

Selection & Specification Data

Generic Type	Proprietary cross-linking epoxy-acrylic gloss finish
Description	Fast cure iso-cyanate-free epoxy-acrylic gloss coating for industrial and marine and off-shore applications where use of polyurethane coatings is banned or undesirable.
Features	<ul style="list-style-type: none"> • Isocyanate free • Early through-curing • User friendly wet edge characteristics - cuts over-spray 'flashing' • Excellent colour and gloss** retention • Lead and chrome-free colour range • Excellent gloss retention • Good chemical resistance • Good chalk resistance • Excellent durability • Excellent aged self re-coat
Gloss	Typical Gloss - 83+ Gloss Units – Colour dependant
Colour	White, Black, Golden Yellow LF & most BS and AS shades
Primers	Apply over specified Carboline [®] intermediate or primer (refer to Carboline Technical Service)
Dry Film Thickness	40 – 60 microns – 50 microns optimum Do NOT attempt to overbuild this product
Solids Content	44% by volume
Theoretical Coverage Rate	9 square metres per litre at 50 µm DFT 111 µm wet to obtain 50 µm dry. Do NOT attempt to overbuild this product
Mix Ratio	4 : 1 by volume (Part A : Part B)
VOC Values	490 grams per mixed litre (EPA 24)
Dry Temp. Resistance	121°C
Limitations	Colour may change as temperature approaches 121°C, but the film will remain intact

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 primer as recommended by your Carboline sales representative. Refer to the specific primer's Product Data Sheet for detailed requirements of the specified primer.
Steel	Power tool clean or abrasive blast to the standard required for the specified primer, taking into account the required performance and the exposure conditions.
Galvanized Steel	Prime with specific Carboline primer as recommended by your Carboline Sales Representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.
Previously Painted Surfaces	Lightly sand or abrade to roughen and de-gloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scratch" adhesion test.

Performance Data

Adhesion (ASTM D4541)	Excellent
Humidity Resistance (ASTM D2247)	Very Good
Abrasion Resistance (ASTM D4060)	Very Good
Elongation (ASTM D522 Method B)	Very Good
Gloss	83+ Gloss Units
Gloss Retention**	96% Gloss Retention after 3000 hours QUV-A exposure (white finish)

Chemical Resistance ASTM D1308 – 24 hour Spot Test Under Watch-Glass at 21°C

Reagent	Result
10% Ammonia (aqueous)	No effect
Ammonia – concentrated	No effect
10% Sodium Hydroxide	Slight fine blistering, slight discolouration
35% Sodium Hydroxide	Very slight discolouration, no blisters
Tap Water	No effect
5% Sodium Chloride	No effect
10% Hydrochloric Acid	No effect
10% Acetic Acid	Severe blistering & wrinkling
10% Nitric Acid	Heavy blistering & discolouration
5% Sulphuric Acid	Slight fine blistering
10% Sulphuric Acid	Moderate fine blistering
10% Phosphoric Acid	Moderate fine blistering

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Carboguard® 2929

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. **General Guidelines:**

Spray Application (General) This is a medium solids gloss finish 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 DeVilbiss and Graco.

Conventional Spray Pressure pot equipped with dual regulators, 9mm (3/8") I.D. minimum material hose, 1.8mm (.070") I.D. fluid tip and appropriate air cap.

Airless Spray Pump Ratio: 30:1 (min.)*
Output: 10 lt/min (min.)
Material Hose: 9mm (3/8") I.D. (min.)
Tip Size: .013-.017"
Output PSI: 2100-2400
Filter Size: 60 mesh
*Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) Multiple coats may be required to obtain desired appearance and adequate hiding. Avoid excessive rebrushing or re-rolling. For best results, tie-in within 10 minutes at 24°C.

Brush Recommended for touch-up only. Use a medium, natural bristle brush.

Roller Use a short nap roller cover with a phenolic core

Mixing & Thinning

Mixing Power mix Part A separately, then combine and power mix. DO NOT MIX PARTIAL KITS.

Ratio 4:1 by volume (Part A : Part B)

Thinning Spray: Up to 20% with #25
Brush: Up to 20% with #25
Roller: Up to 20% with #25
Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Pot Life 8 Hours at 24°C and less at higher temperatures. Pot life ends when coating becomes too viscous to use.

Cleanup & Safety

Cleanup Use Thinner #2 or Acetone. 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, OSH approved supplied air respirator.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16°-29°C	18°-29°C	18°-29°C	40-60%
Minimum	10°C	5°C	2°C	10%
Maximum	38°C	45°C	35°C	90%

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Handle	Dry to Recoat*	Final Cure
10°C	12 hours	24 hours	14 days
16°C	10 hours	24 hours	10 days
24°C	8 hours	24 hours	7 days
32°C	4 hours	12 hours	5 days

These times are based on a 50 micron dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

*Maximum recoat times are indefinite. Surface must be clean and dry. As part of good painting practice it is recommended to test for adhesion by wiping the surface with Thinner 25. If the film shows a slight "tack" the surface is suitable for recoating without extensive surface preparation such as abrading.

Packaging, Handling & Storage

Pack Sizes	Part A	Part B
5 litre kit	4 litre	1 litre
1.25 litre kit	1 litre	0.25 litre

Flash Point (Setaflash) 27°C – mixed product

Storage Temperature & Humidity Store under cover. KEEP DRY
4°-43°C
0-80% Relative Humidity

Shelf Life Part A: Min. 26 months at 24°C
Part B: Min. 24 months at 24°C

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

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