

PRODUCT DATA SHEET

L-336 PHENOLIC RESIN COATINGS PTI SPECIALTY SERIES

DESCRIPTION

L-336 is a corrosion preventative permanent resin coating that conforms to **MIL-PRF-3043C**. **L-336** is intended for use on interior and exterior aircraft engine components and other metal parts. This permanent resin shows excellent resistance to solvents, hot oils (395°F), salt & fresh water, most acids as well as other organic and inorganic chemicals. **L-336** is very durable with good abrasion resistance properties.

COLORS

This coating can be provided in clear or clear with blue or green dye. Custom colors are NOT available.

COATING PROPERTIES & CHARACTERISTICS

Mil-Spec	MIL-PRF-3043C
Recommended Primer(s)	None
Reducer	PT-1070
Toxicity	No known toxicity when used under normal conditions
Solids Content	25% – 30%
Viscosity	0.4 poise max or 22 seconds in a #2 Zahn Cup
Weight per gallon	7.7 ± 0.3
Gloss	80 degrees minimum

SHELF LIFE

Shelf life is only applicable for materials stored in unopened and undamaged original factory filled containers.
1 year when stored between 50°-85° Fahrenheit.

CLEANING

All parts must be chemically or mechanically cleaned, film free, by an industry recognized cleaning specification or method

MIXING INSTRUCTIONS

Generally, no thinning is required. If bubbling does occur during application, reduce 4 parts of **L-336** with 1 part **PT-1070** solvent. More solvent may be added for special applications but do not exceed a 1:1 by volume ratio.

APPLICATION

This product can be applied using brush, dripping, conventional air spray equipment or HVLP Spray system. Please consult with a PTI representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix both base and catalyst thoroughly and filter/strain before spray application.

NOTE: It is not recommended to strain flat/matte coatings.

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3. HVLP Spray Pressure: 7-10psi. Conventional Spray Equipment 15-30 psi.
4. Always air-blow and tack wipe the surfaces to be painted. Parts should be grounded to prevent static.
5. Best application results: apply 2 coats: 1 fog/tack coat & 1 full coats from 0.75 – 1 mil thickness.
6. Allow 20-30 minutes to pass before applying additional coats.

NOTE: Application of PTI products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, PTI products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance. The material, hangar, and aircraft skin temperatures should be no lower than 75° F / 25° C before, during and after application.

DRYING & CURING SCHEDULE

Air Dry Times (75°F / 25°C and 50% Relative Humidity)

- 30 minutes for set to touch.
- After air drying L-336 for no less than 1 hours, the parts should be baked

Bake Cure

- Bake 25-30 minutes at 320° to 330°F for optimum resistance performance

EQUIPMENT CLEANUP

Use clean Acetone, IPA, or PT-1070. Do not allow material to dry or cure inside any equipment.

HEALTH, SAFETY, & STORAGE REQUIREMENTS

Refer to each individual material SDS (Safety Data Sheet) for specific requirements on the health, safety, storage and handling requirements. Follow all local, state, and national regulations during surface preparation, material application and cleanup.

PRODUCT INFORMATION & DISCLAIMER

Product Data Sheets are periodically updated to reflect new information. It is important to use the latest and most recent revision for the product being used. The foregoing information is accurate to the best of our knowledge. However, due to differences in customer handling, use and method of application which are not known and are beyond our control, Products Techniques, Inc. makes no warranties as to the end result.