

SELECTION & SPECIFICATION DATA

Generic Type	Modified alkyd enamel
Description	A high gloss alkyd finish that dries to a uniform, touch film. It has very good application properties and can be used over properly primed metal surfaces. Compatible with most alkyd primers. Provides excellent protection in mild environments.
Features	<ul style="list-style-type: none"> • As a finish coat for atmospheric protection of plant equipment, farm equipment, road building machinery, pipe racks, exposed structural steel, tank exteriors and steel buildings • Excellent flexibility • Excellent weathering • Very good abrasion resistance • May be applied over most alkyd primers. Specific recommendations include Carboline GP Primers and Undercoats • Not recommended for immersion service, splash and spillage of acids, alkalies and strong solvents
Color	Available in a variety of 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	High Gloss
Dry Film Thickness	40 Microns
Solid(s) Content	By Volume 40% ± 2% May vary with certain colours
Theoretical Coverage Rates	10m ² /litre at 40 microns NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
Dry Temp. Resistance	Continuous: 85°C (185°F) Non-Continuous: 110°C (230°F) Coating may discolour
Topcoats	Optional second coat will give a longer service life and may be required when covering dark primers with a light colour topcoat.

SUBSTRATES & SURFACE PREPARATION

General	Remove any oil and grease from surface to be coated.
Steel	Apply over clean, dry, recommended primers.

MIXING & THINNING

Mixing	Mix to a uniform consistency before thinning.
Thinning	Thin up to 10% by volume with Thinner # 85. 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.

Carbocoat AD-51 Finish

PRODUCT DATA SHEET



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 adequate air volume for correct operation.
Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

- 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 (SX290)

* Teflon packings are recommended and are available from the pump manufacturer.
Use a .015" to .017" tip with 2000 psi (138 bar)

- Brush** | Use a medium natural bristle brush.

- Roller** | Use a short nap mohair roller with phenolic core.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	49°C (120°F)	50°C (122°F)	49°C (120°F)	95%
Optimum	19°C (66°F)	22°C (72°F)	25°C (77°F)	60%

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.	Final Cure	Between Coats
10°C (50°F)	7 Days	36 Hours
16°C (61°F)	5 Days	24 Hours
24°C (75°F)	3 Days	16 Hours
32°C (90°F)	2 Days	12 Hours

Curing Details | **Relative Humidity: 50%**
Drying times at 40 microns D.F.T.

CLEANUP & SAFETY

- Cleanup** | Use Thinner # 2

- Safety** | Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product. Employ normal workmanlike safety precautions.

CLEANUP & SAFETY

Ventilation	When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured.
Caution	This product contains flammable solvents. Keep away from sparks and open flames.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 Months minimum when stored at 25°C *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	5 Litre: Carbocoat AD-51: 6kg Thinner # 85: 4.5kg
Storage Temperature & Humidity	2 to 43°C 0 to 100% Store indoors
Flash Point (Pensky Martens Closed Cup)	Carbocoat AD-51: 25°C Thinner # 85: 35°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.