

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy Amide
Description	A 1:1, high solids polyamide epoxy designed to provide very good corrosion resistance as a single coat, direct-to-metal (DTM) exterior coating for railcars and other structures. While all epoxies will chalk and yellow under UV exposure, this coating has good color and gloss retention better than most.
Features	<ul style="list-style-type: none"> • Single coat direct to metal high solids epoxy • Very Low HAPS • Easy one coat high build coverage • Excellent adhesion • Very good resistance to corrosion and spillage /splash of mild chemical • Good initial gloss and very good color & gloss retention • Ready to use viscosity
Color	Black (C900), Grey (2830), White (A806) Other colors may be available upon request. Contact your Carboline representative for more information.
Gloss	80-90+ Per customer requirements (ASTM D523 @ 60° angle)
Dry Film Thickness	4 - 6 mils (102 - 152 microns) per coat Do not exceed 12 mils (300 microns)
Solids Content	By Volume 64% +/- 3%
Theoretical Coverage Rate	1027 ft ² /gal at 1.0 mils (25.2 m ² /l at 25 microns) 257 ft ² /gal at 4.0 mils (6.3 m ² /l at 100 microns) 171 ft ² /gal at 6.0 mils (4.2 m ² /l at 150 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : Per EPA Method 24: 2.5 lbs / gal (295 g/l)

SUBSTRATES & SURFACE PREPARATION

Steel	Severe service applications – blasted to SSPC-SP-10 to a 1.5-2.5 mil angular profile Lesser service applications – blasted to SSPC-SP-6 Surface to be free of all looser rust, dirt, grease and other contaminants
Aluminum	Remove all surface contaminants and treat with Strathmore's Wash Primer or equivalent.

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	Results
Adhesion (ASTM D3359)	5A (no peeling or removal)
Conical Mandrel (ASTM D522)	Passes 1/8"
Hardness (ASTM D3363)	4H - 5H
Impact Resistance (ASTM D2794)	Up to 120 lbs.in (Direct) and 60 lbs.in (Rev)

QUV Resistance (ASTM G154): Gray chalk, 19 gloss units, 460 hrs- QUV UVA-340 Bulb

Chemical Resistance: No effect on film of various chemicals on 4 hrs and 8 hrs spot tests.

MIXING & THINNING

Mixing | Agitate thoroughly each component before combining
 Mix (combine) 1:1 by volume Part A and Part B
 Agitate thoroughly again after combining
 Allow 20 minutes @ 75°F (23°C) of induction time to attain maximum gloss.

Thinning | 0-5% by volume maximum, consult Carboline for recommendations.
 If necessary reduce up to 5% after combining components.

Ratio | 1:1 Part A to Part B

Pot Life | 6 hours @ 70°F (21°C)

APPLICATION EQUIPMENT GUIDELINES

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.

Airless Spray |

- 45:1 Airless spray equipment
- Tip Size: 0.017 to 0.021
- Pump Pressure: 2500-3500 psi (17-24 MPa)

To minimize or eliminate thinner use in-line heated equipment with insulated hoses to reach application vis. Do not exceed 165°F (74°C).

APPLICATION PROCEDURES

General | Designed to be applied direct to metal in a single or two coat application.

APPLICATION CONDITIONS

Condition	Surface
Minimum	50°F (10°C)

Must be a minimum of 5°F (3°C) above the dew point during the surface preparation and coating application.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Minimum Recoat Time	Maximum Recoat Time
72°F (22°C)	3 Hours	6 Hours	12 Hours	7 Days

CURING SCHEDULE

Force Cure | If car is force dried, 1 hr minimum air dry @ 75°F (23°C) before oven.
Then force dry @ 145°F (60°C) for 1 hour, adjusting for ambient maximum conditions.

CLEANUP & SAFETY

Cleanup | MEK may be used for clean up. Batch mixed material will set up in the lines and equipment if left overnight. With plural component equipment, be sure to flush from the mixing head through the delivery hose and guns.

Safety | Handle with care. Before and during use, observe all safety labels on packaging and paint containers and follow all caution statements on this product data sheet. Consult the Safety Data Sheet (SDS) for this product and follow all local or national safety regulations. 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 sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

PACKAGING, HANDLING & STORAGE

Packaging | 55 gal drums or 5 gal pails

Shelf Life | Generally one year from date of manufacturing when kept at recommended storage conditions at 70°F (21°C) and in original unopened containers.
Do not use material beyond shelf life.

Storage Temperature & Humidity | Do not store at temperatures above 110°F (43°C).

Storage | Containers must be closed tightly. Do not store outside. Rotate stock.

Flash Point (Setaflash) | Part A: 31°F (-0.6°C)
Part B: 55°F (13°C)

WARRANTY

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