



SELECTION & SPECIFICATION DATA

Generic Type	General Purpose Ambient Cured Epoxy
Description	A two-component ambient cured epoxy based on novel leading edge technology. This product can be used in applications where abrasive blasting is not possible or feasible. It exhibits excellent adhesion on metal substrates prepared as per SSPC SP-11 Surface Preparation Standard.
Features	<ul style="list-style-type: none">• Excellent resistance to cathodic disbonding up to 65°C (149°F) with SSPC SP-11 Surface Preparation.• Excellent adhesion to SSPC SP-11 prepared steel surfaces, Fusion Bond Epoxy (FBE), and Fiber Reinforced Plastic (FRP).• 100% solids• Excellent impact resistance• Good Flexibility• High build single coat application up to 40 mil• Easily applied by spray, brush or roller
Typical Uses	<ul style="list-style-type: none">• Pipelines• Girth welds• Appurtenances• Sewer lines• General piping• Onshore and offshore structures• Lining of pipes and tanks
Color	Blue (0100)
Dry Film Thickness	20 - 50 mils (508 - 1270 microns) DFT Depends upon application. Consult with your SPC Representative.
Solids Content	By Volume 100%
Theoretical Coverage Rate	1604 ft ² /gal at 1.0 mils (39.4 m ² /l at 25 microns) 80 ft ² /gal at 20.0 mils (2.0 m ² /l at 500 microns) 32 ft ² /gal at 50.0 mils (0.8 m ² /l at 1250 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 5 g/L
Dry Temp. Resistance	Continuous: 149°F (65°C)
Specific Gravity	Base: 1.55 ± 0.03 Hardener: 0.96 ± 0.03 Mixed Material: 1.40 ± 0.03

SUBSTRATES & SURFACE PREPARATION

Steel	Cleanliness: SSPC SP-11 or abrasive blasting to NACE no.2/SSPC SP-10, SA 2.5 (ISO 8501-1) Profile: Minimum 25 – 38 microns (1.0 mils to 1.5 mils); Flapper Wheel or Bristle Blaster recommended.
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SP-1288[®] GP Spray

PRODUCT DATA SHEET



PERFORMANCE DATA

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

Test Method	Results
Adhesion to Steel (Hot Water Soak) (CSA-Z245.20)	28 days @ 75°C (176°F): Rating#1 Bristle Blaster 28 days @ 75°C (176°F): Rating#1 Flapper Wheel
Adhesion to Steel (Pull Off Strength) (ASTM D4541)	@ 25°C (77°F): 20.67 MPa (3000 psi) Bristle Blaster (ASTM D4541) 20.05 MPa (3200 psi) Flapper Wheel (ASTM D4541)
Cathodic Disbondment Resistance (CSA-Z245.20-10, Clause 12.8, System 1A)	28 days @ 65°C (149°F): @ - 1.5 Volts: Bristle Blaster - 10.0mmR Flapper Wheel - 10.2mmR Abrasive Blast - 5.06mmR
Flexibility - Bristle Blaster (CSA-Z245.20-06, Clause 12.11)	Pass 2° PPD @ 25°C (77°F) Pass 1° PPD @ 0°C (32°F) Pass 0.5° PPD @ -20°C (-4°F)
Flexibility - Flapper Wheel (CSA-Z245.20-06, Clause 12.11)	Pass 2° PPD @ 25°C (77°F) Pass 1° PPD @ 0°C (32°F) Pass 0.5° PPD @ -20°C (-4°F)
Impact Resistance - Bristle Blaster	Pass 5 Joules @ 25°C (77°F) Pass 3 Joules @ 0°C (32°F) Pass 2 Joules @ -20°C (-4°F)
Impact Resistance - Flapper Wheel	Pass 6 Joules @ 25°C (77°F) Pass 4 Joules @ 0°C (32°F) Pass 3 Joules @ -20°C (-4°F)
Shore D Hardness (ASTM D2240)	25°C (77°F): 85 Shore D

MIXING & THINNING

Mixing	Spray Grade: Agitation of the Part A component is recommended during the preheating process and during application to ensure a uniform heat throughout the base portion when applying material out of drums. Component Details for Color: Blue (0100): The Base is White (0800) and the Hardener is Blue (0100)
Thinning	DO NOT THIN.
Ratio	Spray & Brush Grade: 3:1 Base to Hardener, by Volume
Pot Life	Brush Grade: 50±5 minutes 200 gms mass @ 25°C (77°F)
Gel Time	Approximately 32 minutes @ 77°F (25°C)

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.

Brush Grade | Brush or Roller



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| Spray Grade | <ul style="list-style-type: none"> • Graco Hydra-Cat or alternative • Tip Size: 0.019-0.031 • Heated hose bundle consisting of 3/8" ID base and 14" ID hardener line with 1/4" solvent flush line • Glycol heat trace or equivalent capable of 80°C (176°F). • Insulated Whip Hoses Not Recommended for Glycol Heat Trace |
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APPLICATION CONDITIONS

Condition	Surface	Ambient
Minimum	10°F (-12°C)	-40°F (-40°C)
Maximum	212°F (100°C)	122°F (50°C)

Preheating of the substrate is required if the surface to be coated is below 10°C (50°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature before proceeding with the coating operation. The temperature of the coating components should be above 20°C (68°F) to enhance mixing. The ideal mixing and application temperature is between 20°C (68°F) and 35°C (95°F).

Brush Grade Material Temperature:

Base and Hardener: 25°C (77°F)

Spray Grade Material Temperature:

Base: 60°C (140°F)

Hardener: 40°C (104°F)

CURING SCHEDULE

Surface Temp.	Dry Hard (Spray Grade)	Dry Hard (Brush Grade)
50°F (10°C)	24 Hours	24 Hours
68°F (20°C)	11.5 Hours	11.5 Hours
86°F (30°C)	5.17 Hours	5.58 Hours
104°F (40°C)	105 Minutes	2.17 Hours
122°F (50°C)	50 Minutes	1 Hour
140°F (60°C)	28 Minutes	40 Minutes
158°F (70°C)	14 Minutes	20 Minutes
176°F (80°C)	7 Minutes	11 Minutes
194°F (90°C)	5 Minutes	5 Minutes

Substrate: 12 mm (0.5 in) Thick Steel Panels

Dry Film Thickness: 0.50 mm (20 mils) as per ASTM D1640.

Note: The information above is to serve as a guide only. The test results were compiled under laboratory-controlled conditions. Field results may vary due to variable conditions such as radiant heat loss and the cooling effect of wind.

Touch Dry: 3 hours @ 25°C (77°F)

CLEANUP & SAFETY

Cleanup | Carboline Thinner 1 or SP-100 Equipment Wash

Safety | Refer to SPC's Safety Data Sheet prior to use. Carefully read and follow all safety instructions on labels and packing. Handle and store material with care in accordance to the Safety Data Sheet. Follow and observe any applicable local or national laws and regulations.

SP-1288[®] GP Spray

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Shelf Life	A maximum of 24 months from the date of manufacture if the materials are in unopened containers.
Storage	Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 50°C (122°F). Keep in a tightly sealed container when not in use. DO NOT FREEZE.
Packaging - Brush Grade	1 Liter (0.26 Gallon) Kit Part A: 0.75 liters (0.2 gallons) Part B: 0.25 liters (0.06 gallons)
	2 Liter (0.53 gallons) Kit Part A: 1.5 liters (0.40 gallons) Part B: 0.5 liters (0.13 gallons)
Packaging - Spray Grade	80 Liter (21.1 Gallon) Kit Part A: 60 liters (15.9 gallons) Part B: 20 liters (5.3 gallons)
	800 Liter (211.3 Gallon) Kit Part A: 600 liters (158.5 gallons) Part B: 200 liters (52.8 gallons)

WARRANTY

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