

Selection & Specification Data

Generic Type	Modified medium oil alkyd undercoat.
Description	Carbocoat GP-64 Undercoat is a moderately fast drying universal undercoat. It has excellent flexibility and good abrasion resistance. It can be applied over most alkyd primers, as an intermediate coat or as a flat finish.
Features	<ul style="list-style-type: none"> - Designed for use in any light industrial or architectural service where chemical attack is not a factor. - Specific recommendations include: atmospheric protection of plant equipment, drilling rigs, farm equipment, road building machinery, pipe racks, exposed structural steel, tank exteriors and steel buildings. - Good flexibility - Excellent weathering (chalks) - Good abrasion resistance - May be applied over most alkyd primers - Not recommended for immersion service, splash and spillage of acids, alkalies or solvents.
Colour	White and Light Grey
Finish	Flat
Topcoat	Normally topcoated with Carbocoat AD-51 Finish.
Dry Film Thickness	50 Microns
Solids Content	By Volume 48% ± 2%
HAPs Value	
Theoretical Coverage Rate	9.6m ² /litre at 50 microns
	NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
VOC Values	
Dry Temp Resistance	<p>Non-Immersion</p> <p>Continuous 85°C *</p> <p>Non-continuous 110°C *</p> <p>* Coating may discolour</p>

Substrates & Surface Preparation

General	Remove any oil and grease from the surface to be coated.
Steel	Apply over clean and dry recommended primers and/or tie coats.

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Carbocoat® GP-64 Undercoat

Application Equipment

Spray Use sufficient air volume for correct operation of equipment. Hold gun 200 to 250mm from the surface and at a right angle to the surface.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat edges first, making an extra pass later.

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

Conventional Use 10mm minimum I.D. material hose.

<u>Mfr & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
DeVilbiss P-MBC or JGA	FX	704
Binks # 18 or # 62	1.8mm	63PB

Airless Use a 10mm minimum I.D. material hose.

<u>Mfr & Gun</u>	<u>Pump *</u>
DeVilbiss JGB-507	QFA-519
Graco 205-591	President 30:1 or Bulldog 30:1
Binks Model 500	Mercury 5C

* Teflon packings are recommended and are available from the pump manufacturer. Use a .015" to .017" tip with 2000 psi (138 bar).

Brush or Roller Use medium bristle brush or short nap roller. Apply with full strokes. Avoid rebrushing.

Mixing & Thinning

Mixing Mix to a uniform consistency before thinning.

Thinning Thin up to 15% by volume with Thinner # 85.

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	10-32°C	13-32°C	13-38°C	30-80%
Minimum	5°C	5°C	5°C	0%
Maximum	49°C	60°C	49°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

Drying times at 50 microns D.F.T. and 50% relative humidity.

Surface Temp. & 50% Relative Humidity	Between Coats	Final Cure
10°C	24 Hours	96 Hours
16°C	18 Hours	72 Hours
25°C	12 Hours	48 Hours
32°C	8 Hours	36 Hours

Cleanup & Safety

Cleanup Use 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)	Carbocoat GP-64	5 Litre
	Thinner # 85	6kg
		4.5kg

Flash Point (Pensky Martens Closed Cup)	Carbocoat GP-64	25°C
	Thinner # 85	35°C

Storage Temperature & Humidity	2 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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