

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Water-based Acrylic Elastomer
<b>Description</b>	This self priming, high build coating is designed for minimally prepared sound rusted or clean steel in mild to moderate industrial environments. Two coats are required. It can also be used on concrete, and the excellent elongation properties of 200% make it suitable for bridging small cracks. Noxyde is not recommended for exposure to most hydrocarbon solvents. Noxyde is suitable for over-coating previous coating systems that are in good sound condition. Noxyde is a trademark of the Rust-Oleum Corporation.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Rust-inhibitive; surface tolerant coating</li> <li>• Flexible, elastomeric film</li> <li>• Tolerant over sound existing coatings</li> <li>• Water-based, low odor</li> <li>• Dry-fall properties (min 8 feet)</li> </ul>
<b>Color</b>	Bright White (0800); Off White (6791) Blue (1193); Brown (2279) Blue Grey (2753); English Red (5492) Black (C900); Reseda Green (D396) Beige Gray (F771); Gray Green (G331) Gravel Gray (G751); Moss Green (N335)
<b>Finish</b>	Satin
<b>Primer</b>	Normally self-priming, refer to Substrates & Surface Preparation.
<b>Dry Film Thickness</b>	7 mils (178 microns) per coat Apply 2 coats.
<b>Solids Content</b>	By Volume 55% +/- 2%
<b>Theoretical Coverage Rate</b>	882 ft <sup>2</sup> /gal at 1.0 mils (21.7 m <sup>2</sup> /l at 25 microns) 126 ft <sup>2</sup> /gal at 7.0 mils (3.1 m <sup>2</sup> /l at 175 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : (EPA 24) 0.33 lbs/gal (40 g/l) These are nominal values.
<b>Dry Temp. Resistance</b>	Non-Continuous: 225°F (107°C) Prolonged or continuous exposure to temperatures above 175°F (80°C) will have a negative effect on the service life of the coating.
<b>Limitations</b>	<ul style="list-style-type: none"> <li>• Surface has a slight tack after curing. A suitable topcoat is recommended for custom colors, gloss and cleanability.</li> <li>• Product has dry-fall properties; however overspray should be avoided on hot (120°F/49°C) metal surfaces.</li> </ul>
<b>Topcoats</b>	Use Carbocrylic 3359 or 3359 DTM for custom colors; higher gloss or easier cleanability.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Surfaces <u>must</u> be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
<b>Steel</b>	Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove loose rust, scale and deteriorated coatings to obtain a sound rusted surface. A rusted surface is considered to be sound when rust can no further be removed by scraping the surface by hand using a dull putty knife under moderate pressure. The surface may also be prepared by the use of High Pressure Water Cleaning (HP WC), minimum pressure 5,000 psi, in accordance to SSPC-SP WJ-4/NACE WJ-4 Light Cleaning.
<b>Galvanized Steel</b>	It is recommended to allow galvanized steel to weather before topcoating. The surface may be prepared by the use of High Pressure Water Cleaning (HPWC), minimum pressure 5,000 psi, in accordance to SSPC-SP WJ-4/NACE WJ-4 Light Cleaning. Then roughen by abrasive blasting or power tool to achieve a 1 mil profile.
<b>Concrete or CMU</b>	Concrete <u>must</u> be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Laitance, form oils, curing agents and hardeners <u>must</u> be removed by suitable method before coating application. Concrete may be coated with a suitable block filler as desired. Mortar joints should be thoroughly cured for a minimum of 15 days at 75°F (24°C) and 50% relative humidity or equivalent. Prime surfaces with 1.5 mils (40 microns) of Noxyde thinned 20% with clean potable water followed by successive full coats.
<b>Previously Painted Surfaces</b>	Thoroughly cured, hard or glossy previous coatings which are very smooth may require scuff sanding to maximize adhesion.

## PERFORMANCE DATA

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

Test Method	System	Results
Abrasion Resistance ASTM D4060 CS-17/1000 g/1000 cycles	Noxyde (14 mils)	29 mg loss
Adhesion ASTM D4541	Noxyde (14 mils)	747 psi (5.2 MPa) over SP10 652 psi (4.5 MPa) over WJ-4
Cyclic Weathering ASTM D5894 1000 hours	Noxyde (14 mils) over SP10 and WJ-4	Blistering: None Delamination: None Scribe Undercutting: 0.5 mm (SP10) and <0.5 mm (WJ-4)
Flexibility ASTM D522 Conical Mandrel	Noxyde (14 mils)	48%
Impact Resistance ASTM D2794	Noxyde (14 mils)	160 inch-lbs
Moist Sulfur Dioxide Resistance ASTM G87 30 cycles	Noxyde (14 mils)	No effect
Relative Humidity (100%) Exposure ASTM D2247 4000 hours	Noxyde (14 mils)	No effect

Tested over steel substrates unless otherwise indicated.

## MIXING & THINNING

<b>Mixing</b>	Power mix until uniform in consistency.
<b>Thinning</b>	Normally not required. Thin 20% with clean fresh water when using as a prime coat on non-porous or smooth concrete or metal surfaces.

## 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.

<b>Spray Application (General)</b>	The following recommendations are the result of equipment manufacturer's testing and field experience. Contact the specific equipment manufacturer if using equipment other than described here.
<b>Conventional Spray</b>	Not recommended
<b>Airless Spray</b>	Pump: Use a pump suitable for maintaining 2500 psi Material Hose: Minimum ¼ inch or larger for long distances Tip Size: 0.013-0.017" Filter: 60 mesh
<b>Brush &amp; Roller (General)</b>	BRUSH: Touch-up and spot priming only. Use a good quality synthetic bristle. ROLLER: Use a good quality synthetic ½" nap roller cover.

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	46°F (8°C)	46°F (8°C)	0%
Maximum	100°F (38°C)	130°F (54°C)	130°F (54°C)	80%

**Do not apply when the surface temperature is less than 5°F (3°C) above the dew point. Do not apply if temperatures are expected to drop below 46°F (8°C) within 24 hours of application.** Water base products are sensitive to moisture during cure. **Do not apply to frozen block or any masonry surface that has not completely thawed.** Special application techniques may be required above or below normal application conditions.

## CURING SCHEDULE

Surface Temp.	Tack Free	Dry to Handle	Dry to Recoat	Dry to Topcoat w/ Other Finishes
75°F (24°C)	1 Hour	3 Hours	4 Hours	16 Hours

\*These times are based on a 7.0 mil (175 micron) dry film thickness and 50%RH. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times.

## CLEANUP & SAFETY

<b>Cleanup</b>	Use Carboline Surface Cleaner 3 followed by potable water rinse. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	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 and wear gloves or use protective cream on face and hands if hypersensitive.

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## PACKAGING, HANDLING & STORAGE

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<b>Shelf Life</b>	48 months at 75°F (24°C)
<b>Storage Temperature &amp; Humidity</b>	40° -100°F (4°-40°C) 0-90% Relative Humidity WATER-BASED: PROTECT FROM FREEZING
<b>Shipping Weight (Approximate)</b>	5 Gallons - 59 lbs (26.8 kg)
<b>Flash Point (Setaflash)</b>	Non-flammable

## 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.