

SELECTION & SPECIFICATION DATA

Generic Type	Waterborne Acrylic
Designation	<p>This is a Carboline Specialty Product</p> <p>Minimum order quantities and special pricing will apply in North America. Contact your Carboline Sales Representative for more details.</p>
Description	Versatile high performance finish with excellent corrosion resistance and exterior weathering properties, as well as suitability for interior and mild environments.
Features	<ul style="list-style-type: none"> • Multi-purpose interior/exterior coating • Excellent color retention • Single component • Outstanding corrosion protection • Low odor, low VOC
Color	Refer to Carboline Color Guide. Minimum order quantities apply. Certain colors may require multiple coats to hide.
Finish	Flat
Primer	Acrylics, Alkyds, Epoxies, Inorganic and Organic Zincs and others as recommended under Substrates & Surface Preparation. A mist coat may be required to minimize bubbling over Inorganic Zinc primers.
Dry Film Thickness	<p>2 - 3 mils (51 - 76 microns) per coat</p> <p>Do not exceed 3.0 mils in a single coat</p>
Solids Content	By Volume 36% +/- 2%
Theoretical Coverage Rate	<p>577 ft²/gal at 1.0 mils (14.2 m²/l at 25 microns)</p> <p>289 ft²/gal at 2.0 mils (7.1 m²/l at 50 microns)</p> <p>192 ft²/gal at 3.0 mils (4.7 m²/l at 75 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Values	<p>As Supplied : 0.5 lbs/gal (60 g/l)</p> <p>Additive 102: 6.0 oz/gal: 0.8 lbs/gal (96 g/l)</p> <p>Additive 102: 6.0 oz/gal: 1.1 lbs/gal (132 g/l)</p> <p>EPA Method 24: 1.1 lbs/gal (132 g/l) (Calculated minus water and exempt solvents)</p> <p>Additive 102: 6.0 oz/gal: 1.8 lbs/gal (216 g/l)</p> <p>Additive 102: 6.0 oz/gal: 2.3 lbs/gal (276 g/l)</p> <p>These are nominal values and may vary slightly with color.</p>
Dry Temp. Resistance	<p>Continuous: 235°F (113°C)</p> <p>Non-Continuous: 325°F (163°C)</p> <p>Slight discoloration and loss of gloss is observed above 200°F (93°C).</p>
Limitations	Apply and cure at temperatures of 50 °F (10 °C) and above for 24 hours.

Carbocrylic[®] 3359 Flat

PRODUCT DATA SHEET



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-SP6 with a 1.0-2.0 mil (25-50 micron) surface profile for maximum protection. SSPCSP2 or SP3 as minimum requirement. Prime with specific Carboline primers as recommended by your Carboline Sales Representative.
Galvanized Steel	SSPC-SP16. Prime with Galoseal [®] WB or Carbocrylic 3358 Series for exterior use. A primer is not required for interior, dry, conditioned space.
Concrete or CMU	Concrete shall be designed, placed, cured, and prepared per NACE No. 6/SSPC-SP 13, latest edition. Abrade to remove all laitance, loose concrete, etc. and to create surface profile in accordance with the appropriate ICRI CSP standard for the coating system.
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 3B rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

MIXING & THINNING

Mixing	Power mix until uniform in consistency. Avoid air entrapment.
Thinning	May be thinned up to 6 oz/gal (5%) with clean, potable water. Areas with cool substrate and warm ambient conditions can experience a surface skinning and separation. Under these conditions, the use of 6-12 oz/gal (5-10%) of Additive 102 assists in the proper film formation at the recommended dry film thickness, without surface skinning. Use of thinners other than those supplied 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	Pre-rinse equipment with undiluted Carboline Surface Cleaner 3 followed by clean potable water before spraying. 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, .086" I.D. fluid tip and appropriate air cap.
Airless Spray	<ul style="list-style-type: none">• Pump Ratio: 30:1 (min.)*• Pump Ratio: 45:1 for two or more guns• GPM Output: 3.0 (min.)• Material Hose: 3/8" I.D. (min.)• Tip Size: 0.017-0.019"• Output PSI: 1800-2100• Filter Size: 60 mesh <p>*PTFE packings are recommended and available from the pump manufacturer. For ease of application, remove the pickup tube and immerse the lower unit directly into the material.</p>

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Brush & Roller (General)	Multiple coats may be required to achieve desired appearance, hiding and recommended dry film thickness. Avoid excessive re-brushing or re-rolling.
Brush	Use a synthetic bristle brush.
Roller	Use a short-nap synthetic roller cover with solvent resistant core. For rough surfaces, use a 3/8" woven nap synthetic roller.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	105°F (41°C)	130°F (54°C)	110°F (43°C)	85%

Do not apply when the surface temperature is less than 5 °F (-15 °C) above the dew point. Do not apply if temperatures are expected to drop below 50 °F (10 °C) within 24 hours of application. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat
50°F (10°C)	3 Hours	3 Hours
75°F (24°C)	2 Hours	2 Hours
90°F (32°C)	1 Hour	1 Hour

These times are based on a 2.0-3.0 mil (50-75 micron) dry film thickness. Higher film thicknesses, insufficient ventilation, high humidity or cooler temperatures will require longer cure times.

The acrylic film forming process may require several weeks at 75 °F (24 °C) with proper ventilation to develop the majority of its adhesion and water resistance. High humidity, high film thickness, insufficient ventilation or cooler temperatures will lengthen the cure times due to slower water evaporation rate. Waterborne acrylics are sensitive to moisture during early cure and are susceptible to handling damage.

CLEANUP & SAFETY

Cleanup	Use clean potable water followed with 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.

PACKAGING, HANDLING & STORAGE

Shelf Life	36 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	40-110 °F (4-43 °C) 0-95% Relative Humidity

Carbocrylic® 3359 Flat

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Storage | Store Indoors. **KEEP FROM FREEZING.**

Shipping Weight (Approximate) | 1 Gallon - 11 lbs (5 kg)
5 Gallons - 51 lbs (23 kg)
50 Gallons - 525 lbs (239 kg)

Flash Point (Setaflash) | >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.