

Selection & Specification Data

Generic Type	Single package vinyl acrylic copolymer				
Description	An economical topcoat with good chemical resistance, flexibility and weathering properties. Compatible with a wide range of generic primers and intermediates. Easy to apply and rapid drying. Available in safety and coding colours.				
Features	<ul style="list-style-type: none"> - Finishing coat for inorganic zincs, vinyls, epoxies and other recommended primers and intermediates. - Topcoat for Carboclad 938 Vinyl System. - Used for the upgrading of existing coating specifications for structural steel, piping and tank exteriors, etc. - May be used for topcoating of surfaces that operate at moderately hot temperatures up to 149°C. - Can be applied by conventional and airless spray. - May be applied over some single package generic types (a test patch is recommended to evaluate adhesion and compatibility over aged coating systems) - Excellent flexibility - Excellent weathering - Fair abrasion resistance - Not recommended for solvent exposure or immersion service. 				
Colour	Available in a variety of colours, including safety and coding colours. White and pastel shades may require multiple coats for adequate hiding. Consult your local StonCor Africa Sales or Customer Service Department for availability.				
Finish	Medium Gloss				
Substrates	Properly primed steel surfaces or others as recommended.				
Primer	May be applied over most generic type primers, including inorganic zincs, vinyls and epoxies. A mist coat is recommended over inorganic zincs to minimize bubbling and attain adequate film thickness.				
Topcoat	Normally none. Light or pastel colours may require two coats for adequate hiding over darker primers or intermediates.				
Dry Film Thickness	40 Microns				
Solids Content	By Volume 32% ± 2%				
Theoretical Coverage Rate	8.0m ² /litre at 40 microns				
	NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.				
Temp Resistance	<table> <tr> <td>Continuous</td> <td>149°C</td> </tr> <tr> <td>Non-continuous</td> <td>200°C</td> </tr> </table>	Continuous	149°C	Non-continuous	200°C
Continuous	149°C				
Non-continuous	200°C				

Substrates & Surface Preparation

General	Remove any oil and grease from surface to be coated.
Steel	Apply over clean, dry, recommended primers.

November 2016 replaces March 2012

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Carboclad® 938 Finish

Application Equipment

Spray Use sufficient air volume for correct operation of equipment.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later. Under certain conditions, when applied over inorganic zinc primers, a mist coat followed by a full coat may be required.

The following equipment has been found suitable, however equivalent equipment may be substituted:

Conventional Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface.

<u>Mfr & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks # 18 or # 62	66	63PB
DeVilbiss	FX (app .017" I.D)	704

Airless Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface.

<u>Mfr & Gun</u>	<u>Pump</u>
Graco 208-663	Bulldog 30:1
Binks Model 700	Mercury 5C

* Teflon packings are recommended and are available from pump manufacturer.

Revers-A-clean tip is recommended.

Use a .013 to .017" tip with 2000 psi (138 bar)

Brush Use natural bristle brush, applying with full strokes. Avoid rebrushing.

Roller For small areas or touch-up only. Use a short nap roller with phenolic core.

Mixing & Thinning

Mixing Power mix to a smooth consistency before thinning.

Thinning Thin up to 12% by volume with Thinner # 10.

NOTE: Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether expressed or implied.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16-32°C	18-32°C	16-32°C	10-85%
Minimum	4°C	4°C	4°C	0%
Maximum	38°C	43°C	43°C	95%

Do not apply when the surface temperature is less than 3°C above the dew point.

Special thinning and application techniques may be required above or below normal conditions.

Curing Schedule

Temperature	Recoat or to Handle
4°C	24 Hours
16°C	8 Hours
25°C	4 Hours
32°C	2 Hours

Cleanup & Safety

Cleanup Thinner # 2

Safety Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product. Employ normal workmanlike safety precautions.

Ventilation When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured.

Caution This product contains flammable solvents. Keep away from sparks and open flames.

Packaging, Handling & Storage

Shipping Weight (Approximate)		<u>5 Litre</u>
Carboclad 938 Finish		6.6kg
Thinner # 10		4.9kg

Flash Point (Pensky Martens Closed Cup)	Carboclad 938 Finish	20°C
	Thinner # 10	20°C

Storage Temperature & Humidity 4 to 43°C
0 to 100%
Store indoors

Shelf Life 24 Months minimum when stored at 25°C

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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