

SELECTION & SPECIFICATION DATA

Generic Type	A two component, high solids, modified epoxy
Description	This product is formulated for use as a topcoat over Stratholiner 7100 primer and Stratholiner 7150 intermediate coat to form a protective lining system with excellent resistance to adipic, acetic and hydrochloric acids.
Features	<ul style="list-style-type: none"> • Excellent resistance to acetic and hydrochloric acids • High solids • Very low water vapor transmission rate
Color	Blue or per customer requirements
Dry Film Thickness	8 - 10 mils (203 - 254 microns) as topcoat for most areas of a tank car 13 - 16 mils (330 - 406 microns) for roof area Designed to be applied in one or 2 coats as a topcoat.
Typical Uses	<ul style="list-style-type: none"> • Tank car lining system for acetic hydrochloric acids • Dry bulk hopper cars with residual process acids
Solids Content	By Volume 67% +/- 2%
Theoretical Coverage Rate	1075 ft ² /gal at 1.0 mils (26.4 m ² /l at 25 microns) 134 ft ² /gal at 8.0 mils (3.3 m ² /l at 200 microns) 67 ft ² /gal at 16.0 mils (1.6 m ² /l at 400 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : Per EPA Method 24: 2.3 lbs/gal (275 g/l) max These are nominal values and may vary slightly with color.

SUBSTRATES & SURFACE PREPARATION

Steel	Blasted and primed with Stratholiner 7100 and then Stratholiner 7150
Aluminum	Remove all surface contaminants and treat with Strathmore's Wash Primer or equivalent. Primed with Stratholiner 7100 and then Stratholiner 7150.

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	Results
Abrasion Resistance (ASTM D4060) CS17 wheel, 1kg load, 1000 cycles	50 mg loss
Adhesion (ASTM D4541)	1800 psi
Hardness (ASTM D3363)	4H
Heat Resistance (ASTM 2485)	Dry, 225°F (107°C)
Salt Spray (ASTM B117)	2000+ hours

Thermal Shock Resistance: 10 cycles water 33°F to 200°F (0°C to 93°C)

Chemical Resistance: Process acids in plastic pellets and granules

MIXING & THINNING

Mixing	For hand mixing of touch up or repair kits, if necessary Agitate thoroughly each component before combining Agitate thoroughly again after combining
Thinning	0-5% by volume maximum Consult Carboline for recommendations
Ratio	1:1 by volume (A:B)
Pot Life	4 hours @ 77°F (25°C) Caution: Pot life is significantly reduced with heat

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.

Plural Component	Heated plural component equipment. Do not exceed 120°F (49°C) Tip Size: 0.019 to 0.025" (0.48-0.64 mm) Pump Pressure: 2800 psi (19.3 MPa) minimum
-------------------------	--

APPLICATION CONDITIONS

Condition	Material
Minimum	60°F (16°C)

Metal temperature must be a minimum of 5°F (3°C) above the dew point during the surface preparation and coating application.

CURING SCHEDULE

Surface Temp.	Dry Hard	Set Time	Tack Free
77°F (25°C)	12 Hours	2 Hours	8 Hours

Recoat: Mandatory 2 hour ambient air flash time, then overnight cure of forced air @ 90-100°F (32-38°C) for 12 hours minimum.

In Service Times:

- After force cure of 150°F (66°C) for 6 hours, or
- Two weeks air dry @ 77°F (25°C)

Force Cure	After coating application, allow to air dry with circulated 90-100°F (32-38°C) heat for 12 hours minimum. Perform electrical holiday test for discontinuities. All tests and touch-ups must be made before a force cure. The ramp-up rate for the force cure shall be a rise of 30°F metal temperatures every 30 minutes. The soak temperature shall be 200°F (93°C) metal temperature for 2 hours or 150°F (66°C) metal temperature for 6 hours.
-------------------	---

CLEANUP & SAFETY

Cleanup	MEK may be used for clean up. Batch mixed material will set up in the lines and equipment if left overnight. With plural component equipment, be sure to flush from the mixing head through the delivery hose and guns.
----------------	---

CLEANUP & SAFETY

Safety	Handle with care. Before and during use, observe all safety labels on packaging and paint containers and follow all caution statements on this product data sheet. Consult the Safety Data Sheet (SDS) for this product and follow all local or national safety regulations. Employ normal workmanlike safety precautions.
Ventilation	When used in enclosed areas, thorough air circulation must be used during and after applications until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion levels to ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

PACKAGING, HANDLING & STORAGE

Packaging	5 gallon pails 55 gallon drums
Shelf Life	One year from date of manufacturing when kept at recommended storage conditions at 70°F (21°C) and in original unopened containers. Do not use material beyond shelf life.
Storage Temperature & Humidity	Do not store at temperatures above 100°F (38°C).
Storage	Containers must be closed tightly. Do not store outside. Rotate stock.
Flash Point (Setaflash)	Part A: 107°F (42°C) Part B: 71°F (22°)

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.