

SELECTION & SPECIFICATION DATA

Generic Type	Acrylic aliphatic polyurethane
Description	A glossy, tile like, attractive topcoat, produces a smooth, slick and hard film which is readily cleaned. It has a very good resistance to splash and spillage of acids, alkalies and most solvents. It exhibits excellent resistance to splash and spillage of salts and water. It is easily applied by airless or conventional spray.
Features	<ul style="list-style-type: none"> • Thin-film, single coat protection • Excellent gloss and color retention • Excellent weatherability • Excellent abrasion resistance • Excellent flexibility
Color	Refer to Carboline Color Guide
Finish	Gloss
Primer	Refer to Substrates & Surface Preparation
Dry Film Thickness	51 microns (2 mils) per coat
Solids Content	By Volume 48% +/- 2%
Theoretical Coverage Rate	18.9 m ² /l at 25 microns (770 ft ² /gal at 1.0 mils) 9.4 m ² /l at 50 microns (385 ft ² /gal at 2.0 mils) Allow for loss in mixing and application.
VOC Value(s)	As supplied: 3.9 lbs/gal (408 g/l) Thinned: 12 oz/gal w/#25: 2.26 lbs./gal. (454 g/l) 18 oz/gal w/#25: 2.26 lbs./gal. (477 g/l) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F) Discoloration and loss of gloss is observed above 200°F (93°C).
Topcoats	Carbothane Clear Coat when required

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. For all surfaces prime with specific Carboline primers defined in Market Guides or as recommended by your StonCor ME sales representative. Refer to the specific primer's Product Data Sheet for detailed requirements of the specified primer.
Steel	SSPC-SP6 with a 1.5-2.5 mils (37.5-62.5 microns) surface profile for maximum protection. SSPC-SP2 or SP3 as minimum requirement. Prime with specific Carboline primers as recommended by your StonCor ME sales representative.

Carbothane 134

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Galvanized Steel	Prime with specific Carboline primers as recommended by your StonCor ME sales representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.
Previously Painted Surfaces	Lightly sand or abrade to roughen and degloss the surface. Existing paint must attain a minimum 3B rating in accordance with AST D3359 "X-Scribe" adhesion test.

MIXING & THINNING

Thinning	Spray: Up to 18 oz/gal (18%) w/ Thinner # 25 Brush: Up to 12 oz/gal (20%) w/ Thinner # 82 Roller: Up to 12 oz/gal (20%) w/ Thinner # 215 Use of thinner other than those supplied or approved by Carboline may adversely affect product performance and void product warranty, whether express or implied.
Ratio	Mix 7:1 Ratio (A to B)
Pot Life	4 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating becomes too viscous to use. MOISTURE CONTAMINATION WILL SHORTEN POT LIFE AND CAUSE GELATION.

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.

General	This is a high solids coating and may require adjustments in spray techniques. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. Minimum material hose, .70" 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: .015-.017" Output PSI: 2100-2400 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Multiple coats may be required to obtain desired appearance, recommended dry film thinners and adequate hiding. Avoid excessive rebrushing or rerolling. For best results, tie-in within 10 minutes at 75°F (24°C).
Brush	Recommended for touch-up only. Use medium, natural bristle brush.
Roller	Use a short-nap mohair roller cover with phenolic core.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	5°C (41°F)	2°C (36°F)	0%
Maximum	43°C (109°F)	54°C (129°F)	49°C (120°F)	85%

Industry standards are substrate temperature to be above 5°F (3°C) the dew point.

Caution: This product is moisture sensitive in the liquid stage and until fully cured. Protect from high humidity, dew and direct moisture contact until fully cured. Application and/or curing in humidity above maximum, or exposure to moisture from rain or dew may result in a loss gloss and/or micro bubbling of the product.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Final Cure
2°C (36°F)	10 Hours	14 Days
10°C (50°F)	6 Hours	10 Days
24°C (75°F)	3 Hours	7 Days
32°C (90°F)	1.5 Hours	5 Days

*50% Relative Humidity

These times are based on a 2.0 mils (50 microns) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperature will require longer cure times and could result in solvent entrapment and premature failure.

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 in enclosed areas and product is thinned, 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. In confined areas, workmen must wear appropriate respiratory protection. 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	Part A: Min 36 months at 75°F (24°C) Part B: Min 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)	3.8-Liter Kit: 5 Kg 19-Liter Kit: 26 Kg

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PACKAGING, HANDLING & STORAGE

Storage Temperature & Humidity	Storage Temperature: 40° - 110°F (4° - 43°C) Relative Humidity: 0 - 80%
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Flash Point (Setaflash)	Part A: 63°F (17°C) Part B: 91°F (33°C)
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Storage	Store indoors
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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 to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. 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. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.