

SELECTION & SPECIFICATION DATA

Generic Type	Alkyd Enamel
Description	A high solids, general purpose air dry enamel that is used as a self-priming finish coat. Carbocoat 8245 has exceptional application characteristics, Very good corrosion protection as a direct to metal coatings. Is used as an OEM finish for a variety of applications. It Is also recommended for light to moderate industrial use for new construction or maintenance.
Features	<ul style="list-style-type: none"> • Smooth, attractive, high gloss finish • Direct-to-metal application if desired • Very good weatherability, gloss and color retention • Outstanding application characteristics • Economical, quick dry • Good flexibility • Impact and abrasion resistant
Color	Refer to Carboline color chart
Finish	High Gloss
Primer	Self-priming can also be applied over most alkyds, epoxies, polyurethanes or others as recommended. A test patch is recommended over existing coatings.
Dry Film Thickness	2 - 3 mils (51 - 76 microns) per coat Do not exceed 4 mils in a single coat.
Solids Content	By Volume 53% +/- 2%
Theoretical Coverage Rate	850 ft ² /gal at 1.0 mils (20.9 m ² /l at 25 microns) 425 ft ² /gal at 2.0 mils (10.4 m ² /l at 50 microns) 283 ft ² /gal at 3.0 mils (7.0 m ² /l at 75 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 3.3 lbs/gal (372 g/l) Thinner 10 : 6 oz w/ thinner 10: 3.5 lbs/gal (423 g/l) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Some discoloration and loss of gloss occurs above 200°F.
Limitations	Not for immersion applications or splash and spillage of acids, alkalies or solvents.

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
Galvanized Steel	This product is NOT RECOMMENDED for galvanized steel.

SUBSTRATES & SURFACE PREPARATION

Ferrous Metal | For best results applied over suitable primer. If priming is not possible use as a direct-to-metal coating and apply over SSPC-SP3 cleaned ferrous metals. If steel is to be abrasive blasted, profile should not exceed 2.0 mils (50 microns).

MIXING & THINNING

Mixing | Power mix to uniform consistency.

Thinning | May be thinned up to 6 oz/gal (5%) with Thinner 10 or Thinner 25. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Conventional Spray | For best results use a pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.052" I.D. fluid tip and appropriate air cap.

Airless Spray | Apply using 30:1 pump able to deliver a minimum of 3000 psi and 3 gal/min output.
Material Hose: 3/8" I.D. (min) x 150' max length
Tip Size: 0.015-0.019"
Output Pressure: 1800-2700 psi
Filter: 60 Mesh

PTFE packings are recommended.

Brush | Use a medium bristle brush.

Roller | Use a short nap roller and avoid re-rolling.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	35°F (2°C)	35°F (2°C)	35°F (2°C)	0%
Maximum	120°F (49°C)	120°F (49°C)	120°F (49°C)	95%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry to Recoat
50°F (10°C)	60 Minutes	24 Hours	24 Hours
75°F (24°C)	45 Minutes	6 Hours	4 Hours
90°F (32°C)	30 Minutes	4 Hours	4 Hours

These times are based on a 3.0 mil (75 micron) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times and could result in solvent entrapment or premature failure. Adhesion develops over a period of time. Wait 30 days before doing adhesion testing.

CLEANUP & SAFETY

Cleanup	Clean up all tools and equipment promptly with Thinner 10 or acetone. Flush out all spray tips, fluid lines and pressure pots immediately after use.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands. Keep container closed when not in use.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. In confined areas, workmen must wear fresh airline respirators. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	12 months when stored at 75°F Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	35° - 110°F (2°-43°C) 0-100% Humidity.
Storage	Store Indoors.
Shipping Weight (Approximate)	5 Gallon - 65 lbs (30 kg) Drum's - 650 lbs (300 kg)
Flash Point (Setaflash)	45°F (7°C)

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.