

## Selection & Specification Data

<b>Generic Type</b>	Amine-Cured Novolac Epoxy
<b>Description</b>	<u>Highly cross-linked, glass flake-filled polymer that offers exceptional barrier protection and resistance to wet/dry cycling at elevated temperatures.</u> Suitable for insulated and non-insulated pipes, stacks and equipment operating up to 450°F (232°C). 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 450°F (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>▪ VOC compliant to current AIM regulations</li> </ul>
<b>Color</b>	Red (0500); Gray (5742)
<b>Finish</b>	Eggshell
<b>Primers</b>	Self-priming. May be applied over epoxies and phenolics.
<b>Topcoats</b>	Epoxies, Polyurethanes
<b>Dry Film Thickness</b>	8.0-10.0 mils (200-250 microns) Do not exceed 10 mils (250 microns) per coat.
<b>Solids Content</b>	By Volume: 70% ± 2%
<b>Theoretical Coverage Rate</b>	1117 mil ft <sup>2</sup> (27.9 m <sup>2</sup> /l at 25 microns) Allow for loss in mixing and application
<b>VOC Values</b>	As supplied: 2.1 lbs/gal (255 g/l) Thinned: 13 oz/gal w/ #213: 2.5 lbs/gal (307 g/l) 13 oz/gal w/#2: 2.5 lbs/gal (307 g/l) These are nominal values and may vary slightly with color.
<b>Dry Temp. Resistance</b>	Continuous: 425°F (218°C) Non-Continuous: 450°F (232°C) Discoloration and loss of gloss may be observed above 200°F (93°C).
<b>Limitations</b>	<ul style="list-style-type: none"> <li>▪ Epoxies lose gloss, discolor and eventually chalk in sunlight exposure.</li> <li>▪ Do not use for immersion service.</li> </ul>

## 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>	SSPC-SP6
	<u>Insulated:</u>	SSPC-SP10
	<u>Surface Profile:</u>	2.0-3.0 mils (50-75 microns)

## Performance Data

Test Method	System	Results	Report #
ASTM D3359 Adhesion	Blasted Steel 2 cts. 450	4A	08460
ASTM D4060 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 in. from damaged area. 100-in./lbs	02675
Heat Cycling Test	Blasted Steel 1 ct. 450	No cracking, blistering or delamination of film after 425°F for 1 hr/ambient/ -10°F for 24 hrs/ambient/ 425°F for 24 hrs/ambient/ -10°F for 24 hrs/ambient/ 425°F 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 discoloration of coating.	SR 359 02735 03133 02794

Test reports and additional data available upon written request.

## Application Equipment

**Spray Application (General)** The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

**Conventional Spray** Pressure pot equipped with dual regulators, ½" I.D. minimum material hose, .110" I.D. fluid tip and appropriate air cap.

**Airless Spray**  
 Pump Ratio: 45:1 (min.)  
 GPM Output: 3.0 (min.)  
 Material Hose: ½" I.D. (min.)  
 Tip Size: .035-.041"  
 Output PSI: 2200-2500  
 Teflon packings are recommended and available from the pump manufacturer.

**Brush** For stripping 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. **Allow 30 minute induction time at 75°F. DO NOT MIX PARTIAL KITS.**

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

**Thinning** May be thinned up to 13 oz/gal (10%) #213. For application on horizontal surfaces, may be thinned up to 13 oz/gal (10%) with Thinner #2. Agitate #213 before use. #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 75°F (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 #2 Thinner 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 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 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 National 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	65°-85°F (18°-29°C)	65°-85°F (18°-29°C)	65°-85°F (18°-29°C)	30-60%
Minimum	55°F (13°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	90°F (32°C)	110°F (43°C)	100°F (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% Relative Humidity	Dry to Handle	Dry to Topcoat w/ Other Finishes	Final Cure
50°F (10°C)	30 Hours	48 Hours	21 Days
60°F (16°C)	18 Hours	32 Hours	14 Days
75°F (24°C)	12 Hours	16 Hours	7 Days
90°F (32°C)	6 Hours	8 Hours	4 Days

These times are based on a 10.0 mil (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 blush 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

<b>Shipping Weight (Approximate)</b>	<b>1 Gallon Kit</b> 12 lbs (6 kg)	<b>5 Gallon Kit</b> 58 lbs (26 kg)
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**Flash Point (Setaflash)** Part A: 53°F (12°C)  
Part B: >200°F (93°C)

**Storage (General)** Store Indoors.

**Storage Temperature & Humidity** 40° - 110°F (4°-43°C)  
0-90% Relative Humidity

**Shelf Life** 24 months at 75°F (24°C)



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