



ATLASKOTE NO 302H LATEX DRUM INTERNAL LINER

PDS-BS-302H
20200102
REV:002

DESCRIPTION

Atlaskote No. 302 H is a solvent based bituminous solution specially formulated with super quality bitumen. The product had been used extensively by all major steel latex drum manufacturers in Malaysia and other countries since 1969.

USAGE

Atlaskote No. 302 H Latex Drum Internal Liner is specially formulated for internal lining of latex drums, and its primary purpose is to prevent the rubber latex contained in the drum from being chemically interfered by the drum metal.

TECHNICAL DETAILS

Adhesion

The coating has good adhesion to most surfaces, e.g. ferrous metals, slight etched zinc, and etc.

Coverage

Wet Thickness: 70 micron minimum

Dry Thickness: 35 micron minimum

[Approximately 8-9 drums per litre for standard 210-litre (46 I.G.) latex drum (35 to 40 drums per I.G)]

Chemical and Water Resistance

Resistant to: water, dilute acids and alkalis

Not resistant to: oils and solvents.

Dilution

No thinning of **Atlaskote No. 302 H** should be allowed as it is supplied ready for use.

Drying Time

The coating will dry within two hours at normal room condition.

Film Thickness

70 micron (wet) minimum.

Flash Point

Approximately 35°C (Cleveland Open Cup)

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It is also not to be taken as warranty or representation for which we assume legal responsibility nor as permission or recommendation to practice any patented invention without a licence. It is offered solely for your consideration, investigation and verification.

Flexibility

This may be bend on a 1” mandrel through 180° without cracking or loss of adhesion (Method – BS 3416:1966 Appendix E-Test for Flexibility)

Gloss

The cured coating is black and shinny.

Heat Flow Resistance

The cured film will not flow or sag at 60°C (but the empty and filled latex drum should always be stored away from direct sunlight, boiler, over, engine room, or other heat sources).

Impact Test

The cured film will pass the test (a 630 to 630-g. steel ball dropped from a height of 2.44 m [8 feet] on a steel plate, the reverse side of which is coated). [Method: BS 4147:1967 Appendix D-Impact Test]

Nonvolatile Content, %weight, (ASTM D1644, Method B):

Minimum 50.

Density @ 25 °C, g/cc (Density cup 100 cc– ASTM D1475):

0.87 – 0.93

Toxicity

Contains no toxic element.

Viscosity at 25 °C, seconds, (BS3900 Type “B” 4 Cup).

30 - 100

Storage Life

12 months under good storage conditions and undamaged containers.

METHOD OF APPLICATION

To ensure that **Atlaskote No. 302H** will provide satisfactory performances, it is important that the method of application is correct. For the drum manufacturing plants, the method recommended is by spraying, either by ‘pressure-pot spray’ system or by ‘airless spray’ system and spraying pressure should be adjusted to suit the particular spray unit by actual test spraying. The resultant coating should be even and of uniform thickness to the application rate recommended.

PREPARATION OF SURFACES

The metal surface to be sprayed coated with **Atlaskote No. 302 H** should be free from grease, oil, preventive, rust preventive and etc. Various methods are in use for degreasing and the best is Trichloroethylene vapour stripping in a proper build degreasing unit.

APPLICATION

Generally the drum bodies and the ends are formed and degreased following which they are separately sprayed on the internal surfaces with **Atlaskote No. 302 H** and then ovened. The bodies and ends are then formed into drums and the exterior paint sprayed followed by second ovening.

The usual conditions are as follows:-**First Ovening**

Peak Metal Temperature 135 °C maximum.

Duration of ovening Approximately 10 minutes.

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Second Ovening

Peak Metal Temperature 180 °C maximum.
Duration of ovening Approximately 13 minutes.

Ovening conditioning should be strictly maintained and depending on the plant used, adjustments should be made by actual testing. The completed drums should have an internal lining which is uniformly black of high gloss without pin-holding, craterings or other defects.

Some manufacturers assemble their drums immediately after spraying with **Atlaskote No. 302 H** and apply the exterior paint followed by a single ovening process. This is not ideal to obtain satisfactory results.

As mentioned earlier, **Atlaskote No. 302 H** is a bituminous solution, i.e. it contains solvent. During ovening, the solvent evaporates to vapour and when the vapour is not driven out from the drum through the two small bungs, it will recondense on the drums lining on cooling and this will soften the bituminous lining.

Experiments, carried out by hot-air purging of the drum immediately after ovening, whilst the drum body is still hot, showed that a very large volume of air had to be used in order to reduce the solvent vapour in the drum to a 'safe' level. If due to plant limitations, which require this method to be adopted, then it is an added safety by allowing the sprayed drums bodies and ends to stand for a few hours in a freely ventilated covered area before assembling into drums for exterior painting and ovening.

The bungs should not be closed after air-purging until a few days later, this will give added safety margin.

CAUTION

- * **Atlaskote No. 302 H** should not be diluted with thinner. The thinned lining may not give an expected performance as thick films of bitumen coating give greater protection pro-rata than thin ones, and will also cause excessive solvent vapour in the drum during ovening.
- * It is utmost importance that the surface preparation should be carried out before spraying with **Atlaskote No. 302 H**.
- * Too high a baking temperature will result in cratering.
- * Water contamination will cause blistering and pin-holding.
- * The screw threads should not be sprayed with **Atlaskote No. 302 H** as this will, during closing and opening, cause the lining to flake off and thus contaminates the rubber latex.

HANDLING PRECAUTION

Clean hands and tools with solvent or kerosene.

PACKING

Atlaskote No. 302H is available in 210-litre drum.

TECHNICAL SERVICE

Our sales Department can assist you on the proper use of our products and you are free to consult them on any matter regarding our product.