ChemLINE® 784 WS Wine and Spirits

TECHNICAL DATA SHEET

**This Technical Data Sheet supersedes those previously issued.*

DESCRIPTION

ChemLINE® WS (Wine and Spirits) is a two-coat thermoset polymer lining engineered for wine, spirits, and other alcohol service applications. Formulated with ethanol as the reduction solvent and no hydrocarbon solvents, it helps minimize cargo contamination concerns while delivering exceptional chemical resistance through APC's highly cross-linked polymer technology. ChemLINE® WS has been independently assessed as safe for use in food contact applications in the United States.*

TECHNICAL DATA

Color	White, Grey	
Solids Content, %	87% by volume	
Finish	Gloss	
VOC's	As supplied	Grey / White 104 g/l (0.87 lb/gal)
	Thinned to max level	Grey / White 147 g/l (1.23 lb/gal)
Pot Life	20 minutes at 75°F (24°C)	



SUBSTRATE & SURFACE PREPARATION

General	All surfaces to be coated should be clean, dry, and free from all contamination. All oil, grease, and other contaminants must be removed according to SSPC-SP 1 Solvent Cleaning prior to high pressure fresh water washing.
Steel Substrate	All surfaces to be coated shall be abrasively blast cleaned to NACE No 2 / SSPC-SP 10 / ISO Sa 2½ with a 3-4 mil (75 to 100 micron) blast profile.

MIXING & THINNING

Mixing	Mechanically agitate Component A (resin) for 1-2 minutes. Slowly add Component B (catalyst) to the resin and mix thoroughly for 3-5 minutes using a high shear (SSPC recommended) mechanical mixer. The mixture must be homogeneous and uniform in consistency.	
Ratio	One gallon kit	Part A: 0.89 gallons (3.38 liters) | Part B: 0.11 gallons (0.41 liters)
	Five gallon kit	Part A: 4.47 gallons (16.9 liters) | Part B: 0.53 gallons (1.99 liters)
Thinning	(if needed) Reduce with 200 proof Ethanol ONLY, up to 5% by volume.	

**Independently assessed as safe for its intended use in applicable food contact applications in the United States, including alcohol and certain fatty food service. This statement does not represent FDA clearance or approval.*

APPLICATION GUIDELINES

Equipment Type	Coating should be applied via airless spray equipment, pump size 45:1 or greater. Recommended airless tip sizes .017 to .023 inch. 3/8" ID hose size, 1/4" ID hose whip. *Contact APC Technical Service for additional information	
Dry Film Thickness (Total system thickness)	Average: 12-14 mils DFT (300-350 microns) Minimum: 10 mils DFT (250 microns) Maximum: 18 mils DFT (450 microns)	
Theoretical Coverage	at 1 mil: 1395 ft^2 / gallon (25 microns) at 12 mils: 116 ft^2 / gallon (300 microns) at 14 mils: 99 ft^2 / gallon (355 microns) *Allow for loss in mixing and application	at 1 mil: 34.2 m^2 / liter (25 microns) at 12 mils: 2.8 m^2 / liter (300 microns) at 14 mils: 2.4 m^2 / liter (355 microns) *Allow for loss in mixing and application
Re-coat Times	59ºF (15ºC) = minimum 12 hours, maximum 3 days (72 hours) 77ºF (25ºC) = minimum 8 hours, maximum 2 days (48 hours) 86ºF (30ºC) = minimum 6 hours, maximum 2 days (48 hours)	
Holiday Testing	High voltage holiday detector set at 3,000 volts, prior to repairs. Touch ups tested at 100 volts / mil.	

APPLICATION CONDITIONS

Material	55ºF (13ºC) – 75ºF (24ºC)
Substrate	59ºF (15ºC) – 104ºF (40ºC)
Humidity	10% – 75%

CLEAN-UP & SAFETY

Clean-up	ChemLINE® WS can be cleaned up Acetone (preferred) or MEK.
Safety	Consult SDS

PACKAGING, HANDLING & STORAGE

Shelf Life	12 months
Storage	72ºF – 90ºF (22ºC - 32ºC) | 0 - 100% RH Consult SDS or contact APC Technical Service for more info.

Information on TDS documents represent typical data for the mixed coating formulation (part A + part B) using 'as supplied' materials as of the date hereof. All information is correct to the best of our knowledge. Values should not be construed as specifications. Please contact Advanced Polymer Coatings' Technical Service Team if you have any questions related to this data sheet or application.

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