Carbocrylic 3375

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Waterborne Acrylic
Description	Versatile high performance finish with excellent corrosion resistance and exterior weathering properties.
Features	• Multi-purpose interior / exterior coating • Excellent colour and gloss retention • Single component • Outstanding corrosion protection • Low odour, low VOC
Color	Available in a range of colours
Finish	Semi-Gloss (35-70)
Primer	Acrylics, Alkyds, Epoxies and Organic Zincs.
Dry Film Thickness	50 to 75µm per coat Thicknesses greater than 125µm per coat is not recommended.
Solid(s) Content	By volume 40% ± 2%
Theoretical Coverage Rates	8m²/litre at 50µm Allow for loss in mixing and application
VOC Value(s)	As supplied: 33g/litre These are the nominal values and may vary by colour.
Dry Temp. Resistance	Continuous: 77°C (171°F) Non-Continuous: 95°C (203°F) Coating may discolour
Limitations	Apply and cure at temperatures of 10°C and above for 24 hours.

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.
Steel	Prime with specific Carboline primers as recommended by your Carboline Sales Representative.
Galvanized Steel	Clean with Carboclean 251 and rinse with potable water. Prime with specific Carboline primers as recommended by your StonCor Africa Sales Representative.
Previously Painted Surfaces	Lightly sand or abrade to roughen surface and degloss the surface. Existing paint must attain a minimum 3A rating in accordance with ASTM D-3359 (x-scribe adhesion test).

MIXING & THINNING

Mixing	Power mix until uniform in consistency. Avoid excessive air entrapment.
Thinning	May be thinned up to 10% with clean potable water.

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	Pre-rinse equipment with undiluted Carboclean 250 followed by clean potable water before spraying.
Conventional Spray	Pressure pot equipped with dual regulators, ½ “ I.D. minimum material hose, .086” 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:** 1800-2100 • **Filter Size:** 60 mesh * Teflon packings are recommended and available from the pump manufacturer. For ease of application, remove the pickup tube and immerse the lower unit directly into the material.
Brush & Roller (General)	Multiple coats may be required to achieve desired appearance, hiding and recommended dry film thickness. Avoid excessive re-brushing or re-rolling.
Brush	Use a synthetic bristle brush.
Roller	Use a short-nap synthetic roller cover with phenolic core. For rough surfaces, use a 3/8” woven nap synthetic roller.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	41°C (106°F)	54°C (129°F)	43°C (109°F)	80%

Do not apply when the surface temperature is less than 3°C above the dew point. Do not apply if temperatures are expected to drop below 10°C within 24 hours of application. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat
10°C (50°F)	3 Hours	3 Hours
24°C (75°F)	2 Hours	2 Hours
32°C (90°F)	1 Hour	1 Hour

These times are based on a 50µm dry film thickness. Higher film thicknesses, insufficient ventilation, or cooler temperatures will require longer cure times. The acrylic film forming process may require several weeks at 24°C with proper ventilation to develop adhesion and water resistance. High humidity, high film thickness, insufficient ventilation or cooler temperatures will lengthen the Dry To Handle and Dry To Topcoat times due to slower water evaporation rate. Waterborne Acrylics are sensitive to moisture during early cure and are susceptible to handling damage.

Curing Details	**Relative Humidity: 50%**

CLEANUP & SAFETY

Cleanup	Use clean potable water followed with suitable solvent to dry equipment. 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 MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life	36 Months at 24°C Shelf life (actual stated shelf life) when kept at recommended storage conditions and in original, unopened containers.
Shipping Weight (Approximate)	**5 Litre:** 7.0kg **20 Litre:** 28kg
Storage Temperature & Humidity	4°C to 43°C 0-95% Relative Humidity
Flash Point (Pensky Martens Closed Cup)	>93°C

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