

SELECTION & SPECIFICATION DATA

Generic Type	5:1, high solids, two component, polyurethane color coat coating
Description	A 5:1, high solids, two component, polyurethane color coat coating. This coating is designed to provide very good corrosion, UV and chemical resistance as a middle coat, used with a primer and a clearcoat.
Features	<ul style="list-style-type: none"> • Excellent Weathering resistance • Very Low HAPS • Low VOC • Easy one coat coverage • Excellent adhesion • Very good resistance to corrosion and spillage /splash of mild chemical • Very flexible • Excellent color fastness
Color	White, Grey and Black or per customer requirements
Finish	Low Gloss
Dry Film Thickness	2 - 4 mils (51 - 102 microns) per coat Not to exceed 8 mils (200 µm) DFT.
Solids Content	By Volume 50% +/- 2%
Theoretical Coverage Rate	802 ft²/gal at 1.0 mils (19.7 m²/l at 25 microns) 401 ft²/gal at 2.0 mils (9.8 m²/l at 50 microns) 200 ft²/gal at 4.0 mils (4.9 m²/l at 100 microns) Allow for loss in mixing and application.
VOC Value(s)	Per EPA Method 24: 2.03 lbs/gal (243 g/l) These are nominal values and may vary slightly with color. This product contains US EPA VOC-exempt solvent(s).

SUBSTRATES & SURFACE PREPARATION

Steel	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.

MIXING & THINNING

Mixing	Agitate Part A component before combining Mix (combine) 5:1 by volume Part A and Part B Agitate thoroughly again after combining
Thinning	None required, consult Carboline for recommendations
Ratio	5:1 Part A to Part B (by Volume)

MIXING & THINNING

Pot Life | 4 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	<ul style="list-style-type: none">• 45:1 Airless spray equipment• Tip Size: 0.013 to 0.017• 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 in a single or two coat application.

APPLICATION CONDITIONS

Condition

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
70°F (21°C)	2 Hours	4 Hours	8 Hours	5 Days

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

PACKAGING, HANDLING & STORAGE

Shelf Life | 24 months from date of manufacturing when kept at recommended storage conditions at 70°F (21°C) and in original unopened containers.

Storage Temperature & Humidity | Do not store at temperatures above 100°F (38°C).

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

WARRANTY

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