

## Selection & Specification Data

<b>Generic Type</b>	Amine Cured Novolac Epoxy
<b>Description</b>	Highly cross-linked, glass flake-filled polymer that offers exceptional barrier protection and resistance to wet/dry cycling at elevated temperatures. Suitable for insulated and non-insulated pipes, stacks and equipment operating up to 232°C (450°F). This coating provides excellent resistance to corrosion, abrasion and permeation, and its novolac-modification resists severe chemical attack.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Temperature resistance up to 232°C</li> <li>• High-build single-coat capabilities</li> <li>• Excellent resistance to thermal shock</li> <li>• Superior abrasion and chemical resistance through internal reinforcement</li> <li>• Ambient-temperature cure</li> <li>• Low VOC</li> </ul>
<b>Gloss</b>	Eggshell
<b>Colour</b>	Gray (5742)
<b>Primers</b>	Normally self-priming. May be applied over epoxies and phenolics.
<b>Topcoats</b>	Epoxies, Polyurethanes
<b>Dry Film Thickness</b>	200-250 microns. Do not exceed 375 microns per coat.
<b>Solids Content</b>	By Volume: 70% ± 2%
<b>Theoretical Coverage Rate</b>	28.0 m <sup>2</sup> /l at 25 microns 3.5 m <sup>2</sup> /l at 200 microns Allow for loss in mixing and application
<b>Mix Ratio</b>	4:1 by volume (Part A : Part B)
<b>VOC Values</b>	As supplied: 250 g/l Thinned 10% with #213: 308 g/l Thinned 10% with #2: 305 g/l These are nominal values.
<b>Dry Temp. Resistance</b>	Continuous: 218°C Non-Continuous: 232°C Discoloration and loss of gloss may be observed above 93°C.
<b>Limitations</b>	Epoxies lose gloss, discolour and eventually chalk in sunlight exposure.

## Substrates & Surface Preparation

<b>General</b>	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.
<b>Steel</b>	<u>Non-Insulated:</u> AS 1627.4 Class 2 (SSPC-SP6) <u>Insulated:</u> AS 1627.4 Class 2½ (SSPC-SP10) Surface Profile: 50-75 microns

## Performance Data

Test Method	System	Results	Report #
ASTM D3359 Adhesion	Blasted Steel 2 cts 450	4A	08460
ASTM D5(Δ) Abrasion	Blasted Steel 2 cts 450	171 mg loss after 1000 cycles; CS17 wheel, 1000 gram load	02910
ASTM D2794 Impact	Blasted Steel 1 ct 450	.375" (9.5mm) from damaged area. 100-in./lbs	02675
Heat Cycling Test	Blasted Steel 1 ct 450	No cracking, blistering or delamination of film after: 218°C for 1 hr/ambient -23°C for 24 hrs/ambient 218°C for 24 hrs/ambient -23°C for 24 hrs/ambient 218°C for 200 hr/ambient	SR342
Modified NACE Std. TM-01-74B Immersion	Blasted Steel 2 cts 450	No effect to coating film except discoloration after 6 month exposure, Deionized water	02551
Chemical Resistance	Blasted Steel 1 ct 450	Resistant to fumes of commons acids, alkalis, solvents and hydrocarbon compounds. Resistant to splash and spillage of alkalis, solvents and hydrocarbons. Acid contact may cause discolouration of coating.	SR 359 02735 03133 02794

Test reports and additional data available upon written request

## 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, 12mm (½") I.D. minimum material hose, 2.8mm (.110") I.D. fluid tip and appropriate air cap.

**Airless Spray** Pump Ratio: 45:1 (min.)\*  
Output: 12 litres/min (min.)  
Material Hose: 12mm (½") I.D. (min.)  
Tip Size: .035-.041" (0.9-1.05mm)  
Output PSI: 2200-2500  
\*Teflon packings are recommended and available from the pump manufacturer.

**Brush** For striping of welds and touch-up of small areas only. Use a medium natural bristle brush and avoid rebrushing.

**Roller** Not recommended

## Mixing & Thinning

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

**Ratio** 4:1 Ratio (A to B)

**Thinning** May be thinned up to 10% with Thinner #213. For application on horizontal surfaces, may be thinned up to 10% with Thinner #2. Agitate Thinner #213 before use. Thinner #213 will have a thick viscous appearance which is normal. Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

**Pot Life** 3 Hours at 24°C. Pot life ends when coating loses body and begins to sag. Pot life times will be less at higher temperatures.

## 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 vapour 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.

**Caution** This product contains flammable solvents. 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%

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% R.H.	Dry to Handle	Dry to Topcoat w/ Other Finishes	Final Cure
10°C	18 hours	48 hours	21 days
16°C	12 hours	32 hours	14 days
24°C	6 hours	16 hours	7 days
32°C	3 hours	8 hours	4 days

These times are based on a 250 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. 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 bluish 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 final cure time is exceeded, the surface must be abraded by sweep blasting prior to the application of additional coats.

## Packaging, Handling & Storage

**Pack Sizes** 10 litre 2 component kits  
Part A: 8 litres  
Part B: 2 litres

**Flash Point (Setaflash)** Part A: 12°C  
Part B: >93°C

**Storage Temperature & Humidity** Store under cover  
4°-43°C  
0-90% Relative Humidity

**Shelf Life** Part A & B: Min. 36 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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