

SELECTION & SPECIFICATION DATA

Generic Type	Proprietary cross-linking epoxy-acrylic gloss finish
Description	Fast cure iso-cyanate-free epoxy-acrylic gloss coating for industrial and marine and off-shore applications where use of polyurethane coatings is banned or undesirable.
Features	<ul style="list-style-type: none"> • Isocyanate free • Early through-curing • User friendly wet edge characteristics - cuts over-spray 'flashing' • Excellent colour and gloss** retention • Good chemical resistance • Good chalk resistance • Excellent durability • Excellent aged self re-coat
Colour	<p>NZ & AU: Tintable to an extensive range of RAL, British Standards and AS 2700 colours</p> <p>NZ Only: White, Black, and Golden Yellow</p> <p>AU Only: Silver Aluminium (satin finish), and Blast Grey (low sheen finish)</p>
Gloss	<p>Typical Gloss - 83+ Gloss Units*</p> <p>* Gloss level may be colour dependent (see notes to AU only colours above)</p>
Primer	Apply over the specified Carboline intermediate or primer coat Refer to Carboline Technical Service or relevant Coating Specification
Film Build	<p>40-60 microns dry per coat Optimum DFT: 50 microns</p> <p>Do NOT attempt to overbuild this product</p>
Solid(s) Content	44% by volume
Theoretical Coverage Rates	<p>11 m²/litre at 40 microns dry 8.8 m²/litre at 50 microns dry 7.3 m²/litre at 60 microns dry</p> <p>Optimum WFT/DFT: 113 microns wet to obtain 50 microns dry Allow for loss in mixing and application.</p>
VOC Value(s)	490 grams per litre (mixed) - EPA Method 24
Dry Temp. Resistance	<p>Continuous: 90°C (194°F) Non-Continuous: 121°C (250°F)</p> <p>Discolouration may be observed above 93°C</p>
Limitations	<ul style="list-style-type: none"> • Colour may change as temperature approaches 121°C, but the film will remain intact • As noted above under "Film Build"; this product should not be overbuilt as it will retard through-cure and may cause finish wrinkling.

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Chemical Resistance Tables

ASTM D1308 – 24 hour Spot Test Under Watch-Glass at 21°C

- 10% Ammonia (aqueous): No effect
- Ammonia – concentrated: No effect
- 10% Sodium Hydroxide: Slight fine blistering, slight discolouration
- 35% Sodium Hydroxide: Very slight discolouration, no blisters
- Tap Water: No effect
- 5% Sodium Chloride: No effect
- 10% Hydrochloric Acid: No effect
- 10% Acetic Acid: Severe blistering & wrinkling
- 10% Nitric Acid: Heavy blistering & discolouration
- 5% Sulphuric Acid: Slight fine blistering
- 10% Sulphuric Acid: Moderate fine blistering
- 10% Phosphoric Acid: Moderate fine blistering

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 primer as recommended by your Carboline sales representative. Refer to the specific primer's Product Data Sheet for detailed requirements of the specified primer.

Steel

Power tool clean or abrasive blast to the standard required for the specified primer, taking into account the required performance and the exposure conditions.

Galvanised Steel

Prime with specific Carboline primer as recommended by your Carboline 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 ASTM D3359 "X-Scribe" adhesion test.

PERFORMANCE DATA

Test Method	System	Results
Abrasion Resistance ASTM D4060		Very good
Adhesion ASTM D4541	1 ct Cg 690 / 1 ct Cg 2929	Excellent
Elongation ASTM D522 Method B	1 ct Cg 690 / 1 ct Cg 2929	Very good
Gloss		83+ Gloss Units
Gloss Retention QUV Exposure	Cg 2929 Gloss White	96% Gloss Retention after 3000 hours QUV-A
Humidity Resistance ASTM D2247	1 c Cg 690 / 1 ct Cg 2929	Very good

MIXING & THINNING

Mixing

Mix each component separately, then combine and mix to the correct 4:1 proportions.

Thinning

Thin up to 20% with Thinner #25 for spray, brush, or roller application.

Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

MIXING & THINNING

Ratio | 4:1 by volume (Part A : Part B)

Pot Life | 4 hours at 24°C (5 litre kit)

Induction Time | 10 minutes at 25°C; longer if colder

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.

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Conventional Spray	Pressure pot equipped with dual regulators, 9.5 mm (3/8") I.D. minimum material hose, 1.8 mm (.070") I.D. fluid tip and appropriate air cap. Hold gun 300-350 mm from the surface and at a right angle to the surface.
Airless Spray	<p>Pump Ratio: 30:1 Volume Output: 10 l/minute min. Material Hose: 9.5 mm min. (3/8") I.D. Tip Size: .013-.017" Output Press.: 2100-2400 psi Filter Size: 60 mesh *Teflon packings are recommended and available from pump manufacturer.</p>
Brush & Roller (General)	<p>Recommended for touch-ups only Multiple coats may be required to obtain desired appearance and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 24°C.</p> <ul style="list-style-type: none"> • Brush: Use a medium, natural bristle brush. • Roller: Use a short nap roller cover with a phenolic core

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	5°C (41°F)	2°C (36°F)	0%
Maximum	38°C (100°F)	45°C (113°F)	35°C (95°F)	90%
Optimum	20°C (68°F)	20°C (68°F)	20°C (68°F)	50%

Industry standards are for substrate temperatures to be above the dew point. Special thinning and application techniques may be required above or below normal conditions.

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CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat	Final Cure
10°C (50°F)	12 Hours	24 Hours	14 Days
16°C (61°F)	10 Hours	24 Hours	10 Days
24°C (75°F)	8 Hours	24 Hours	7 Days
32°C (90°F)	4 Hours	12 Hours	5 Days

These times are based on a 50 micron dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

***Maximum recoat times are indefinite.** Surface must be clean and dry. As part of good painting practice it is recommended to test for adhesion by wiping the surface with Thinner #25. If the film shows a slight "tack" the surface is suitable for recoating without extensive surface preparation such as abrading.

CLEANUP & SAFETY

Cleanup	Use Thinner #2, #12 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 vapour concentration from reaching the lower explosion limit for the solvents used.
Caution	This product contains flammable solvents. Keep away from sparks and open flames.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A and B: 24 months @ 24°C *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	4-38°C 0-95%
Flash Point (Setaflash)	Mix: 27°C
Storage	Store indoors and KEEP DRY
Packaging	1¼ litre & 5 litre kits

WARRANTY

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