Carbocrylic 3359 Flat

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Waterborne Acrylic
Description	Versatile high performance finish with excellent corrosion resistance and exterior weathering properties, as well as suitability for interior and mild environments.
Features	• Multi-purpose interior/exterior coating • Excellent color retention • Single component • Outstanding corrosion protection • Low odor, low VOC
Color	Refer to Carboline Color Guide. Minimum order quantities apply. Certain colors may require multiple coats to hide.
Finish	Flat (0-10)
Primer	Acrylics, Alkyds, Epoxies, Inorganic and Organic Zincs and others as recommended under Substrates & Surface Preparation. A mist coat may be required to minimize bubbling over Inorganic Zinc primers.
Dry Film Thickness	51 - 76 microns (2 - 3 mils) per coat Do not exceed 3.0 mils in a single coat
Solids Content	By Volume 36% +/- 2%
Theoretical Coverage Rate	14.2 m²/l at 25 microns (577 ft²/gal at 1.0 mils) 7.1 m²/l at 50 microns (289 ft²/gal at 2.0 mils) 4.7 m²/l at 75 microns (192 ft²/gal at 3.0 mils) Allow for loss in mixing and application.
VOC Value(s)	As supplied:0.5 lbs/gal (60 g/l) w/6 oz #102: 0.8 lbs/gal (96 g/l) w/12 oz #102: 1.1 lbs/gal (132 g/l) EPA Method 24: 1.1 lbs/gal (132 g/l) (Calculated minus water and exempt solvents) w/6 oz #102: 1.8 lbs/gal (216 g/l) w/12 oz #102: 2.3 lbs/gal (276 g/l) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 113°C (235°F) Non-Continuous: 163°C (325°F) Slight discoloration and loss of gloss is observed above 200°F (93°C).
Limitations	Apply and cure at temperatures of 50°F and above for 24 hours.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	16°C (60°F)	18°C (65°F)	18°C (65°F)	10%
Maximum	32°C (90°F)	29°C (85°F)	32°C (90°F)	80%

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
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 2.0-3.0 mil (50-75 micron) dry film thickness. Higher film thicknesses, insufficient ventilation, high humidity or cooler temperatures will require longer cure times.
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 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.

PACKAGING, HANDLING & STORAGE

Shipping Weight (Approximate)

1 Gallon 11 lbs(5 kg)
5 Gallons 51 lbs(23 kg)
50 Gallons 525 lbs(239 kg)

WARRANTY

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