

SELECTION & SPECIFICATION DATA

Generic Type	Single package silicone acrylic finish (air-drying)
Description	Air-dried coating suitable for high temperature exposures up to 525°F (273°C). Air-drying characteristics allow for faster handling of in-shop applications than with other high-temperature coatings. Heat cure above 300°F (149°C) is acceptable and will impart added strength and integrity to the coating.
Features	<ul style="list-style-type: none"> • Temperature resistance up to 525°F (273°C) • Single-coat application • Excellent resistance to thermal shock • Good weathering • VOC compliant
Color	C901 (Aluminum) only
Finish	Semi-Gloss
Primer	<ul style="list-style-type: none"> • Self-priming on stainless steel, aluminum and metalized surfaces. • For carbon steel, apply over recommended inorganic zinc primer. • A mist coating may be required to minimize bubbling over inorganic zinc primers. • Do not use as a topcoat over Thermaline Heat Shield.
Dry Film Thickness	<p>1.5 - 2 mils (38 - 51 microns) per coat</p> <p>Do not exceed 2.5 mils (63 microns) in a single coat.</p>
Solids Content	By Volume 44% +/- 2%
Theoretical Coverage Rate	<p>706 ft²/gal at 1.0 mils (17.3 m²/l at 25 microns)</p> <p>471 ft²/gal at 1.5 mils (11.5 m²/l at 38 microns)</p> <p>353 ft²/gal at 2.0 mils (8.7 m²/l at 50 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Value(s)	<p>Per EPA Method 24: 2.74 lbs/gal (329 g/l)</p> <p>16 oz/gal of Thinner 236 E: 2.74 lbs/gal (329 g/l)</p> <p>This product contains US EPA VOC-exempt solvent(s).</p>
Topcoats	Not Applicable

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	<p>SSPC-SP 10 with a 1.0-1.5 (13-25 micron) surface profile when applying direct to metal. When going over a Carboline recommended primer, follow the surface preparation requirements for that primer.</p> <p>* 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.</p>

Thermaline[®] 4900 VOC Aluminum

PRODUCT DATA SHEET



MIXING & THINNING

Mixing | Thoroughly mix to a uniform consistency prior to use.

Thinning | Normally not required. May be thinned up to 16 oz/gal. (12.5%) by volume with Thinner #236E for "hot" applications exceeding 150°F (66°C). Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

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 for application of this material. Conventional spray application is preferred.

Conventional Spray | Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.052" I.D. fluid tip and appropriate air cap. Use adequate air volume for proper equipment operation. Hold gun 10-12" from the surface and at right angles. Lap each pass 50%. Apply 4.0-5.0 wet mils to obtain desired dry film.

Airless Spray | Not recommended.

Brush & Roller (General) | Recommended for touch up of small areas or where spray application is not permitted. Avoid excessive re-brushing or re-rolling.

Brush | Use a medium bristle brush.

Roller | Use a short-nap mohair roller cover with solvent resistant core.
Note: Different application procedures or methods will result in streaky or non-uniform appearance with aluminum containing products.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	55°F (13°C)	40°F (4°C)	40°F (4°C)	0%
Maximum	95°F (35°C)	300°F (149°C)	120°F (49°C)	90%

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.	Dry to Topcoat with Itself	Dry to Touch
77°F (25°C)	4 Hours	1 Hour

These times are based on a 2.0 mils (50 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. While Thermaline 4900 VOC Aluminum will air dry at ambient, optimum film properties are achieved with heat curing. The heat cure cycle consists of a minimum 2-hour flash off at 75°F (24°C) followed by slowly raising the substrate temperature to 300°F (149°C) and hold for at least 3 hours.

CLEANUP & SAFETY

Cleanup	Use Thinner #2. 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. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not able to monitor levels, MSHA/NIOSH approved supplied air respirator may be required.
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	Min. 24 months at 77°F (24°C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40°F-100°F (4-43°C) 0-90% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	1 Gallon - 14 lbs. (6.4 kg) 5 Gallon - 70 lbs. (32 kg)
Flash Point (Setaflash)	102°F (39°C) 98°F (37°C) C901 Aluminum

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.