

SELECTION & SPECIFICATION DATA

Generic Type	Single package silicone acrylic finish
Description	Air-dried coating available in colors and suitable for high temperature exposures up to 525°F (273°C). Air-drying characteristics allow for faster handling of in-shop applications than with other high-temperature coatings. Heat cure above 300°F (149°C) is recommended and will impart added strength and integrity to the coating.
Features	<ul style="list-style-type: none"> • Temperature resistance up to 525°F (273°C) • Single-coat application • Excellent resistance to thermal shock • Good weathering and color stability
Color	C901 (Aluminum) only
Primer	<ul style="list-style-type: none"> • Self-priming on stainless steel, aluminum and metalized surfaces. • For carbon steel, apply over recommended inorganic zinc primer. • A mist coating may be required to minimize bubbling over inorganic zinc primers. • Do not use as a topcoat over Thermaline Heat Shield.
Dry Film Thickness	<p>1.5 - 2 mils (38 - 51 microns) per coat</p> <p>Don't exceed 2.5 mils (63 microns) in a single coat. Excessive film thickness over inorganic zincs may increase damage during shipping or erection.</p>
Solids Content	By Volume 48% +/- 2%
Theoretical Coverage Rate	<p>770 ft²/gal at 1.0 mils (18.9 m²/l at 25 microns)</p> <p>513 ft²/gal at 1.5 mils (12.6 m²/l at 38 microns)</p> <p>385 ft²/gal at 2.0 mils (9.4 m²/l at 50 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Values	<p>Thinner 25 : 22 oz/gal (17%): 4.3 lbs/gal (517 g/l)</p> <p>Thinner 235 : 22 oz/gal (17%): 4.2 lbs/gal (503 g/l)</p> <p>As Supplied : 3.8 lbs/gal (456 g/l)</p> <p>These are nominal values and may vary slightly with color.</p>
Topcoats	Not Applicable

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.
Steel	SSPC-SP10 with 0.5-1.0 mils (12-25 microns) surface profile. Prime with specific Carboline primers as recommended by your Carboline sales representative.

MIXING & THINNING

Mixing	Thoroughly mix to a uniform consistency prior to use.
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Thermaline[®] 4900 Aluminum

PRODUCT DATA SHEET



MIXING & THINNING

Thinning | Normally not required. May be thinned up to 22 oz./gal. (17%) by volume with Thinner #25 for ambient conditions. For "hot" applications exceeding 150°F (66°C) use Thinner #230 instead. Use Thinner #238 up to 5% (6 oz) for brush or roller application. (Note: Shake Thinner #238 just prior to use).

Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Ratio | N/A

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.

Spray Application (General) | The following spray equipment has been found suitable for application of this material. Conventional spray application is preferred.

Conventional Spray | Use DeVilbiss P-MBC, E-needle and tip, and a 704 air cap or equal. Use adequate air volume for proper equipment operation. Hold gun 10-12" from the surface and at right angles. Lap each pass 50%. Apply 4.0-5.0 wet mils to obtain desired dry film.

Airless Spray | Not recommended.

Brush & Roller (General) | Recommended for touchup of small areas or where spray application is not permitted. Avoid excessive re-brushing or re-rolling.

Brush | Not recommended due to final appearance.

Roller | Not recommended due to final appearance.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	55°F (13°C)	40°F (4°C)	40°F (4°C)	0%
Maximum	95°F (35°C)	300°F (149°C)	120°F (49°C)	90%

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.

The alignment of aluminum flakes in aluminum filled finishes is very dependent on application conditions and techniques. Care must be taken to keep conditions as constant as possible to reduce variations in final appearance. It is also advisable to work from a single batch of material since variations can occur from batch to batch. For more information consult the Carboline Technical Service Dept.

CURING SCHEDULE

Surface Temp.	Dry to Topcoat	Dry to Touch
77°F (25°C)	4 Hours	1 Hour

These times are based on a 2.0 mils (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. These times are based on a 2.0 mils (50 micron) dry film thickness. While Thermaline 4900 Aluminum will air dry at ambient, optimum film properties are achieved with heat curing. The heat cure cycle consists of a minimum 2-hour flash off at 75°F (24°C) followed by slowly raising the substrate temperature to 300°F (149°C) and hold for at least 3 hours.

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 SDS 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 MSHA/NIOSH approved 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 National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	Min. 24 months at 77°F (25°C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40° - 100°F (4° - 38°C) 0-90% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	1 Gallon Kit - 12 Lbs. (5.5 kg) 5 Gallon Kit - 60 Lbs. (27 kg)
Flash Point (Setaflash)	77°F (25°C)

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WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.