

SELECTION & SPECIFICATION DATA

Generic Type	Aliphatic Polyaspartic
Description	This fast-cure, high-build polyaspartic coating provides good corrosion protection plus long term weatherability in just one coat. It can be applied direct to metal (DTM), eliminating the need for primers. If primers are used, this product can be applied in place of the mid coat and topcoat creating a high performing, two coat system.
Features	<ul style="list-style-type: none"> • Fast cure • High build, up to 250 microns DFT per coat • Can be applied direct to metal (DTM) • Excellent corrosion protection - ISO 12944-6 C3 Medium, DTM • Excellent weathering - SSPC Ctg. Spec. No. 39 Level 3A (highest level) • 1 - 2 coats instead of 2 - 3 coats saves significant time, labour and money • Excellent durability - abrasion and impact resistant • Low VOC and low HAPS • Indefinite recoatability
Colour	White, Black, N53 Blue Grey, Golden Yellow, also available in most British Standard (BS5252), Australian Standards (AS2700), Resene colours and custom tints. Please refer to your local representative for further information.
Finish	Semi-Gloss (Initial gloss is a higher semi-gloss that levels out into a traditional semi-gloss finish after a few weeks)
Primer	Self-priming on properly prepared metal for many applications. For more severe service use with one of the following approved Carboline primers: Carbozinc 859 EZ2**, Carbozinc 858, Carbozinc 11, Carboguard 635 Series. Contact Carboline for further recommendations. ** Strict 24 hours minimum cure for Carbozinc 859 EZ2 prior to overcoating with Carboquick 200.
Film Build	150 - 250 microns per coat Can be applied at 100 - 125 microns DFT when applied over approved primer(s).
Solid(s) Content	By Volume 69% +/- 2%
Theoretical Coverage Rates	4.6 m ² /l at 150 microns dry 2.76 m ² /l at 250 microns dry Allow for loss in mixing and application.
VOC Values	As Supplied : 242 g/L EPA Method 24 These values may vary by colour.
Dry Temp. Resistance	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F) Discolouration may occur at temperatures near 93°C

Carboquick 201 SG

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants as described in SSPC-SP 1 (AS 1627.1).
Steel	Minimum surface preparation: Commercial Blast Clean per SSPC-SP 6 / AS 1627.4 Sa 2 with a 35-75 micron anchor profile. For optimum performance abrasive blast to SSPC-SP 10 / AS 1627.4 Sa 2½ with a 35-75 micron anchor pattern.
Galvanised Steel	Galvanising requires a roughened surface for optimum adhesion/performance of subsequent coatings. Clean per SSPC-SP 16 with a 25-50 micron anchor profile or prime as recommended by your Carboline Representative. Refer to the specific primer Product Data Sheet for substrate preparation requirements. Cleaned and abraded galvanising should be coated immediately after preparation.

MIXING & THINNING

Mixing	Power mix separately, then combine Part A with Part B and power mix thoroughly for at least three minutes to ensure the product is thoroughly mixed. DO NOT MIX PARTIAL KITS.
Thinning	Not normally required. May be reduced up to 5% v/v with the following: Thinner #76 or Thinner #2. For warmer temperatures use Thinner #214. Use of thinners other than those supplied or recommended by Carboline may adversely effect product performance and void product warranty, whether expressed or implied.
Ratio	2:1 (Part A to Part B) by volume
Pot Life	1.5 hours at 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. Remove any skin that may form on top of the mixed product in the container.

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	It may be necessary to make adjustments in spray techniques since wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from various manufacturers.
Conventional Spray	Pressure pot equipped with dual regulators, minimum 3/8" I.D. material hose, 1.8mm (0.070") I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.) Volume Output: minimum 9.5 L/min. Airless Hose: 9.5 mm I.D. min. (3/8" min.) Tip Size: 0.013 - 0.019" Output PSI: 2,200 - 2,800 psi (155 - 197 kg/cm ²) Filter Size: 60 mesh PTFE packings are recommended and available from the pump manufacturer.

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Brush & Roller (General)	Recommended for small areas or touch-up only. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive brushing and rolling. For best results, tie-in within 10 minutes at 24°C.
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APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	2°C (36°F)	10%
Maximum	32°C (90°F)	60°C (140°F)	43°C (109°F)	95%

Substrate temperatures must be 3°C above the dew point. Caution: this product reacts with moisture in order to complete the final cure. Relative humidity below 30% will slow cure time.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle or Recoat	Final Cure General
2°C (36°F)	2 Hours	8 Hours	7 Days
4°C (39°F)	1.5 Hours	6 Hours	7 Days
10°C (50°F)	50 Minutes	4 Hours	7 Days
24°C (75°F)	30 Minutes	1 Hour	4 Days
32°C (90°F)	20 Minutes	45 Minutes	2 Days

These times are based on 50% relative humidity (RH). RH lower than 50%, higher film thickness, insufficient ventilation and/or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity and/or condensation on the surface during curing can interfere with the cure, can cause micro-foaming and may result in loss of sheen and/or discoloration. Maximum recoat times are indefinite. As part of good painting practice it is recommended to first test for adhesion by wiping the surface with Thinner #76 or one of the other solvents listed for thinning. If the film shows a slight "tack" the surface is suitable for recoating without abrading to create profile.

CLEANUP & SAFETY

Cleanup	Use Thinner #2, #214, or Acetone. In case of spillage, 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	Contains iso-cyanate. When sprayed may be harmful by inhalation - do not breathe vapour or spray. Wear suitable clothing, gloves, eye and face protection, including suitable breathing protection such as an air supplied respirator or hood. 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 vapour 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 able to monitor levels, use suitable approved air-fed respirator.

Carboquick 201 SG

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Packaging	9 Litre Kit Part A: 6 Litres Part B: 3 Litres
	18 Litre Kit - MTO Part A: 12 Litres Part B: 6 Litres
Shelf Life	Part A: Minimum 24 months at 24°C Part B: Minimum 24 months at 24°C
	Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.
Storage Temperature & Humidity	4-43°C 0-90% Relative Humidity
Flash Point (Setaflash)	Part A: 10°C Part B: 27°C
Shipping Weight (Approximate)	9 Litre kit: 14.4 kg 18 Litre kit: 28.8 kg
Storage	Store indoors.
	This product is solvent based and not affected by excursions below these published storage temperatures, down to -12°C, for a duration of no more than 14 days. Always inspect the product prior to use to make sure it is smooth and homogeneous when properly mixed.

WARRANTY

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