

Selection & Specification Data

Generic Type	Cycloaliphatic Amine Epoxy						
Description	Polyethylene-enhanced abrasion resistant primer / finish with superior resistance to algae and other filamentitious growth. Used for process water and wastewater immersion, lining railcar hopper interiors, coal bunkers, hydro bins and dust collectors.						
Features	<ul style="list-style-type: none"> - Exceptional abrasion resistance - Suitable for application to tight rust and ISO 8501 St2 and St3 cleaned substrates - Excellent immersion performance - Forms a slick, non-stick surface - Free of anti-foulants and toxins - VOC compliant to current AIM regulations 						
Colour	Off White, Pipe Blue, Grey						
Finish	Gloss						
Primer	Self-priming. May be applied over inorganic zinc primers and other tightly adhering coatings. A mist coat may be required to minimize bubbling over inorganic zinc primers. Do not apply over latex coatings.						
Dry Film Thickness	125 to 175µm per coat Do not exceed 250µm in a single coat.						
Solids Content	By volume 75% ± 2%						
Theoretical Coverage Rate	6m ² /litre at 125µm Allow for loss in mixing and application						
VOC Values	<table border="0"> <tr> <td>As supplied</td> <td>214 g/l</td> </tr> <tr> <td>Thinned 6% with Thinner # 2</td> <td>250 g/l</td> </tr> <tr> <td>Thinned 13% with Thinner # 33</td> <td>285 g/l</td> </tr> </table> <p>These are nominal values and may vary slightly with colour.</p>	As supplied	214 g/l	Thinned 6% with Thinner # 2	250 g/l	Thinned 13% with Thinner # 33	285 g/l
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Dry Temp Resistance	<table border="0"> <tr> <td>Continuous</td> <td>93°C</td> </tr> <tr> <td>Non-continuous</td> <td>121°C</td> </tr> </table> <p>Slight discolouration and loss of gloss is observed above 93°C</p>	Continuous	93°C	Non-continuous	121°C		
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Non-continuous	121°C						
Water Temp Resistance	Immersion temperature resistance depends upon exposure. Consult Carboline Technical Service for specific information. It is recommended that metal tanks operating above 60°C be insulated.						
Limitations	Epoxies lose gloss, discolour and eventually chalk in sunlight exposure.						

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.	
Steel	Immersion:	ISO 8501 Sa2½
	Non-immersion:	ISO 8501 Sa2
	Surface Profile:	40-80 Microns
	ISO 8501 St 2 or St3 are suitable cleaning methods for mild environments.	
Concrete	Immersion and Non-immersion: Concrete must be cured 28 days at 25°C and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.	
Previously Painted Surfaces	Lightly sand or abrade to roughen surface 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	Results
Taber Adhesion (ASTM D4060)	54 mg loss per 1000 cycles C17 wheel, 1000 gm load

Mixing & Thinning

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
Thinning	Spray: Up to 6% with Thinner # 2 May thin using Thinner # 33 up to 13% for brush and roller applications and hot / windy conditions. Use of thinners other than those supplied or recommended by StonCor Africa may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	1:1 Ratio (A to B)
Pot Life	2 Hours at 25°C. Pot life ends when coating loses body and begins to sag. Pot life times will be less at higher temperatures.

May 2018 replaces March 2016

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Application Equipment

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 and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray Pressure pot equipped with dual regulators, 10mm I.D. minimum material hose, 1.8mm nozzle fluid tip and appropriate air cap.

Airless Spray

Pump Ratio:	45:1 (min)
GPM Output:	12lt per m
Material Hose:	10mm I.D. (min)
Tip Size:	.017-.021"
Output PSI	2100-2300
Filter Size:	60 Mesh

Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) Not recommended for tank lining applications except when striping welds. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 24°C.

Brush Use a medium bristle brush.

Roller Use a short-nap synthetic roller cover with phenolic core.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	16-29°C	16-29°C	16-32°C	0-80%
Minimum	10°C	10°C	10°C	0%
Maximum	32°C	52°C	43°C	90%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

Curing Schedule

Surface Temp & 50% Relative	Dry to Recoat	Dry to Topcoat with other Finishes	Final cure for Immersion Service	Maximum Recoat Time
10°C	12 Hours	24 Hours	N/R *	
16°C	8 Hours	16 Hours	10 Days	
24°C	4 Hours	8 Hours	5 Days	30 Days
32°C	2 Hours	4 Hours	3 Days	

	Dry to Touch	Dry to Handle
24°C	2.5 Hours	6.5 Hours

These times are based on a 125µm dry film thickness. Higher film thicknesses, insufficient ventilation, or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration, and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. During high humidity conditions, it is recommended that the application be done while temperatures are increasing. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting prior to the application of additional coats. For **force curing**, contact StonCor Africa Technical Service for specific requirements. * **Note:** Final cure temperatures below 16°C are not recommended for tank linings.

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Cleanup & Safety

Cleanup Use Thinner # 2. 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 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 vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

Caution This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Packaging, Handling & Storage

Shelf Life Part A: Min. 36 months at 25°C.
Part B: Min 24 Months at 25°C.

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

Shipping Weight (Approximate)

	10 litre kit
Part A	7.45kg
Part B	8.6kg

Storage Temperature & Humidity 4°C to 43°C
0-100% Relative Humidity

Flash Point (Setflash) Part A:
Part B:

Storage Store indoors.



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