Carboclad 938 Finish

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Single component non-isocyanate (NISO) vinyl acrylic copolymer
Description	An economical finish coat with good chemical resistance, flexibility and weathering properties. Compatible with recommended primers and intermediate coats. Easy to apply and fast drying. Available in safety and coding colours.
Features	• Finishing coat for inorganic zincs, vinyls, epoxies and other recommended primers and intermediates. • Topcoat for Carboclad 938 Vinyl System. • Suitable for maintenance and refurbishment of structural steel, pipe and tank exteriors. • May be used for topcoating of surfaces that operate at moderately hot temperatures up to 149°C. • Can be applied by conventional and airless spray. • May be applied over some single package generic types (a test patch is recommended to evaluate adhesion and compatibility over aged coating systems) • Excellent flexibility • Excellent weathering • Fair abrasion resistance • Not recommended for solvent exposure or immersion service.
Color	Available in a variety of colours, including safety and coding colours. White and pastel shades may require multiple coats for adequate hiding. Consult your local StonCor Africa Sales or Customer Service Department for availability.
Finish	Medium Gloss
Primer	May be applied over recommended inorganic zinc, vinyl and epoxy primers. Apply a mist coat over inorganic zinc where required to minimise bubbling and obtain adequate film build.
Dry Film Thickness	40 Microns
Solid(s) Content	By Volume 32% ± 2%
Theoretical Coverage Rates	8.0m²/litre at 40 microns NOTE: Allow for mixing and application losses.
Dry Temp. Resistance	Continuous: 149°C (300°F) Non-Continuous: 200°C (392°F)
Substrates & Compatable Coatings	Properly primed steel surfaces or others as recommended.
Topcoats	Normally none. Light or pastel colours may require two coats for adequate hiding over darker primers or intermediate coats.

SUBSTRATES & SURFACE PREPARATION

General	Remove oil, grease and other surface contaminants before coating.
Steel	Apply over clean, dry, recommended primers and intermediate coats.

MIXING & THINNING

Mixing	Power mix to a smooth, uniform consistency before thinning.
Thinning	Thin up to 12% by volume with Thinner # 10, where required. NOTE: Use of thinners other than those supplied or approved by StonCor Africa 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	Use sufficient air volume for correct operation of equipment. Apply each pass with approximately 50% overlap. On irregular surfaces, coat the edges first, making an extra pass later. Under certain conditions, when applied over inorganic zinc primers, a mist coat followed by a full coat may be required.
Conventional Spray	Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface. **Gun:**905 Spray Gun **Fluid Tip:**1.8mm **Air Cap:**905-PV
Airless Spray	Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface. **Gun:**TRITECH T360 Spray Gun **Pump:**47:1 * PTFE packings are recommended and are available from pump manufacturer. Revers-A-clean tip is recommended. Use a .013 to .017” tip with 2000 psi (138 bar)
Brush	Use natural bristle brush, applying with full strokes. Avoid rebrushing.
Roller	For small areas or touch-up only. Use a short nap roller with phenolic core.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	4°C (39°F)	4°C (39°F)	0%
Maximum	38°C (100°F)	43°C (109°F)	43°C (109°F)	95%
Optimum	24°C (75°F)	25°C (77°F)	24°C (75°F)	45%

Do not apply when the surface temperature is less than 3°C above the dew point.
Special thinning and application techniques may be required above or below normal conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle or Topcoat
4°C (39°F)	24 Hours
16°C (61°F)	8 Hours
25°C (77°F)	4 Hours
32°C (90°F)	2 Hours

CURING SCHEDULE

Curing Details	**Relative Humidity: 50%**

CLEANUP & SAFETY

Cleanup	Thinner # 2
Safety	Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product. Use suitable PPE and normal industrial safety precautions.
Ventilation	Provide effective ventilation during application and cure, particularly in enclosed areas. Refer to the latest Safety Data Sheet for this product.
Caution	This product contains flammable solvents. Keep away from sparks, open flames and other ignition sources.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 Months minimum when stored at 25°C in original unopened container. *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	**5 Litre:** Carboclad 938 Finish: 6.6kg Thinner # 10: 4.9kg
Storage Temperature & Humidity	4 to 43°C 0 to 100% Store indoors
Flash Point (Pensky Martens Closed Cup)	Carboclad 938 Finish: 20°C Thinner # 10: 20°C

WARRANTY

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