

SELECTION & SPECIFICATION DATA

Generic Type	Modified acrylic terpolymer
Description	A single-component durable, high performance direct-to-metal acrylic coating for use where excellent weathering properties and chemical resistance are required. Use as a direct-to-metal acrylic coating for tank exteriors, piping, and structural steel, as well as other exterior and interior uses. May also be used as a finish coat over recommended primers.
Features	<ul style="list-style-type: none"> • Smooth, attractive, high build finish • Excellent weatherability, gloss and color retention • Low odor • Excellent corrosion protection • Meets most VOC (Volatile Organic Content) regulations • Excellent resistance to flash rusting • Outstanding application characteristics • Dry-fall* properties • Suitable for use in USDA inspected facilities <p>*Overspray can be wiped or washed from most surfaces depending on temperatures and humidity. The longer the overspray dwells on the surface and the hotter the surface, the more difficult to remove. A 20-foot (distance) test is recommended.</p>
Color	Available in a variety of colors.
Finish	High Gloss (85-100)
Primer	May be used over alkyds, inorganic zincs, epoxies and acrylics.
Dry Film Thickness	<p>51 - 76 microns (2 - 3 mils) per coat 76 - 127 microns (3 - 5 mils) per coat</p> <p>2-3 mils over recommended primers 3-5 mils direct to properly prepared substrates</p>
Solids Content	By Volume 40% +/- 2%
Theoretical Coverage Rate	<p>15.7 m²/l at 25 microns (642 ft²/gal at 1.0 mils) 7.9 m²/l at 50 microns (321 ft²/gal at 2.0 mils) 3.1 m²/l at 125 microns (128 ft²/gal at 5.0 mils) Allow for loss in mixing and application.</p>
VOC Values	<p>As Supplied : 0.96 lbs./gal (115 g/l)</p> <p>These are nominal values and may vary slightly with color. EPA Method 24: 1.8 lbs/gal Thinned: 6 oz/ gal w/ potable water: 0.92 lbs/gal (110 g/l)</p>
Dry Temp. Resistance	<p>Continuous: 113°C (235°F) Non-Continuous: 163°C (325°F)</p> <p>Slight discoloration and loss of gloss is observed above 200 F (93 C).</p>
Topcoats	Not normally topcoated (except with itself). Waterborne aryls may be used, or others are recommended by Technical Service.

Carbocrylic 3359 DTM

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

General	Surfaces <u>must</u> 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	SSPC-SP6 with a 1.0-2.0 mil (25-50 micron) surface profile for maximum protection. SSPC-SP2 or SP3 as minimum requirement. Prime with specific Carboline primers as recommended by your Carboline Sales Representative.
Galvanized Steel	SSPC-SP1. Prime with Sanitile® 120 or others as recommended by your Carboline Sales Representative.
Concrete or CMU	Concrete: Must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Laitance, form oils, curing agents and hardeners must be removed by suitable method before coating application. Prime with Sanitile 120. CMU: Mortar joints should be thoroughly cured for a minimum of 15 days at 75°F (24°C) and 50% relative humidity or equivalent. Prime with a latex block filler.
Drywall & Plaster	Joint compound and plaster should be fully cured prior to coating application. Prime with Sanitile 120.
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 D3359 "X-Scribe" adhesion test. Prime with Sanitile 120 or others as recommended by your Carboline Sales Representative.
Wood	Lightly sand with fine sandpaper and remove dust. Prime with Sanitile 120.

MIXING & THINNING

Mixing	Power mix until uniform in consistency. Avoid excessive air entrainment.
Thinning	Not normally required. May be thinned up to 6 oz/gal with clean, potable water where conditions dictate. 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)	Pre-rinse equipment with undiluted Carboline Surface Cleaner 3 followed by clean, potable water before spraying. The following spray equipment has been found suitable and is available from manufacturers.
Conventional Spray	Pressure pot equipped with dual regulators. 1/2" I.D. material hose, 0.086" fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (minimum)* GPM Output: 3.0 (minimum) Material Hose: 3/8" I.D. (minimum) Tip Size: 0.017" - 0.19" Output PSI: 1800 - 2200 Filter Size: 60 Mesh *PTFE packings are recommended and available from the pump manufacturer.

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Brush	Use a synthetic bristle brush. Multiple coats may be required to achieve desired dry film thickness and hiding characteristics.
Roller	For smooth surfaces, use a short woven nap synthetic roller. For rough surfaces, cinder block or very porous concrete, use a 3/8" woven nap synthetic roller. Multiple coats may be required to obtain desired appearance, hiding and recommended dry film thickness.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	38°C (100°F)	49°C (120°F)	43°C (110°F)	85%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point. Do not apply if temperatures are expected to drop below 50°F (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 with Itself
10°C (50°F)	10 Hours	3 Hours
24°C (75°F)	6 Hours	2 Hours
32°C (90°F)	4 Hours	1 Hour

These times are based on 50% relative humidity and 3-4 mil (75-100 microns) dry film thickness. The acrylic film forming process may require several weeks at 75°F (24°C) with proper ventilation to develop adhesion and water resistance. High humidity, high film thickness, insufficient ventilation or cooler temperatures will lengthen dry to handle/topcoat times due to slower water evaporation rate. Waterborne acrylics are sensitive to moisture during early cure and are susceptible to handling damage.

CLEANUP & SAFETY

Cleanup	Use clean, potable water followed with a 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 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 respirator.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. 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.

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PACKAGING, HANDLING & STORAGE

Shelf Life	36 months at 75°F (24°C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	1 Gallon - 11 Lbs. (5 kg) 5 Gallon - 51 Lbs. (23 kg) 50 Gallon - 600 Lbs. (239 kg)
Storage Temperature & Humidity	45° - 110°F (7° - 43°C) 0-95% Relative Humidity
Flash Point (Setaflash)	>200°F (>93°C)
Storage	Store Indoors. KEEP FROM FREEZING.

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.