

SELECTION & SPECIFICATION DATA

Generic Type	Inorganic silicate
Description	Armorlast I (2K) is a high build inorganic topcoat used to seal and protect inorganic zinc primers. The film exhibits exceptional toughness, high temperature resistance, and is available in a limited assortment of colors. Being inorganic, Armorlast I (2K) provides exceptional weatherability and long-term performance. When used as finish over a permanent zinc primer, the system becomes an ultra-long lasting corrosion resistant system.
Features	Outstanding weatherability Long life performance High temperature resistance Available in various colors Isocyanate free Meets Class B Slip Co-Efficient over Carbozinc 11 HS
Color	Grey (1709), White (1864) Other colors may be available upon request. Contact your Carboline Representative for availability.
Finish	Flat
Primer	Best when used over solvent-based inorganic zinc silicate primers like Carbozinc 11 Series. Suitable organic zinc primers such as Carbozinc 608 HB, Carbozinc 808, Carbozinc 858 Series, and Carbozinc 859 Series may be used for lower maximum dry temperature service and/or for repairing mechanical damage to the coating system that may result in bare metal being exposed. Refer to the specific organic zinc primer Product Data Sheet for the maximum dry temperature resistance.
Dry Film Thickness	75 - 125 microns (2.95 - 4.92 mils) per coat Not to exceed 175 microns (7 mils).
Solids Content	By Volume 57% +/- 2%
Theoretical Coverage Rate	22.4 m ² /l at 25 microns (914 ft ² /gal at 1.0 mils) 7.6 m ² /l at 74 microns (310 ft ² /gal at 3.0 mils) 4.6 m ² /l at 123 microns (186 ft ² /gal at 4.9 mils) Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 427°C (800°F)* Non-Continuous: 538°C (1000°F) *Dry temperature resistance listed above is only applicable when applied over suitable solvent based inorganic zinc primers.
Limitations	Do not use over water-based inorganic zinc-rich primers.

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. Refer to specific primer's Product Data Sheet for detailed requirements of the specified primer.
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Armorlast I (2K)

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Steel | Apply over properly applied inorganic zinc primers. Allow at least 2 hour dry time on inorganic zinc primers prior to topcoating.

MIXING & THINNING

Mixing | Power mix Part A to a uniform consistency and then add the Catalyst / Part B. Then power mix for an additional 2 to 3 minutes until thoroughly mixed.

Thinning | May be thinned up to 5% by volume with Carboline Thinner 33.

Pot Life | 6 hours at 20°C (68°F)
Avoid moisture contamination.

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) | This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from equipment manufacturers.

Conventional Spray | Conventional pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, and 0.043" to 0.070" fluid tip and appropriate air cap.

Airless Spray | Pump Ratio: 30:1 (min.)
Volume Output: 11.5 l/min min. - 2.5 gpm min.
Material Hose: 12.5mm min. - 1/2" I.D. min.
Tip Size: 0.43-0.53mm - 0.017-0.021"
Output Pressure: 135-170kg/cm² - 2100-2500 psi -

Brush | For touch up use only. Use medium bristle brush and avoid rebrushing. Two coats may be required to obtain desired thickness and appearance. For best results tie-in within 5 min.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	4°C (39°F)	4°C (39°F)	30%
Maximum	32°C (90°F)	93°C (199°F)	43°C (109°F)	95%

Industry standards are for substrate temperatures during application to be 3°C (5°F) above the dew point. This product requires moisture to complete its final cure. Use water mist if humidity is below minimums.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Maximum Recoat
16°C (61°F)	30 Minutes	4 Hours	90 Days
24°C (75°F)	15 Minutes	2 Hours	90 Days
32°C (90°F)	10 Minutes	1 Hour	90 Days

Armorlast I (2K) may be applied to Carbozinc 11 Series inorganic zinc silicate primers after two hours dry at 75°F, >30% relative humidity. These times are based on recommended coverage rates. Curing under low humidity conditions will extend times. Consult Carboline Technical Service with questions.

CLEANUP & SAFETY

Cleanup	Use Thinner 2 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 (PDS) and on the safety data sheet (SDS) for this product. Employ normal workmanlike safety precautions. Use adequate ventilation. 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 supplied air respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life	9 months at 24 °C (76 °F) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	15.35 litre kit (24.56kg) Part A is 15 litres (24kg) Part B (catalyst) is 350ml (560g)
Storage Temperature & Humidity	4-32 °C (40-90 °F) 0-90% Relative Humidity
Flash Point (Setaflash)	Armorlast I: 19°C (66 °F) Thinner 33: 24°C (75 °F) Thinner 2: -5°C (23 °F)
Storage	Store Indoors. KEEP DRY.

Armorlast I (2K)

PRODUCT DATA SHEET



WARRANTY

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