

SELECTION & SPECIFICATION DATA

General Paint Name | High-build, epoxy resin paint

Generic Type | Epoxy/ modified cycloaliphatic polyamine

Description | Epoxy intermediate coating dedicated to anti-corrosion coating systems with ultra-high weathering resistance. Applied as an intermediate coating for such fluorourethane topcoats as Fulon Ace FII and Fulon Ace FII HB. Recommended for the use for public buildings, food factories, leisure facilities, or anchillary facilities of railways. Also recommended for the use for such steel structures as chimneys, bridges, tank exterior, cranes, cyclone separators, conveyers, power utilities, etc.

Features |

- High build
- Excellent adhesion characteristics to fluorourethane topcoats
- "Low VOC paint" (Weight solids $\geq 70\%$)

Color | White (Beige white), Light Colors, and others

Finish | Semi-Gloss

Primer | Carbomastic 15 T, etc.

Solid(s) Content | By Volume 76% +/- 2%

Solids Content | By Weight 86% +/- 2%

Mixed Density | 1.51 +/- 0.03 g/ cm³

VOC Values | As Supplied : 211 g/ L

Application Method	Dry Film Thickness (microns/coat)	Theoretical Coverage Rate (g/m ²)	Practical Coverage Rate (g/m ²)*
Spray	60	119	200 ~ 220
Brush	60	119	180 ~ 200

*: Practical Coverage Rates are estimates based on average results. Individual results may vary based on several issues including the shape and location of the item being painted as well as environmental conditions like temperature, humidity and wind. The skill level of those applying the paint will also impact the final results. For details, consult Japan Carboline staff.

Wet/ Dry (As Supplied) | 1.32

Sag Resistance (Dry) | 200 microns

Dry Temp. Resistance | Continuous: 82°C (180°F)
Non-Continuous: 121°C (250°F)

Limitations |

- Not recommended for immersion in or exposure to solvents or chemicals like strong acids or alkali.
- Not recommended for immersion in water.
- Epoxies may lose gloss, discolor and chalk when exposed to sunlight.
- Discoloration is more pronounced with this product.

Topcoats | Fulon Ace FII, Fulon Ace FII HB, etc.

Fulon Ace M

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

General | Remove any oil or grease from surface to be coated with clean rags soaked in an adequate solvent.

MIXING & THINNING

Mixing	Power mix Part A and B separately, until uniform consistency, then combine and power mix until uniform consistency.
	In principle, the whole contents in the containers of Part A and B should be mixed together. When using partial kits out of necessity, agitate Part A and B separately, until uniform consistency, use a scale to weigh each part precisely, then combine and power mix until uniform consistency.
Thinning	Use of Fulon Ace M Thinner is recommended.
	Use of thinners other than those supplied or recommended by JAPAN CARBOLINE may adversely affect product performance.
Ratio	Part A : Part B = 73 : 27 (by weight)
Pot Life	5°C: 5 hours
	10°C: 4 hours
	20°C: 3 hours
	30°C: 1.5 hours

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.

Application Tool	Airless spray, Air spray, Brush
Airless Spray	• Pump Ratio: 30 : 1
	• Output Pressure: 15-20 MPa
	• Tip Size: 0.017-0.021"
	• Filter Size: 50 Mesh (if needed)
	• Thinning: up to 10 weight %
	• Appropriate Viscosity: 0.5-1.0 Pa·s (5-10 Poise)

APPLICATION CONDITIONS

Condition	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	0%
Maximum	50°C (122°F)	43°C (109°F)	85%

CURING SCHEDULE

Surface Temp.	Dry Hard	Maximum Recoat Time	Minimum Recoat Time
5°C (41°F)	72 Hours	14 Days	72 Hours
10°C (50°F)	36 Hours	10 Days	36 Hours
20°C (68°F)	18 Hours	7 Days	18 Hours
30°C (86°F)	9 Hours	4 Days	9 Hours

Proper measures, such as heating of substrates, should be taken to avoid premature failure of the coated film, when precipitation, condensation, and/or ambient temperature lower than 5°C, is expected until curing.

Curing schedule is based on 60 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. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating.

PACKAGING, HANDLING & STORAGE

Shelf Life | 12 months (when kept in original unopened containers)

Storage | Store indoors.

Net Weight	20 kg kit	10 kg kit
Part A	14.6 kg	7.3 kg
Part B	5.4 kg	2.7 kg

Flash Point (Setaflash)

Part A: 14°C
Part B: 4°C
Fulon Ace M Thinner: 27°C

UPDATE INFORMATION

Last Modified | December, 2023

Control Number | PDS010-019

WARRANTY

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