

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, 9mm (3/8") I.D. minimum material hose, 1.8mm (.070") I.D. fluid tip and appropriate air cap.

Airless Spray Pump Ratio: 30:1 (min.)*
Output: 10 lt/min (min.)
Material Hose: 9mm (3/8") I.D. (min.)
Tip Size: .015-.017"
Output PSI: 2100-2400
Filter Size: 60 mesh
*Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) The desired film thickness is easily achieved in a single brush or roller coat; however due to the initial lacquer dry characteristic of this coating additional thinning with Thinner #12 may be required for a smooth finish; in warm or windy conditions use of slower solvent such as Thinner #25 may be advantageous. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 24°C.

Mixing & Thinning

Mixing Power mix Part A and Part B separately, then combine and power mix.

Ratio 4:1 by volume (Part A : Part B)

Thinning Thinning requirement will vary depending upon conditions. Thin with Thinner #12 as required for good atomisation; typically between 5% - 20%.

Pot Life 12 hours at 25°C

Cleanup & Safety

Cleanup Use Thinner #12 or #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 sprayed may be harmful by inhalation - do not breath vapour or spray. Wear suitable clothing, gloves, eye and face protection.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16°-24°C	16°-24°C	16°-24°C	30-70%
Minimum	5°C	5°C	5°C	0%
Maximum	32°C	50°C	50°C	85%

Curing & Recoat / Top-Coat Guide Schedule - Cg 504 at 50µm DFT

Over-Coating Sequence	Temp:	5°C	15°C	25°C	30°C
Self or epoxy	Min.	6 hr	2½ hr	2 hr	1½ hr
Polyurethanes (PUR)	Min.	8 hr	5 hr	4 hr	3 hr
Self or epoxy	Max.	90 dy	90 dy	60 dy	30 dy
PUR *except E-Line 379 & CT 130 Clear Coat	Max.	28 dy	28 dy	14 dy	5 dy
*E-L 379 & CT 130	Max.	10 dy	7 dy	5 dy	2 dy

Temperature Cautionary Note: The temperatures in the table above refer to the time-weighted average substrate or coating temperatures NOT ambient. In exterior situations surface temperatures can vary widely with sunlit surfaces often being 20+°C higher than the air temperature.

*Both E-Line 379 and Carbothane 130 Clear Coat have limited time to top-coat windows; maximum adhesion is obtained by strictly observing top-coat window times. When in doubt light sanding to matte finish prior to top-coating is recommended.

Packaging, Handling & Storage

Pack Sizes NZ Buff 1.25 litre 5 litre 10 litre
NZ Grey 10 litre
AU Buff 5 litre 10 litre

Flash Point (Setaflash) Part A: 23°C
Part B: 23°C

Storage Temperature & Humidity Store Indoors.
KEEP DRY 4°C-38°C
0-95% Relative Humidity

Shelf Life Part A & B: 24 months minimum

*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.

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