

Selection & Specification Data

Generic Type	Aliphatic Acrylic-Polyester Polyurethane
Description	High build, low sheen finish that has excellent resistance to corrosion, chemicals and abrasion. Suitable for application over a number of Carboline primers and intermediates, this material provides very good weathering performance in a broad range of colors.
Features	<ul style="list-style-type: none"> ▪ Outstanding performance properties in both mild and aggressive environments ▪ High build; suitable for many two-coat systems ▪ Suitable for application direct to inorganic zincs ▪ Application by spray, brush or roller ▪ Indefinite recoatability ▪ VOC compliant to current AIM regulations
Color *	Refer to Carboline Color Guide. Certain colors may require multiple coats to hide.
Finish	Satin
Primers	Refer to <i>Substrates & Surface Preparation</i>
Topcoats	Carbothane® Clear Coat when required.
Dry Film Thickness	3.0-5.0 mils (75-125 microns) per coat. Dry film thickness in excess of 7 mils (175 microns) per coat is not recommended.
Solids Content	By Volume: 57% ± 2%
Theoretical Coverage Rate	914 mil ft ² (22.8 m ² /l at 25 microns) 228 ft ² at 4 mils (5.7 m ² /l at 100 microns) Allow for loss in mixing and application.
VOC Values	As supplied: 3.2 lbs/gal (383 g/l) Thinned: 11 oz/gal w/ #25: 3.5 lbs/gal (420 g/l) 18 oz/gal w/ #25: 3.7 lbs/gal (449 g/l) 6 oz/gal w/ #214: 3.3 lbs/gal (403 g/l) 11 oz/gal w/#241: 3.5 lbs/gal (423 g/l) 1.5 oz/gal of Additive 101 adds 0.08 lbs/gal (10g/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) Discoloration and loss of gloss is observed above 200°F (93°C).

* The alignment of aluminum flakes in aluminum-filled finishes is very dependent on application conditions and techniques. Care must be taken to keep conditions as constant as possible to reduce variations in final appearance. It is also advisable to work from a single batch of material since variations can occur from batch to batch. For more information consult Carboline Technical Service Department.

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. Refer to the specific primer's Product Data Sheet for detailed requirements of the specified primer.
Steel	SSPC-SP6 with a 1.5-2.5 mil (37.5-62.5 micron) surface profile for maximum protection. SSPC-SP2 or SP3 as minimum requirement. Prime with specific Carboline primers as recommended by your Carboline sales representative.
Galvanized Steel	Prime with specific Carboline primers as recommended by your Carboline Sales Representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.
Aluminum	SSPC-SP1 and prime with appropriate Carboline primer as recommended by your Carboline sales representative.
Previously Painted Surfaces	Lightly sand or abrade to roughen and degloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scratch" adhesion test. Prime with specific Carboline primers as recommended by your Carboline sales representative.

Performance Data

Test Method	System	Results	Report #
ASTM D4213 Scrub Resistance	1 ct. 133 HB	.0027 microliters erosion rate after 100 cycles with abrasive scrub medium.	03403
ASTM G26 Weatherometer	Blasted Steel 1 ct. IOZ 1 ct. 133 HB	No blistering, rusting or cracking after 3500 hours.	01982
ASTM G53 QUV (2500 hours w/ UVA 340 bulb)	Blasted Steel 1 ct. Epoxy 1 ct. 133 HB	Color change less than 2 McAdam units; no blistering, rusting, cracking or chalking.	03394
ASTM B117 Salt Fog	Blasted Steel 1 ct. OZ 1 ct. 133 HB	No rusting, or blistering on plane or scribe 4,000 hours	02585
ASTM B117 Salt Fog	Blasted Steel 1 ct. IOZ 1 ct. 133 HB	No rusting, or blistering on plane or scribe 2,000 hours	02585
ASTM D5894 QUV A Prohesion	1 ct. 133 HB	No effect on plane area and 78% gloss retention after 1008 hours of wet/dry salt fog cycle	03274
ASTM D4585 Humidity	Blasted Steel 1 ct. IOZ 1 ct. 133 HB	No rusting or blistering after 3000 hours.	02585
Graffiti Resistance	Blasted Steel 1 ct. Epoxy 1 ct. 133 HB	All markings and stains removed by solvent after exposure to: shoe polish, Sharpie marker, crayon, lipstick, spray cans of acrylic, alkyd and epoxy.	03395
ASTM D1735 Water Fog	Blasted Steel 1 ct. Epoxy 1 ct. 133 HB	No rusting or blistering after 8600 hours.	02061

Test reports and additional data available upon written request.

