

Selection & Specification Data

Generic Type	Aliphatic Acrylic-Polyester Polyurethane
Description	High solids, high build, satin finish that provides a tough attractive finish while exhibiting outstanding performance properties. Demonstrates extremely good resistance to abrasion, corrosion and chemical exposure when applied over recommended Carboline primers and/or intermediate coats.
Features	<ul style="list-style-type: none"> • Compliant to AWWA D102-11, OCS-4 & OCS-6 • Outstanding performance properties in virtually all industrial markets • High build; suitable for many two-coat systems • High solids formulation allows for improved edge protection • Suitable for application direct to inorganic and organic zinc primers • Indefinite recoatability • VOC compliant to current AIM regulations
Color	Refer to Carboline Color Guide. Certain colors require multiple coats to hide.
Finish	Satin to Semi-Gloss
Primer	Inorganic zinc primers, organic zinc primer, or epoxy primers
Dry Film Thickness	3.0 - 5.0 mils (76 - 127 microns) per coat
	<small>Dry film thickness in excess of 7.0 mils (175 microns) per coat is not recommended.</small>
Solids Content	By Volume 72% +/- 2%
Theoretical Coverage Rate	1155 ft ² at 1.0 mils (28.3 m ² /l at 25 microns) 385 ft ² at 3.0 mils (9.4 m ² /l at 75 microns) 231 ft ² at 5.0 mils (5.7 m ² /l at 125 microns)
	<small>Allow for loss in mixing and application.</small>
VOC Values	Thinner 2 16 oz/gal 2.05 lbs/gal (246 g/l) Thinner 214 16oz/gal. 1.92 lbs./gal (230 g/l) Thinner 215 16 oz/gal 2.07 lbs/gal (249 g/l) Thinner 236 E 16 oz/gal.1.31 lbs./gal (157 g/l) Thinner 242 E 16 oz/gal: 1.31 lbs/gal (157 g/l) Thinner 25 16 oz/gal 2.07 lbs/gal (248 g/l) As Supplied 1.31 lbs/gal (157 g/l)
	<small>These are nominal values and may vary slightly with color. NOTE: Thinner 242 E contains VOC-exempt t-butyl acetate. Check local regulations regarding product usage.</small>
Dry Temp. Resistance	Continuous: 200 °F (93 °C) Non-Continuous: 250 °F (121 °C)
Limitations	*The alignment of aluminum flakes in aluminum-filled finishes is very dependent on application conditions and techniques. Care must be taken to keep conditions as constant as possible to reduce variations in final appearance. It is also advisable to work from a single batch of material since variations can occur from batch to batch. For more information consult Carboline Technical Service Department.

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 as recommended by your Carboline sales representative.
Steel	SSPC-SP6 with a 1.5-2.5 mil (37.5-62.5 microns) surface profile for maximum protection. SSPC-SP2 or SP3 as minimum requirement.
Previously Painted Surfaces	Lightly sand or abrade to roughen surface and degloss the surface. Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

Performance Data

Test Method	System	Results
ASTM B117 Salt Fog for 4,000 hours	1ct. Carbozinc 11/1ct. Carbothane 133 VOC	No effect to plane, very slight rust in scribe

Mixing & Thinning

Mixing	Power mix separately Part A, then combine with Part B and power mix. DO NOT MIX PARTIAL KITS.
Thinning	Spray: Up to 16 oz/gal (12%) w/ Thinner 2 Spray: Up to 16 oz/gal (12%) w/ Thinner 25 Spray: Up to 16 oz/gal (12%) w/ Thinner 236E Spray: Up to 16 oz/gal (12%) w/ Thinner 242E Brush: Up to 16 oz/gal (12%) w/ Thinner 215 Roller: Up to 16 oz/gal (12%) w/ Thinner 215 Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	5:1 Ratio (A to B)
Pot Life	6 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 GELLATION.

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 (General)	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.

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