

PPG PHENGUARD™ TANKCOATING

HOT CURE

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This is only applicable for PPG PHENGUARD tank coating systems and only a requirement when Methanol or Vinyl Acetate Monomer are to be carried. However, to obtain maximum resistance in the shortest possible time, a hot cure is generally recommended.

Prior to the hot cure, in all cases, the full cure must have already been achieved.

METHOD: HOT WATER USING BUTTERWORTH SYSTEMS

For vessels with a double hull construction, the procedure for hot cure of the Phenguard system with hot (sea) water (approximately 80-85°C) gives good results. The minimum steel temperature of the internal surface must continuously be above 60°C.

Minimum curing time in relation to steel temperature.

Steel temperature	Minimum curing time
60 °C	16 hours
70 °C	6 hours
80 °C	3 hours

PROCEDURE

Recommended procedure is to commence by heating up the water to a temperature of 80 – 85°C using heating coils in the slop tanks or by other means such as heat exchangers, then distributing the hot water through butterworths using continuous recirculation method for periods as described in above table.

Start-up time before achievement of required substrate temperature depends on the capacity of the heating equipment, and external temperatures.

SPECIAL NOTES

1. Heating up times are not included in the minimum curing times mentioned in the above table
2. Steel temperatures during curing period must be monitored continuously and extensively by automatic equipment. Special attention to be taken to cold areas, such as but not limited to, stiffeners etc. A record of temperatures to be maintained at all times.
3. To avoid cold wall effect, adjacent areas must be free from cargo or ballast.

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