

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Aliphatic Acrylic-Polyester Polyurethane
<b>Description</b>	High build, semi-gloss, low-HAP's 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.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Outstanding performance properties in both mild and aggressive environments</li> <li>• High build; suitable for many two-coat systems</li> <li>• Application by spray, brush or roller</li> <li>• Indefinite recoatability</li> <li>• VOC compliant to current AIM regulations</li> <li>• Low HAPs content</li> </ul>
<b>Color</b>	Refer to Carboline Color Guide. This is a Made-to-Order product.
<b>Finish</b>	Semi-Gloss
<b>Primer</b>	Carbozinc, Carboguard and Carbomastic or other primers as specified. Refer to Substrates & Surface Preparation.
<b>Dry Film Thickness</b>	3 - 5 mils (76 - 127 microns) per coat Dry film thickness in excess of 7 mils (175 microns) per coat is not recommended.
<b>Solids Content</b>	By Volume 61% +/- 2%
<b>Theoretical Coverage Rate</b>	978 ft <sup>2</sup> /gal at 1.0 mils (24.0 m <sup>2</sup> /l at 25 microns) 326 ft <sup>2</sup> /gal at 3.0 mils (8.0 m <sup>2</sup> /l at 75 microns) 196 ft <sup>2</sup> /gal at 5.0 mils (4.8 m <sup>2</sup> /l at 125 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 2.7 lbs./gal (324 g/l) These are nominal values and may vary slightly with color.
<b>Dry Temp. Resistance</b>	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Discoloration and loss of gloss is observed above 200°F(93°C).

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	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.
<b>Steel</b>	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.
<b>Galvanized Steel</b>	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.

### SUBSTRATES & SURFACE PREPARATION

<b>Aluminum</b>	SSPC-SP1 and prime with appropriate Carboline primer as recommended by your Carboline sales representative.
<b>Previously Painted Surfaces</b>	Lightly sand or abrade to roughen and degloss the surface. Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 "X-Scribe" adhesion test. Prime with specific Carboline primers as recommended by your Carboline sales representative.

### MIXING & THINNING

<b>Mixing</b>	Power mix Part A separately, then combine Part B and power mix. DO NOT MIX PARTIAL KITS.
<b>Thinning</b>	<p>Thinning not normally required. Carboline Thinner 225E, 236E or 243E may be used to thin this product to minimize HAP and VOC emissions. Thinner 25 may also be used. Consult Carboline Technical Service for guidance.</p> <p>Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.</p>
<b>Ratio</b>	<p>4:1 Ratio (A to B)</p> <p><b>1.0 Gal Kit</b> Part A: 1 gal can (part filled) UC 8800: 1 qt (part filled)</p> <p><b>5.0 Gal Kit</b> Part A: 5 gal can (part filled) UC 8800: 1 gal</p>
<b>Pot Life</b>	4 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating becomes too viscous to use. MOISTURE CONTAMINATION WILL SHORTEN POT LIFE AND CAUSE GELLATION.

### 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.

<b>Spray Application (General)</b>	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers.
<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.070" I.D. fluid tip and appropriate air cap.
<b>Airless Spray</b>	<p>Pump Ratio: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.013-0.015" Output PSI: 2100-2300 Filter Size: 60 mesh</p> <p>*PTFE packings are recommended and available from the pump manufacturer.</p>
<b>Brush &amp; Roller (General)</b>	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive rebrushing or re-rolling. For best results, tie-in within 10 minutes at 75°F (24°C).

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**Brush** | Recommended for touch-up only. Use a medium, natural bristle brush.

**Roller** | Use a medium-nap synthetic roller cover with phenolic core.

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	40°F (4°C)	40°F (4°C)	40°F (4°C)	0%
Maximum	100°F (38°C)	110°F (43°C)	110°F (43°C)	90%

Industry standards are for substrate temperatures to be 5°F (3°C) above the dew point. This product simply requires the substrate temperature to be above the dew point.

**Caution:** This Product is moisture sensitive in the liquid stage and until cured. Protect from high humidity, dew and direct moisture contact until cured. Application and/or curing in humidities above maximum, or exposure to moisture from rain or dew may result in a loss of gloss and/or microbubbling of the product

## CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat	Final Cure General
40°F (4°C)	24 Hours	24 Hours	28 Days
50°F (10°C)	15 Hours	15 Hours	14 Days
75°F (24°C)	6 Hours	6 Hours	7 Days
90°F (32°C)	3 Hours	3 Hours	4 Days

These times are based on a 3.0-5.0 mil (75-125 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

**\*Maximum recoat times are indefinite.** Surface must be clean and dry. As part of good painting practice it is recommended to test for adhesion by wiping the surface with Thinner 25. If the film shows a slight “tack” the surface is suitable for recoating without extensive surface preparation such as abrading.

## CLEANUP & SAFETY

<b>Cleanup</b>	Use Thinner 2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	Read and follow all caution statements on this product data sheet and on the SDS for this product and use personal protective equipment as directed.
<b>Ventilation</b>	When used 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.

# Carbothane<sup>®</sup> 133 SG

## PRODUCT DATA SHEET



### PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	Part A: Min. 24 months at 75°F (24°C) Part B: Min. 24 months at 75°F (24°C)  *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
<b>Storage Temperature &amp; Humidity</b>	40° -110°F (4°-43°C) 0-90% Relative Humidity
<b>Storage</b>	Store Indoors.
<b>Shipping Weight (Approximate)</b>	1 Gallon Kit - 15 lbs (7 kg) 5 Gallon Kit - 70 lbs (32 kg)
<b>Flash Point (Setaflash)</b>	Part A: 68°F (20°C) Part B: 28°F (-2°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.