

Selection & Specification Data

Generic Type	Amine adduct cured, modified epoxy-phenolic	
Description	A high performance, immersion grade coating system which has excellent resistance to wet/dry cycling conditions at elevated temperatures.	
Features	<ul style="list-style-type: none"> • Temperature resistance to 204°C (400°F) • Very good flexibility • Excellent overall chemical resistance • Very good abrasion resistance • Easily applied by spray • Acceptable for use over stainless steels • Meets stringent VOC (volatile organic content) regulations 	
Gloss	Flat	
Colour	Primer: Red (0500) only Finish: Gray (6797)	
Dry Film Thickness	Thermaline 400 Primer:	125 microns
	Thermaline 400 Finish:	<u>125</u> microns
Solids Content	Primer:	65% ± 2% by volume
	Finish:	63% ± 2% by volume
Theoretical Coverage Rate	<u>Primer:</u> 26 m ² /l at 25 microns, 5.2 m ² /l at 125 microns <u>Finish:</u> 25 m ² /l at 25 microns, 5 m ² /l at 125 microns Mixing and application losses will vary and must be taken into consideration when estimating job requirements.	
Mix Ratio	4:1 by volume (Part A : Part B)	
VOC Values	As supplied: Primer: 300 g/l Finish: 312 g/l	
Dry Temp. Resistance	Continuous:	204°C
	Non-Continuous:	232°C

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated in accordance with SSPC-SP1.
Steel	Abrasive blast to a Near White Metal Finish in accordance with AS 1627.4 Class 2½ (SSPC-SP10) to obtain a 35-75 micron blast profile. Weld slag must be removed and welds ground to a rounded contour. After abrasive blasting, all dust, foreign particles and spent abrasives must be removed by blowing down with clean, dry, oil-free air, brushing and vacuum cleaning. Striping of properly prepared welds with Thermaline 400 Primer by brush or spray is recommended.

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)	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, 1.4-1.8mm (.055-.070") I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio:30:1 (min.)* Output:10 litre/minute (min.) Material Hose:9mm (3/8") I.D. (min.) Tip Size:.015-.019" Output PSI: 2100-2300 Filter Size:60 mesh *Teflon packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	For striping of welds and touch-up of small areas only. Use a natural bristle brush applying with full strokes. Avoid rebrushing. If rolled, use a short nap mohair roller with phenolic core. Avoid rerolling.

Mixing & Thinning

Mixing	Power mix separately, then combine and power mix in the following proportions: 400 Primer or Finish Pt. A: <u>5 litre Kit</u> 400 Part B: 4 litres 400 Part B: 1 litre
Ratio	4:1 by volume (Part A : Part B)
Thinning	May be thinned up to 25% with Thinner #2. Refer to Specification Data for VOC information. Use of thinners other than those supplied or approved by Carboline may adversely affect product performance and will void product warranty whether express or implied.
Pot Life	4 Hours at 24°C and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

Cleanup & Safety

Cleanup	Use Thinner #2
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 OSH approved supplied air 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 local Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	18°-29°C	18°-29°C	18°-29°C	30-60%
Minimum	13°C	10°C	10°C	0%
Maximum	32°C	43°C	38°C	85%

Curing Schedule

Surface Temp. & 50% Relative Humidity	Between Coats	Final Cure
10°C	4 days	N/R
16°C	2 days	15 days
24°C	24 hours	7 days
32°C	12 hours	2 days

These times are based on the recommended dry film thicknesses. Excessive film thickness or inadequate ventilating conditions after application require longer dry times and will cause premature failure in extreme cases. Excessive humidity or condensation on the surface during curing may result in surface haze or blush; any haze or blush should be removed by washing with water before recoating.

Packaging, Handling & Storage

Pack Sizes	<u>5 litre Kit</u> Part A: 4 litres Part B: 1 litre
Flash Point (Setaflash)	Thermaline 400 PrimerPart A: 8°C Thermaline 400 Finish Part A: 8°C Thermaline 400 Part B: 29°C
Storage Temperature & Humidity	Store under cover. KEEP DRY. 4°-43°C 0-90% Relative Humidity
Shelf Life	All components: 24 months at 24°C
*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.	

Manufactured / distributed by:-
 Altex Coatings Ltd, 91-111 Oropi Road,
 Tauranga 3112
 New Zealand
 Phone: +64 7 5411221
 Resene Paints Australia Ltd.
 T/A Altex Coatings
 7 Production Avenue
 Queensland 4214
 Australia
 Phone: +61 7 55949522



350 Hanley Industrial Court, St. Louis, MO 63144-1599
 314/644-1000 314/644-4617 (fax) www.carboline.com

