

SELECTION & SPECIFICATION DATA

Generic Type	Waterborne acrylic
Designation	This is a Carboline Specialty Product Minimum order quantities and special pricing will apply in North America. Contact your Carboline Sales Representative for more details.
Description	A high build waterborne acrylic with excellent weatherability and corrosion resistance when coupled with the appropriate primer.
Features	<ul style="list-style-type: none"> • Smooth, attractive, high build finish • Excellent weatherability, gloss and color retention • Low odor, low VOC • Excellent corrosion protection when coupled with the appropriate primer • Outstanding application characteristics • Single component
Color	Available in a variety of colors.
Finish	Eggshell
Primer	May be used over zincs, epoxies and acrylics. When applied over epoxy zinc rich primers, a 18 hour primer cure must occur.
Dry Film Thickness	3 - 8 mils (76 - 203 microns) over recommended primers
Solids Content	By Volume 42% +/- 2%
Theoretical Coverage Rate	674 ft ² /gal at 1.0 mils (16.5 m ² /l at 25 microns) 225 ft ² /gal at 3.0 mils (5.5 m ² /l at 75 microns) 84 ft ² /gal at 8.0 mils (2.1 m ² /l at 200 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 0.83 lbs./gal (99 g/l) These are nominal values and may vary slightly with color. VOC values are determined in accordance with EPA Method 24. Thinned: 6 oz/ gal w/potable water: 0.83 lbs/gal (99 g/l)
Dry Temp. Resistance	Continuous: 235°F (113°C) Non-Continuous: 325°F (163°C) Slight discoloration and loss of gloss is observed above 200 F (93 C).
Topcoats	May be topcoated with itself.

SUBSTRATES & SURFACE PREPARATION

General	Surfaces <u>must</u> be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
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Carbocrylic 3357 HB

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Steel	In accordance with primer requirements per Carboline product data sheet. When using under fireproofing products, defer to the primer surface preparation requirements in the product data sheet of the fireproofing product
Galvanized Steel	SSPC-SP1. Prime with Sanitile 120 or others as recommended by your Carboline Sales Representative. When using under fireproofing products, defer to the primer surface preparation requirements in the product data sheet of the fireproofing product.
Concrete or CMU	Concrete: Must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Laitance, form oils, curing agents and hardeners must be removed by suitable method before coating application. Prime with Sanitile 120. CMU: Mortar joints should be thoroughly cured for a minimum of 15 days at 75°F (24°C) and 50% relative humidity or equivalent. Prime with a latex block filler.
Drywall & Plaster	Joint compound and plaster should be fully cured prior to coating application. Prime with Sanitile 120.
Previously Painted Surfaces	Lightly sand or abrade to roughen surface and degloss the surface. Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 "X-Scribe" adhesion test. Prime with Sanitile 120 or others as recommended by your Carboline Sales Representative.
Wood	Lightly sand with fine sandpaper and remove dust. Prime with Sanitile 120.
PVC	Remove all oils, grease and dirt. Prepare surface by light sanding/abrading to degloss and provide anchor profile.

MIXING & THINNING

Mixing	Power mix until uniform in consistency. Avoid excessive air entrainment.
Thinning	Not normally required. May be thinned up to 6 oz/gal with clean, potable water where conditions dictate. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

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)	Pre-rinse equipment with undiluted Carboline Surface Cleaner 3 followed by clean, potable water before spraying. The following spray equipment has been found suitable.
Conventional Spray	Pressure pot equipped with dual regulators. 1/2" I.D. material hose, 0.086" fluid tip and appropriate air cap.

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Airless Spray	Pump Ratio: 30:1 (minimum)* GPM Output: 3.0 (minimum) Material Hose: 3/8" I.D. (minimum) Tip Size: 0.017" - 0.021" Output PSI: 1800 - 2200 Filter Size: 60 Mesh *PTFE packings are recommended and available from the pump manufacturer.
Brush	Use a synthetic bristle brush. Multiple coats may be required to achieve desired dry film thickness and hiding characteristics.
Roller	For smooth surfaces, use a short woven nap synthetic roller. For rough surfaces, cinder block or very porous concrete, use a 3/8" woven nap synthetic roller. Multiple coats may be required to obtain desired appearance, hiding and recommended dry film thickness.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	100°F (38°C)	120°F (49°C)	110°F (43°C)	85%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point. Do not apply if temperatures are expected to drop below 40°F (4°C) within 24 hours of application.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat with Itself	Dry to Touch
40°F (4°C)	10 Hours	24 Hours	60 Minutes
50°F (10°C)	8 Hours	12 Hours	30 Minutes
75°F (24°C)	3 Hours	4 Hours	20 Minutes
90°F (32°C)	2 Hours	2 Hours	15 Minutes

These times are based on 4 mil (100 microns) dry film thickness. Maximum adhesion and ultimate film properties are achieved after several weeks cure at 75°F with proper ventilation. High humidity, high film thickness, insufficient ventilation or cooler temperatures will lengthen dry to handle/topcoat times due to slower water evaporation rate. Waterborne acrylics are sensitive to moisture during early cure and are susceptible to handling damage. For 8.0 mils, the recoat time is 24 hours. Recoat intervals may vary from those listed above when using under intumescent fireproofing products. Consult Carboline Technical Service for recommended cure times before applying Carboline intumescent products.

CLEANUP & SAFETY

Cleanup	Use clean, potable water followed with a suitable solvent to dry equipment. 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. Use adequate ventilation. Keep container closed when not in use.

Carbocrylic 3357 HB

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 75°F (24°C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	45° - 110°F (7° - 43°C) 0-95% Relative Humidity
Storage	Store Indoors. Do not allow to freeze.
Shipping Weight (Approximate)	1 Gallon - 11 Lbs. (5 kg) 5 Gallon - 51 Lbs. (23 kg)
Flash Point (Setflash)	>200°F (>93°C)

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 Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. 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.