

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Epoxy-amine
<b>Description</b>	A ready-to-spray, modified epoxy formulated to provide outstanding corrosion resistance as a single-coat, direct-to-metal (DTM) exterior coating for railcars and other structures. While all epoxies will chalk and yellow under UV exposure; this epoxy resists this affect better than most.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Ready-to-spray formulation (no thinning required)</li> <li>• Resists yellowing and chalking</li> <li>• Single-coat; direct-to-metal coating</li> <li>• Self-priming finish</li> <li>• High solids; Low VOC</li> <li>• Easy 1:1 mix ratio</li> <li>• Long pot life</li> <li>• Wide application properties (4-8 mils/100-200 microns)</li> </ul>
<b>Color</b>	White, Gray, Black and other colors available subject to minimum order.
<b>Finish</b>	High Gloss Initial gloss. Epoxies lose gloss and chalk upon exposure to UV.
<b>Primer</b>	None required; self-priming.
<b>Dry Film Thickness</b>	4 - 8 mils (102 - 203 microns) per coat
<b>Solids Content</b>	By Volume 67% +/- 2%
<b>Theoretical Coverage Rate</b>	1075 ft <sup>2</sup> /gal at 1.0 mils (26.4 m <sup>2</sup> /l at 25 microns) 269 ft <sup>2</sup> /gal at 4.0 mils (6.6 m <sup>2</sup> /l at 100 microns) 134 ft <sup>2</sup> /gal at 8.0 mils (3.3 m <sup>2</sup> /l at 200 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 2.25 lbs/gal mixed; 268 g/l mixed

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	All surfaces must be thoroughly cleaned to remove dirt, grease, mill scale, loose rust and any other contaminants that can reduce adhesion via SSPC-SP1 solvent cleaning before proceeding with recommended surface preparation.
<b>Steel</b>	Minimum: Abrasive blast per SSPC-SP6 (NACE No. 3) to a Commercial Blast finish; with a 1.5-3 mils angular profile.

## MIXING & THINNING

<b>Mixing</b>	Power mix each component separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
<b>Thinning</b>	No thinning is necessary. Product is formulated to spray as received.
<b>Ratio</b>	1:1 by volume
<b>Pot Life</b>	3 hours @ 77°F

### 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.

**Spray Application (General)** | Listed below are general guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve desired results.

**Airless Spray** | 45:1 ratio pump  
Tip orifice: 0.017 - 0.019" diameter  
Fluid pressure: 2600-3000 psi

### CURING SCHEDULE

Surface Temp.	Dry Hard	Dry to Recoat	Dry to Touch
77°F (25°C)	10 Hours	8 Hours	3 Hours

Note: recoat within 10 days @ 77°F

### CLEANUP & SAFETY

**Cleanup** | Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

**Safety** | Read and follow all caution statements on this product data sheet and on the MSKS for this product. Employ normal workmanlike safety precautions. Wear protective clothing, gloves and use protective cream on face, hands, and all exposed areas.

**Ventilation** | When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.

### PACKAGING, HANDLING & STORAGE

**Shelf Life** | Part A: 12 months  
Part B: 12 months

**Storage Temperature & Humidity** | Store indoors: 40°-110°F (4°-43°C)  
0-100% relative humidity

**Shipping Weight (Approximate)** | 10-gal kits  
12 lbs (5.2 kg) per gallon

**Flash Point (Setaflash)** | Part A: 115°F (46°C)  
Part B: 66°F (19°C)



## **WARRANTY**

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