

SELECTION & SPECIFICATION DATA

Generic Type	Aliphatic Polyaspartic
Description	<p>This fast cure high build polyaspartic coating provides excellent corrosion protection as well as long term weatherability in just one coat. It can be applied direct to metal (DTM) at 6 to 10 mils dry film thickness (DFT) to eliminate the need for typical primers and/or intermediate coats. This significantly speeds up the painting process, saves labor, and saves money without sacrificing performance. If even better corrosion protection is desired it can be applied over our time proven Carbozinc, Carbomastic, or Carboguard primers.</p>
Features	<ul style="list-style-type: none"> • Fast cure speeds the painting process • High build, 6 to 10 mils DFT per coat • Excellent corrosion protection • Meets ISO 12944-6 C3 High, one coat applied DTM • Saves significant time, labor and money • Excellent weathering • Exceeds SSPC Coating Specification No. 39 Level 3A, highest level for aliphatic polyurea • Exceeds SSPC Coating Specification No. 36 Level 3A, highest level for aliphatic polyurethane • Very good flexibility and elongation • Excellent abrasion and impact resistance • Excellent wetting and adhesion • Extremely durable to help provide long service life • Low VOC and low HAPS • Suitable for use in USDA inspected facilities • Indefinite recoatability
Color	1864 White and a broad range of colors are available using Carboline rapid tint system.
Gloss	High Gloss
Primer	<p>Self-priming, DTM, for many applications. For more severe service use with one of the following approved Carboline primers: Carbozinc 11 Series; Carbozinc 608 HB; Carbozinc 808; Carbozinc 8701 with overnight cure; Carboguard 60 Series; Carboguard 61; Carboguard 635 Series; Carboguard 890 or CG 8922 Series.</p> <p>Contact Carboline for recommendations.</p>
Dry Film Thickness	<p>6 - 10 mils (152 - 254 microns) per coat</p> <p>Can be applied at 4-5 mils DFT (102-127 microns) when applied over approved primer(s).</p>
Solids Content	By Volume 70% +/- 2%
HAPs Values	<p>0.07 lbs/solid gallon.</p> <p>This value may vary by color.</p>
Theoretical Coverage Rate	<p>1123 ft²/gal at 1.0 mils (27.6 m²/l at 25 microns) 187 ft²/gal at 6.0 mils (4.6 m²/l at 150 microns) 112 ft²/gal at 10.0 mils (2.8 m²/l at 250 microns) Allow for loss in mixing and application.</p>

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VOC Values	As Supplied : 2.05 lbs/gal As Supplied : 246 g/l These values may vary by color.
Dry Temp. Resistance	Continuous: 250°F (121°C) Non-Continuous: 300°F (149°C) Discoloration may occur at temperatures near 200 °F, 93 °C.

SUBSTRATES & SURFACE PREPARATION

General	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 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.
Phosphatized Steel	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 the following: Thinner 236 E; Thinner 10; or Thinner 76. For warmer temperatures use Thinner 214 or Thinner 25. Use of thinners other than those supplied or recommended by Carboline may adversely effect product performance and void product warranty, whether expressed or implied.
Ratio	2:1 (Part A to Part B)
Pot Life	1.5 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.

Spray Application	This is a high solids coating and it 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 the 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.) • Tip Size: 0.013-0.017" • Output PSI: 1,700-2,300 • 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 re-brushing or re-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%

Industry standards are for substrate temperatures to be 5 °F (3 °C) above the dew point. This product simply requires the substrate to be above the dew point. Caution: this product does react with atmospheric moisture in order to complete 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)	3 Hours	17 Hours	7 Days
40°F (4°C)	2.5 Hours	16 Hours	7 Days
50°F (10°C)	2 Hours	7 Hours	7 Days
75°F (24°C)	30 Minutes	1.5 Hours	4 Days
90°F (32°C)	30 Minutes	1 Hour	2 Days

These times are based on 50% relative humidity (RH) and 6-10 mils (152-254 microns) dry film thickness (DFT). At 4-5 mils DFT (102-127 microns), 75 °F, and 50% RH the Dry To Handle Times are approximately 50-60 minutes. 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 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 and use personal protective equipment as directed.

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 supplied air 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) <p>*Shelf life: keep at recommended storage conditions and in original unopened containers.</p>
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: 10.1 lbs (4.59 kg)• 3 gallon kit: 35.5 lbs (16.1 kg)
Flash Point (Setaflash)	<ul style="list-style-type: none">• Part A: 42 °F, (5.6 °C)• Part B: 42 °F, (5.6 °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.