # 4FC 70° F (sec.)	22-24
Density @ 70° F (Lbs./gal.)	10.06 +/- 0.20
Total Solids (% weight)	54.9 +/- 2.0
Total Solids (% volume)	37.7 +/- 2.0
Resin Solids (% weight)	32.8 +/- 2.0
Pigment Solids (% weight)	22.2 +/- 2.0
Color, wet	Red
Color, baked	Red
Gloss	medium
Coverage (sq. ft./gal. @ 0.6 mil DFT)	1008

ENVIRONMENTAL DATA	VALUES
VOC solvent density (Lbs./gal.)	7.16
VOC solvent % weight (% volume)	32.2 (45.3)
Water % weight (%volume) ASTM D4017	8.1 (9.8)
Acetone % weight (% volume)	4.8 (7.2)
VOC/gal less water/acetone (EPA TM 24)	3.9 Lbs.
Lbs. VOC/gallon of solids	8.6
Lbs. VOC/gallon as supplied	3.24
Lbs. HAPs/gallon of solids	1.43
Lbs. HAPs/gallon as supplied	0.54

APPLICATION DATA:

Reduction:

**Reduce with 1/1 blend of MEK/Butyl Cellosolve to 21 – 24 sec. (EZ # 2)
(By Volume 5 Parts 404-13-RS03/ 1 Part MEK/Butyl Cellosolve)**

Apply by:

Conventional, airless or air assisted spray

Application temperature:

Use heat to apply @ 110 - 130°F

Application film thickness:

1.6 – 2.1 mils wet to obtain 0.6 – 0.8 mils dry

Standard bake:

10 minutes @ 350 - 375°F metal temperature

Two coat application:

Under cure first coat 5 minutes @ 300 - 350°F metal temperature,

Apply second coat and bake @ standard bake

Clean up solvent:

MEK

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