

SELECTION & SPECIFICATION DATA

Generic Type	Fluorourethane
Description	This coating is part of a premium, ultra-weatherable, ambient-cured, metallic finish system. It is a VOC-compliant coating that provides unparalleled weathering resistance and long lasting appearance. A clear finish coat is normally used in combination with this product to maintain metallic appearance over its service life. This product offers a level of durability for field application previously not available in the construction industry. It can also be applied directly to aged PVDF finishes.
Features	<ul style="list-style-type: none"> • Metallic-filled appearance • Ambient temperature cure; no heat cure required • Exceptional weatherability (especially with Clear) • Excellent graffiti resistance • VOC compliant to current SCAQMD regulations
Color	Metallic appearance. Colored metallics are Special Order and limited due to VOC restrictions regarding colorants. It is recommended that customers pre-approve color samples prior to manufacture.
Finish	N/A A clear coat is normally used as a finish.
Primer	Refer to Substrates & Surface Preparation
Dry Film Thickness	2 mils (51 microns) per coat
Solids Content	By Volume 35% +/- 2%
Theoretical Coverage Rate	561 ft ² /gal at 1.0 mils (13.8 m ² /l at 25 microns) 281 ft ² /gal at 2.0 mils (6.9 m ² /l at 50 microns) Allow for loss in mixing and application.
VOC Value(s)	Per EPA Method 24: 0.81 lbs./gal (97 g/l) This product contains US EPA VOC-exempt solvent(s).
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Slight discoloration and loss of gloss is observed above 200°F (93°C)
Limitations	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.
Steel	Prime with specific Carboline primers as recommended by your Carboline Sales Representative.

Carboxane[®] 950 MC Metallic

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Galvanized Steel	Prime with specific Carboline primers as recommended by your Carboline Sales Representative.
Aluminum	Prime with specific Carboline primers as recommended by your Carboline Sales Representative.
Aged PVDF Finishes	SSPC-SP1 (A test patch adhesion check is recommended.)
Other Aged Finishes	Must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" adhesion test. Prime with specific Carboline primers as recommended by your Carboline Sales Representative.

MIXING & THINNING

Mixing	Power mix Part A, then combine and power mix to a uniform consistency. DO NOT MIX PARTIAL KITS.
Thinning	Thin up to 10% using Thinner 236E.
Ratio	3.2 Gal. Kit Part A: 3 gal Urethane Converter MC: 0.2 gal 1 Gal Kit Part A: 0.94 gal Urethane Converter MC: 0.06 gal
Pot Life	4 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating becomes too viscous to use. THIS PRODUCT IS MOISTURE SENSITIVE. AVOID MOISTURE CONTAMINATION.

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)	The following spray equipment has been found suitable and is available from manufacturers. Metallic finishes require use of either conventional or air-assisted airless for best results and appearance.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.070" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.011-0.015" Output PSI: 2000-2300 Filter Size: 60 mesh *PTFE packings are recommended and available from the pump manufacturer.
Brush	Not recommended for metallic finishes due to poor appearance.
Roller	Not recommended for metallic finishes due to poor appearance and coverage.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	40°F (4°C)	40°F (4°C)	0%
Maximum	100°F (38°C)	120°F (49°C)	95°F (35°C)	80%

Industry standards are for substrate temperatures to be above 5°F (3°C) the dew point. Special application techniques may be required above or below normal application conditions.

Caution: Product is moisture sensitive. Application and/or curing in humidity 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
50°F (10°C)	6 Hours	6 Hours	24 Hours
75°F (24°C)	3 Hours	3 Hours	20 Hours
90°F (32°C)	2 Hours	2 Hours	16 Hours

*These times are based on a 2.0 mil (50 micron) dry film thickness and 50% RH. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

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 SDS for this product. Employ normal workmanlike safety precautions.
Ventilation	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. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	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.
Storage Temperature & Humidity	40°–110°F (4°–43°C) 0-80% Relative Humidity
Storage	Store Indoors
Shipping Weight (Approximate)	1 Gallon Kit - 12 lbs (5 kg) 3.2 Gallon Kit - 40 lbs (18 kg)

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PACKAGING, HANDLING & STORAGE

Flash Point (Setaflash)	Part A: 109°F (43°C)
	Part B: 109°F (43°C)

WARRANTY

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