

SELECTION & SPECIFICATION DATA

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| Generic Type | General Purpose Ambient Cured Epoxy |
| Description | A two-component ambient cured epoxy based on novel leading edge technology. This product can be used in applications where abrasive blasting is not possible or feasible. It exhibits excellent adhesion on metal substrates prepared as per SSPC SP-11 Surface Preparation Standard. |
| Features | <ul style="list-style-type: none"> • Excellent resistance to cathodic disbonding up to 65°C (149°F) with SSPC SP-11 Surface Preparation. • Excellent adhesion to SSPC SP-11 prepared steel surfaces, Fusion Bond Epoxy (FBE), and Fiber Reinforced Plastic (FRP). • 100% solids • Excellent impact resistance • Good Flexibility • High build single coat application up to 40 mil • Easily applied by spray, brush or roller |
| Typical Uses | <ul style="list-style-type: none"> • Pipelines • Girth welds • Appurtenances • Sewer lines • General piping • Onshore and offshore structures • Lining of pipes and tanks |
| Color | Blue (0100) |
| Dry Film Thickness | 508 - 1270 microns (20 - 50 mils) DFT Depends upon application. Consult with your SPC Representative. |
| Solids Content | By Volume 100% |
| Theoretical Coverage Rate | 39.4 m ² /l at 25 microns (1604 ft ² /gal at 1.0 mils) 2.0 m ² /l at 500 microns (80 ft ² /gal at 20.0 mils) 0.8 m ² /l at 1250 microns (32 ft ² /gal at 50.0 mils) Allow for loss in mixing and application. |
| VOC Values | As Supplied : 5 g/L |
| Specific Gravity | Base: 1.55 ± 0.03 Hardener: 0.96 ± 0.03 Mixed Material: 1.40 ± 0.03 |

SUBSTRATES & SURFACE PREPARATION

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| Steel | Cleanliness: SSPC SP-11 or abrasive blasting to NACE no.2/SSPC SP-10, SA 2.5 (ISO 8501-1) Profile: Minimum 25 – 38 microns (1.0 mils to 1.5 mils); Flapper Wheel or Bristle Blaster recommended. |
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PERFORMANCE DATA (TYPICAL VALUES)

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| Service Temperature | Up to 65°C (149°F) |
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SP-1288 GP

PRODUCT DATA SHEET



PERFORMANCE DATA (TYPICAL VALUES)

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| Adhesion to Steel (Pull Off Strength) | 25°C (77°F): 20.67 MPa (3000 psi) Bristle Blaster (ASTM D4541) 25°C (77°F): 20.05 MPa (3200 psi) Flapper Wheel (ASTM D4541) |
| Adhesion to Steel (Hot Water Soak) | 28 days @ 75°C (176°F): Rating#1 Bristle Blaster (CSA-Z245.20) 28 days @ 75°C (176°F): Rating#1 Flapper Wheel (CSA-Z245.20) |
| Cathodic Disbondment Resistance | 28 days @ 65°C (149°F): @ - 1.5 Volts: Bristle Blaster - 10.0mmR Flapper Wheel - 10.2mmR Abrasive Blast - 5.06mmR (CSA-Z245.20-10, Clause 12.8, System 1A) |
| Impact Resistance | Bristle Blaster: Pass 5 Joules @ 25°C (77°F) Pass 3 Joules @ 0°C (32°F) Pass 2 Joules @ -20°C (-4°F) Flapper Wheel: Pass 6 Joules @ 25°C (77°F) Pass 4 Joules @ 0°C (32°F) Pass 3 Joules @ -20°C (-4°F) |
| Flexibility | Bristle Blaster: Pass 2° PPD @ 25°C (77°F) Pass 1° PPD @ 0°C (32°F) Pass 0.5° PPD @ -20°C (-4°F) Flapper Wheel: Pass 2° PPD @ 25°C (77°F) Pass 1° PPD @ 0°C (32°F) Pass 0.5° PPD @ -20°C (-4°F) (CSA-Z245.20-06, Clause 12.11) |
| Hardness | 25°C (77°F): 85 Shore D (ASTM D2240) |

MIXING & THINNING

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| Brush Grade Pot Life | 50±5 minutes 200 gms mass @ 25°C (77°F) |
| Mixing | Spray Grade: Agitation of the Part A component is recommended during the preheating process and during application to ensure a uniform heat throughout the base portion when applying material out of drums. Component Details for Color: Blue (0100): The Base is White (0800) and the Hardener is Blue (0100) |
| Thinning | DO NOT THIN. |
| Ratio | Spray & Brush Grade: 3:1 Base to Hardener, by Volume |
| Gel Time | Approximately 32 minutes @ 77°F (25°C) |



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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| Spray Grade | <ul style="list-style-type: none">• Graco Hydra-Cat or alternative• Tip Size: 0.019-0.031• Heated hose bundle consisting of 3/8" ID base and 14" ID hardener line with 1/4" solvent flush line• Glycol heat trace or equivalent capable of 80°C (176°F).• Insulated Whip Hoses Not Recommended for Glycol Heat Trace |
| Brush Grade | Brush or Roller |

APPLICATION CONDITIONS

Ambient Temperature | -40°C to 50°C (-40°F to 122°F)

Substrate Temperature | 10°C (50°F) to 100°C (212°F).
Preheating of the substrate is required if the surface to be coated is below 10°C (50°F). The substrate temperature must be a minimum of 3°C (5°F) above the dew point temperature before proceeding with the coating operation.

Material Temperature | The temperature of the coating components should be above 20°C (68°F) to enhance mixing. The ideal mixing and application temperature is between 20°C (68°F) and 35°C (95°F).
Brush Grade Material Temperature:
Base and Hardener: 25°C (77°F)
Spray Grade Material Temperature:
Base: 60°C (140°F)
Hardener: 40°C (104°F)

CURING SCHEDULE

Touch Dry | 3 hours @ 25°C (77°F)

25°C (77°) @ 50% RH
Maximum 4 hours

Recoat Interval | The Recoat interval may vary significantly due to variable conditions including but not limited to humidity, surface temperature, and product application temperature.
Sweep blasting of the surface is required if the maximum re-coat interval is exceeded.
Small areas ≤316 sq cm (≤49 sq in) may be sanded using a medium grit (80-100) carborundum cloth.
All dust from the sanding or blast roughening must be removed from the surface prior to the application of the coating.
Contact your SPC representative for assistance in determining minimum and maximum recoat intervals specific to your application.

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CURING SCHEDULE

| Surface Temp. | Dry Hard (Spray Grade) | Dry Hard (Brush Grade) |
|---------------|------------------------|------------------------|
| 10°C (50°F) | 24 Hours | 24 Hours |
| 20°C (68°F) | 11.5 Hours | 11.5 Hours |
| 30°C (86°F) | 5.17 Hours | 5.58 Hours |
| 40°C (104°F) | 105 Minutes | 2.17 Hours |
| 50°C (122°F) | 50 Minutes | 1 Hour |
| 60°C (140°F) | 28 Minutes | 40 Minutes |
| 70°C (158°F) | 14 Minutes | 20 Minutes |
| 80°C (176°F) | 7 Minutes | 11 Minutes |
| 90°C (194°F) | 5 Minutes | 7 Minutes |

Substrate: 12 mm (0.5 in) Thick Steel Panels

Dry Film Thickness: 0.50 mm (20 mils) as per ASTM D1640.

Note: The information above is to serve as a guide only. The test results were compiled under laboratory-controlled conditions. Field results may vary due to variable conditions such as radiant heat loss and the cooling effect of wind.

CLEANUP & SAFETY

Cleanup | Carboline Thinner 1 or SP-100 Equipment Wash

Safety | Refer to SPC's Safety Data Sheet prior to use. Carefully read and follow all safety instructions on labels and packing. Handle and store material with care in accordance to the Safety Data Sheet. Follow and observe any applicable local or national laws and regulations.

PACKAGING, HANDLING & STORAGE

Shelf Life | A maximum of 24 months from the date of manufacture if the materials are in unopened containers.

Storage | Store in a cool, dry, well-ventilated area at temperatures between 5°C (41°F) and 50°C (122°F). Keep in a tightly sealed container when not in use. DO NOT FREEZE.

Packaging - Spray Grade

- 80 Liter (21.1 Gallon) Kit**
Part A: 60 liters (15.9 gallons)
Part B: 20 liters (5.3 gallons)
- 800 Liter (211.3 Gallon) Kit**
Part A: 600 liters (158.5 gallons)
Part B: 200 liters (52.8 gallons)

Packaging - Brush Grade

- 1 Liter (0.26 Gallon) Kit**
Part A: 0.75 liters (0.2 gallons)
Part B: 0.25 liters (0.06 gallons)
- 2 Liter (0.53 gallons) Kit**
Part A: 1.5 liters (0.40 gallons)
Part B: 0.5 liters (0.13 gallons)



WARRANTY

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