

SELECTION & SPECIFICATION DATA

Generic Type	Solventless, two component, cross-linked epoxy.
Description	This is a solvent-free and BPA-free, flexible epoxy lining specifically developed for tank cars that transport liquid food products including corn syrup. This lining is applied by heated, plural-component airless spray, as a one coat lining.
Features	<ul style="list-style-type: none"> • Tough, flexible, abrasion resistant liner • Single coat, high performance protection • Low-to-no odor • Easy to apply by plural component airless • Complies with FDA 21 CFR 175.300 criteria for food contact • Bisphenol-A free formulation • Excellent chemical resistance • Fast cure • Excellent corrosion protection • Impact resistant • High build application in one coat
Color	Available in Blue (4169) and Gray (0700).
Finish	Gloss (Epoxies lose gloss, discolor and eventually chalk in sunlight exposure).
Primer	Self-priming
Dry Film Thickness	8 - 12 mils (203 - 305 microns) in a single coat Dry film Thickness in excess of 18 mils (400 microns) is not recommended.
Solids Content	By Volume 99% +/- 1%
Theoretical Coverage Rate	1588 ft ² /gal at 1.0 mils (39.0 m ² /l at 25 microns) 198 ft ² /gal at 8.0 mils (4.9 m ² /l at 200 microns) 132 ft ² /gal at 12.0 mils (3.2 m ² /l at 300 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 0.04 lbs/gal (5 g/l) per EPA Method 24 These are nominal values and may vary slightly with color.

SUBSTRATES & SURFACE PREPARATION

General	Remove all oil or grease from the surface to be coated with clean rags soaked in Thinner 2 or Carboline Surface Cleaner 3 (refer to Surface Cleaner 3 instructions) in accordance with SSPC-SP1. For girth weld areas, all burrs, weld slag and other matter shall be removed to achieve a smoother surface prior to blasting.
Steel	Abrasive blast to a Near White Metal Finish in accordance with SSPC-SP 10 and obtain a 2.0-3.0 mil (50-75 micron) blast profile.

MIXING & THINNING

Mixing	Premix each component separately to ensure homogeneity, prior to mixing/spraying.
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MIXING & THINNING

Thinning	Thinning is not required. 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	By volume: 1:1 Ratio (Part A to Part B)
Pot Life	30 minutes in a one-quart mass at 75°F (24°C), less than 5 minutes at 130°F (54°C). The pot life ends when the material becomes too viscous to use.

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 multiple manufacturers.

Plural Component Airless Spray | Airless plural component, heated spray equipment capable of 3000 psi with a mixer manifold and whip hose is required for the application of this material. Contact Carboline Technical Service for additional information.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	120°F (49°C)	55°F (13°C)	55°F (13°C)	10%
Maximum	130°F (54°C)	110°F (43°C)	110°F (43°C)	80%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Chemical Exposure	Dry to Touch	Dry Hard	Final Cure
75°F (24°C)	5.5 Hours	6 Hours	10 Hours	NR
120°F (49°C)	NR	NR	NR	3.5 Hours

For the Final Cure cycle, increase the surface temperature from 75°F(24°C) to 120°F(49°C) at a rate not exceeding 30°F(16°C) every 15 minutes.

Cure times are based on 50% relative humidity.

CLEANUP & SAFETY

Cleanup | Use #2 Thinner 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.

CLEANUP & SAFETY

Ventilation	When used as a tank lining or 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.
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PACKAGING, HANDLING & STORAGE

Shelf Life	Part A & B: 18 months* at 75°F (24°C) *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)	10 Gallon Kit - 128 lbs. (58 kg) 100 Gallon Kit - 1290 lbs. (585 kg)
Flash Point (Setaflash)	Part A: >205°F (96°C) Part B: >205°F (96°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.