

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy Polyamide
Description	An economical, high-gloss maintenance coating. Cures to a hard, tough film, with excellent sub-film corrosion resistance. Has excellent physical properties and good all-around chemical resistance. A high-gloss finish provides a clean pleasing surface.
Features	<ul style="list-style-type: none"> • Excellent corrosion resistance • Good all round chemical resistance • Good Flexibility • Very Good Abrasion Resistance
Color	Refer to Carboline Color Guide. Certain colors may require multiple coats for hiding.
Finish	High Gloss
Primer	Refer to Substrates & Surface Preparation May be applied over most Carboguard primers
Dry Film Thickness	51 - 76 microns (2 - 3 mils) per coat
Solids Content	By Volume 65% +/- 2%
Theoretical Coverage Rate	25.6 m ² /l at 25 microns (1043 ft ² /gal at 1.0 mils) 12.8 m ² /l at 50 microns (521 ft ² /gal at 2.0 mils) 8.5 m ² /l at 75 microns (348 ft ² /gal at 3.0 mils) Allow for loss in mixing and application.
VOC Value(s)	As supplied: 3.0 lbs/gal (362 g/l) This is a nominal value and may vary slightly with color.
Dry Temp. Resistance	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F)
Limitations	Epoxies lose gloss, discolor and eventually chalk in exposure to sunlight
Topcoats	Normally not required

SUBSTRATES & SURFACE PREPARATION

General	Remove any oil or grease from surface to be coated with clean rags soaked in Carboline Thinner #2
Steel	Apply over clean, dry, recommended primers
Concrete	Do not coat concrete treated with hardening solutions unless test patches indicate satisfactory adhesion. Do not apply coating unless concrete has cured at least 28 days at 70°F (21°C) and 50% RH or equivalent time. Apply to properly prepared concrete that was acid etched or swept sandblasted.

MIXING & THINNING

Mixing	Mix separately, then combine
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Carboguard E-20

PRODUCT DATA SHEET



MIXING & THINNING

Thinning	Thin up to 5% by volume with Carboline Thinner #15. For hot or windy conditions above 80°F (27°C), use Carboline Thinner #33.
Ratio	2:1 (A to B) By Volume
Pot Life	5 hours at 77°F (25°C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

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	Use adequate air volume for correct operation. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.
Conventional Spray	Use 3/8" minimum I.D. material hose. Hold gun 12-14 inches from the surface and at a right angle to the surface. Binks #18 or #62, fluid tip 6, air cap 63PB DeVibloss JGN-502, fluid tip E, air cap 704 JGA, approximate 0.070" ID
Airless Spray	Use 3/8" minimum I.D. material hose. Hold gun 12-14 inches from the surface and at a right angle to the surface. Pump Ratio: 30:1 (min) GPM Output: 3.0 (min) Material Hose: 3/8" I.D. (min) Tip Size: .017-.021" Output PSI: 2100-2300 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer. Use a 0.15" tip with 2000 psi
Brush & Roller (General)	For small areas or touch-up only. Use a medium natural bristle brush, with full strokes. Avoid rebrushing. Use short nap mohair roller with phenolic core.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	13°C (55°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	32°C (90°F)	43°C (109°F)	43°C (109°F)	85%

Do not apply when the surface temperature is less than 3°F (2°C) above dew point.
Special thinning and application techniques may be required above or below normal conditions.

CURING SCHEDULE

Surface Temp.	Final Cure	Between Coats
10°C (50°F)	12 Days	24 Hours
16°C (61°F)	6 Days	12 Hours
24°C (75°F)	2 Days	6 Hours
32°C (90°F)	2 Days	3 Hours

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. During high humidity conditions, it is recommended that the application be done while temperatures are increasing. Maximum recoat/topcoat times are 30 days for epoxies and 90 days for polyurethanes at 75°F (24°C). If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats.

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 and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
Ventilation	When used as a tank lining or 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.
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, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 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)	5.7 Liters - 9 Kg 28.5 Liters - 43 Kg
Storage Temperature & Humidity	Temperature: 40° -110 °F (4 °- 43°C) Relative Humidity: 0-100%
Flash Point (Setaflash)	Part A: 8°C (46°F) Part B: 16°C (60°F)
Storage	Store indoors

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PRODUCT DATA SHEET



WARRANTY

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