

SELECTION & SPECIFICATION DATA

Generic Type	Alkyd Enamel
Description	A high solids, quick-dry, general purpose air dry enamel that is used as a self-priming finish coat. Carbocoat 8215 VOC has exceptional application characteristics, fast dry properties and very good corrosion protection as a direct to metal coatings. Is used as an OEM finish for a variety of applications. It is also recommended for light to moderate industrial use for new construction or maintenance. It meets the 340 g/l VOC limit and has very low HAP's at 0.6 lbs/solid gal.
Features	<ul style="list-style-type: none"> • Smooth, attractive, semi-gloss finish • Direct-to-metal application if desired. • Good weatherability, gloss and color retention • Contains corrosion inhibitor • Excellent application characteristics. • Quick dry to handle times • Good flexibility • Impact and abrasion resistant • VOC-compliant for most areas • HAP's = 0.6 lbs/solid gallon
Color	Available in Rapid Tint Service; See Carboline Color Chart
Finish	Semi-Gloss
Dry Film Thickness	2 - 3 mils (51 - 76 microns) per coat Do not exceed 4.0 mils (100 microns) in a single coat.
Solids Content	By Volume 53% +/- 2%
Theoretical Coverage Rate	850 ft ² /gal at 1.0 mils (20.9 m ² /l at 25 microns) 425 ft ² /gal at 2.0 mils (10.4 m ² /l at 50 microns) 283 ft ² /gal at 3.0 mils (7.0 m ² /l at 75 microns) Allow for loss in mixing and application.
VOC Value(s)	Per EPA Method 24: 2.8 lbs./gal (336 g/l) Thinner 242 E - Thinned 5%: 2.8 lbs./gal (336 g/l) These are nominal values and may vary slightly with color. Product contains VOC-exempt t-butyl acetate. Check local regulations regarding product usage.
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Slight discoloration and loss of gloss is observed above 200 F (66 C)
Limitations	Not for immersion applications or splash and spillage of acids, alkalies or solvents.

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.
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Carbocoat[®] 8215 VOC

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Steel	Direct-to-Metal Minimum SSPC-SP3. If abrasive blasted, profile should not exceed 2.0 mils (50 microns).
	Phosphatized Steel 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.

MIXING & THINNING

Mixing	Power mix until uniform in consistency
Thinning	Normally not required. Up to 5% with Thinner 242E. 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 and is available from equipment manufacturers.
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.
Airless Spray	Pump Ratio: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.015-0.019" Output PSI: 1800-2700 Filter Size: 60 mesh *PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Avoid excessive re-brushing or re-rolling.
Brush	Use a medium bristle brush.
Roller	Use a short-nap roller

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	35°F (2°C)	35°F (2°C)	35°F (2°C)	0%
Maximum	120°F (49°C)	120°F (49°C)	120°F (49°C)	95%

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 Hard	Dry to Handle	Dry to Touch
75°F (24°C)	24 Hours	2 Hours	30 Minutes

These times are based on a 3.0 mil (75 micron) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times and could result in solvent entrapment or premature failure. Adhesion develops over a period of time. Wait 30 days before doing adhesion testing.

CLEANUP & SAFETY

Cleanup | Use Thinner #242E 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. Use adequate ventilation and wear gloves or use protective cream on face and hands. Keep container closed when not in use.

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 sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

Caution | This product contains flammable solvents. Keep away from sparks and open flames. In confined areas workers must wear fresh airline respirators. 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 75°F (24°C)
*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.

Storage Temperature & Humidity | 35° -110°F (2°-43°C)
0-100% Relative Humidity

Storage | Store indoors.

Shipping Weight (Approximate) | 1 Gallon - 12 lbs. (5.5 kg)
5 Gallons - 60 lbs. (27 kg)
55 Gallons - 600 lbs. (272 kg)

Flash Point (Setaflash) | 60°F (16°C)

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PRODUCT DATA SHEET



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.