

## Selection & Specification Data

<b>Generic Type</b>	Single pack silicone acrylic										
<b>Description</b>	A protective coating for medium to high temperature service where colour is required. The coating will withstand thermal shock from 204°C to 0°C and temperature surges to 260°C. Exhibits excellent weathering properties, thereby making it suitable for use as a topcoat in coastal and harsh industrial environments. Heat cure above 150°C is recommended and will impart added strength and integrity to the coating.										
<b>Features</b>	<ul style="list-style-type: none"> <li>- Recommended for the protection of equipment (stacks, cat ladders, boilers, heat exchangers, etc.) operating from 93°C to 204°C. The use of Carbozinc 11 as a primer coat prevents rusting during shutdown and/or when the coated units are exposed to moisture at temperatures less than 93°C.</li> <li>- Good flexibility</li> <li>- Excellent weathering</li> <li>- Good abrasion resistance</li> <li>- Not recommended for immersion service</li> </ul>										
<b>Colour</b>	<p>The following colours are stable in continuous service at the indicated temperatures. Prolonged service above these temperatures will result in yellowing at first, followed by a significant colour change.</p> <table border="0"> <tr> <td>White</td> <td>177°C</td> </tr> <tr> <td>Grey</td> <td>204°C</td> </tr> <tr> <td>Aluminium</td> <td>260°C</td> </tr> <tr> <td>Black</td> <td>232°C</td> </tr> <tr> <td>Orange</td> <td>204°C</td> </tr> </table> <p>All colours are made to order. White and Pastel shades may require multiple coats for adequate hiding. Consult your local StonCor Africa Sales or Customer Service Department for availability.</p> <p>Other colours may be tested for temperature stability before order can be released. Check with Technical Service Department.</p>	White	177°C	Grey	204°C	Aluminium	260°C	Black	232°C	Orange	204°C
White	177°C										
Grey	204°C										
Aluminium	260°C										
Black	232°C										
Orange	204°C										
<b>Finish</b>	High gloss. May dull at upper temperature ranges.										
<b>Substrates</b>	Can be applied over properly prepared steel and cast iron. Carbozinc 11 is normally used as a primer for ferrous substrates. May be applied over inorganic zincs or others as recommended. A mist coat may be required when applied over inorganic zinc.										
<b>Topcoat</b>	None										
<b>Dry Film Thickness</b>	40 to 50 microns										
	Excessive film thickness may result in blistering when applied over an inorganic zinc primer. Two coats may be required for light coloured Thermaline 1248 to hide dark primers.										
<b>Solids Content</b>	40% ± 2%										
<b>Theoretical Coverage Rate</b>	10m <sup>2</sup> /litre at 40 microns										
	<b>NOTE:</b> Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.										
<b>VOC Content</b>	<table border="0"> <tr> <td>As supplied</td> <td>485 g/l</td> </tr> <tr> <td>Thinner # 25 at 25%</td> <td>567 g/l</td> </tr> </table>	As supplied	485 g/l	Thinner # 25 at 25%	567 g/l						
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<b>Temp Resistance</b>	<table border="0"> <tr> <td>Continuous</td> <td>232°C</td> </tr> <tr> <td>Non-continuous</td> <td>260°C</td> </tr> </table>	Continuous	232°C	Non-continuous	260°C						
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## Substrates & Surface Preparation

<b>General</b>	Remove any oil or grease from surface to be coated.
<b>Steel</b>	Apply over clean, dry, recommended primer or tie coat.

February 2017 replaces March 2012

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## Application Equipment

- Spray** Use adequate air volume for correct operation.
- Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.
- The following equipment has been found suitable, however, equivalent equipment may be substituted.
- Conventional Spray** Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface.
- |                        |                  |                |
|------------------------|------------------|----------------|
| <b>Mfr &amp; Gun</b>   | <b>Fluid Tip</b> | <b>Air Cap</b> |
| Binks # 18 or # 62     | 63B              | 63PB           |
| DeVilbiss P-MBC or JGA | FX               | 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.
- |                      |                                |
|----------------------|--------------------------------|
| <b>Mfr &amp; Gun</b> | <b>Pump*</b>                   |
| DeVilbiss JGN-507    | QFA-514                        |
| Graco 205-591        | President 30:1 or Bulldog 30:1 |
| Binks Model 700      | B8-36 37:1                     |
- \* Use a .015 to .019" tip with 2000 psi (138 bar)
- Brush** Small areas and touch-up only. Use a natural bristle brush and avoid rebrushing.

## Mixing & Thinning

- Mixing** Mix to a uniform consistency before thinning.
- Thinning** Thin up to 25% by volume with Thinner # 25

**NOTE:** The 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	18-29°C	18-29°C	10-29°C	35-80%
Minimum	5°C	5°C	5°C	0%
Maximum	35°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

Will be touch-dry in 1 hour at 25°C

## 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. 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 ensure all personnel are below guidelines. If not able to monitor levels, a MSHA/NIOSH approved supplied air respirator may be required.
- 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, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## Packaging, Handling & Storage

- |  |                                       |                |
|--|---------------------------------------|----------------|
| <b>Shipping Weight (Approximate)</b>           | Thermaline 1248                       | <b>5 Litre</b> |
|  | Thinner # 25                          | 4.9kg          |
| <b>Flash Point (Pensky-Martens Closed Cup)</b> | Thermaline 1248                       | 21°C           |
|  | Thinner # 25                          | 23°C           |
| <b>Storage Temperature &amp; Humidity</b>      | 4 to 43°C                             |                |
|  | 0 to 100%                             |                |
|  | Store indoors                         |                |
| <b>Shelf Life</b>                              | 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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