

SELECTION & SPECIFICATION DATA

Generic Type	Aliphatic Polyaspartic
Description	This fast-cure, high-build polyaspartic coating provides good corrosion protection plus long term weatherability in just one coat. It can be applied direct to metal (DTM). For improved corrosion protection it can be applied over approved primers including Carbozinc 859. These 1 - 2 coat systems can eliminate the need for typical primers and/or intermediate coats to significantly speed up the painting process. Suitable for use in USDA inspected facilities.
Features	<ul style="list-style-type: none"> • Fast cure with good pot life - speeds the painting process • High build, up to 10 mils DFT per coat • Can be applied direct to metal (DTM) • Excellent corrosion protection - ISO 12944-6 C3 Low, DTM; C5 High over Carbozinc 859 • Excellent corrosion protection over phosphatized carbon steel - ISO 12944-6 C3 High • Excellent weathering - SSPC Ctg. Spec. No. 39 Level 3A (highest level) • 1 - 2 coats instead of 2 - 3 coats saves significant time, labor and money • Excellent durability - abrasion and impact resistant • Low VOC and low HAPS • Indefinite recoatability
Color	White (1864) A wide range of colors is available upon request using Carboline's Rapid Tint System (RTS). Contact your Carboline representative for RTS color availability.
Gloss	Gloss
Primer	Self-priming, DTM, for many applications. For more severe service use with one of the following approved Carboline primers: Carbozinc 11 Series; Carbozinc 859; Carbozinc 808; Carboguard 635 Series; or Carboguard 8922 Series. Contact Carboline for recommendations.
Dry Film Thickness	6 - 10 mils (152 - 254 microns) per coat Can be applied at 4 - 5 mils DFT (102 - 127 microns) when applied over approved primer(s).
Solids Content	By Volume 69% +/- 2%
Theoretical Coverage Rate	1107 ft ² /gal at 1.0 mils (27.2 m ² /l at 25 microns) 184 ft ² /gal at 6.0 mils (4.5 m ² /l at 150 microns) 111 ft ² /gal at 10.0 mils (2.7 m ² /l at 250 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 2.02 lbs/gal (242 g/l) These values may vary by color.
HAPs Values	0.03 lbs/solid gallon. This value may vary by color.

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Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C)
	Discoloration may occur at temperatures near 200 °F, 93 °C.

SUBSTRATES & SURFACE PREPARATION

General	Clean to remove all contaminants per SSPC-SP 1.
Steel	Minimum Commercial Blast Clean per NACE No. 3/SSPC-SP 6 with a 2.0 - 3.0 mil (50 - 75 micron) anchor profile for maximum protection.
Galvanized Steel	Clean per SSPC-SP 16 with 2.0 - 3.0 mils (50 - 75 micron) anchor profile or prime as recommended by your Carboline Sales Representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.
Phosphatized Steel	Clean to remove all contaminants per SSPC-SP 1.
Non-Ferrous Metals	Clean per SSPC-SP 16 with 2.0 - 3.0 mils (50 - 75 microns) anchor profile or prime as recommended by your Carboline Sales Representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix thoroughly.
Thinning	Not normally required. Can be reduced up to 6 oz/gal with Thinner 242 E, Thinner 236 E, or Thinner 225 E.
	Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	2:1 (Part A to Part B)
Pot Life	2 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. Remove any skin that may form on top of the mixed product in the container.

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	It may be necessary to make adjustments in spray techniques since wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from various manufacturers.
Conventional Spray	Pressure pot equipped with dual regulators, minimum 3/8" I.D. material hose, 0.070" I.D. fluid tip and appropriate air cap.

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Airless Spray	<ul style="list-style-type: none"> • Pump Ratio: 30:1 (min.) • Volume Output: minimum 2.5 gpm (9.5 l/min.) • Airless Hose: 3/8" I.D. min. (9.5 mm min.) • Tip Size: 0.013 - 0.019" (0.33 - 0.48 mm) • Output PSI: 2,200-2,800 psi (155 - 197 kg/cm²) • Filter Size: 60 mesh • PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	<p>Recommended for small areas or touch-up only. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive brushing and rolling. For best results, tie-in within 10 minutes at 75 °F (24 °C).</p>

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	40°F (4°C)	35°F (2°C)	35°F (2°C)	10%
Maximum	90°F (32°C)	140°F (60°C)	110°F (43°C)	95%

Substrate temperatures must be 5°F (3°C) above the dew point. Caution: this product reacts with moisture in order to complete the final cure. Relative humidity below 30% will slow cure time.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle or Recoat	Final Cure General
35°F (2°C)	2 Hours	8 Hours	7 Days
40°F (4°C)	1.5 Hours	6 Hours	7 Days
50°F (10°C)	50 Minutes	4 Hours	7 Days
75°F (24°C)	30 Minutes	1 Hour	4 Days
90°F (32°C)	20 Minutes	45 Minutes	2 Days

These times are based on 50% relative humidity (RH). RH lower than 50%, higher film thickness, insufficient ventilation and/or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity and/or condensation on the surface during curing can interfere with the cure, can cause micro-foaming and may result in loss of sheen and/or discoloration. Maximum recoat times are indefinite. As part of good painting practice it is recommended to first test for adhesion by wiping the surface with Thinner 76 or one of the other solvents listed for thinning. If the film shows a slight "tack" the surface is suitable for recoating without abrading to create profile.

CLEANUP & SAFETY

Cleanup	Use Thinner 2, Thinner 225 E or Acetone. In case of spillage, 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. Use adequate ventilation. Keep container closed when not in use.

CLEANUP & SAFETY

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. User should test and monitor exposure levels to insure all personnel are below guidelines. If not able to monitor levels, use MSHA/NIOSH approved respirator.
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PACKAGING, HANDLING & STORAGE

Shelf Life	<ul style="list-style-type: none">• Part A: Minimum 24 months at 75 °F (24 °C)• Part B: Minimum 24 months at 75 °F (24 °C) Shelf life: keep at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40 -110 °F (4-43 °C), 0-90% Relative Humidity
Storage	Store indoors. This product is solvent based and not affected by excursions below these published storage temperatures, down to 10 F, for a duration of no more than 14 days. Always inspect the product prior to use to make sure it is smooth and homogeneous when properly mixed.
Shipping Weight (Approximate)	<ul style="list-style-type: none">• 0.75 gallon kit: 10.25 lbs (4.65 kg)• 3 gallon kit: 41.0 lbs (18.6 kg)
Flash Point (Setaflash)	<ul style="list-style-type: none">• Part A: 50°F, (10°C)• Part B: 80°F, (27°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 to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. 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. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.