

Selection & Specification Data

GENERIC TYPE Epoxy-polyamide. Part A and Part B mixed prior to application

GENERAL PROPERTIES Penetrating clear primer-sealer for concrete surfaces prior to application of surfacers or polyurethane membranes. Carboline 1340 Clear meets ASTM C-309 Type 1 specification for moisture retention of concrete (check local Air Pollution Regulations before use). Excellent fast-drying material. Priming and sealing action provides excellent adhesion for surfacers and polyurethane membranes.

RECOMMENDED USES As a curing compound or form release agent. For application on "green" concrete walls to retard the escape of moisture during cure period. Excellent for use as a form coating on plywood or steel forms. Application prior to surfacing assures tight adhesion between concrete and surfacers or membranes. Compatibility with other coatings, surfacers and polyurethane membranes eliminates need for form release oils or curing oils.

NOT RECOMMENDED FOR Immersion in strong acids or solvents or in corrosive areas without recommended topcoat.

CHEMICAL RESISTANCE GUIDE : (with suitable topcoat)

<u>Exposure</u>	<u>Splash & Spillage</u>
Acids	Good
Alkalies	Good
Solvents-Aliphatic	Good
Salt	Very Good
Water	Very Good
Solvent-Aromatic and Koetone	Good
Oil & Grease	Excellent

TEMPERATURE RESISTANCE : (Non-immersion)	
Continuous	180°F (82°C)
Non-Continuous	220°F (104°C)
May yellow at temperatures above	150°F (66°C)

FLEXIBILITY : Very Good **WEATHERING :** Good(chalks)

ABRASION RESISTANCE : Excellent

SUBSTRATE Apply over suitably primed metal, concrete, or other surface as recommended.

TOPCOAT REQUIRED May be topcoated with catalyzed epoxies, phenolics, polyurethane membranes or other as recommended. Consult Carboline Technical Service for specific recommendations. An acceptable topcoat is Phenoline 305. Recommended Surfacer: Carboline 195 Surfacer and Carboline 295 WB Surfacer.

COMPATIBILITY WITH OTHER COATINGS Can be applied over most epoxies. For specific recommendations, contact Carboline Technical Service.

Specification Data

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL
By Volume

Carboline 1340 Clear 28% ±2%

RECOMMENDED DRY FILM THICKNESS PER COAT: 2mils(50u)

THEORETICAL COVERAGE PER MIXED GALLON*

449 mil sq. ft (11.2 sq. m/l at 25μ)

224 sq. ft. at 2 mils (5.6 sq. m/l at 50μ)

*NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

SHELF LIFE Twenty-four months minimum when stored at 75°F (24°C)

COLORS Clear only

GLOSS High; will chalk if exposed to sunlight.

Ordering Information

Prices may be obtained from Carboline Sales Representative or Main Office.

APPROXIMATE SHIPPING WEIGHT :

	<u>2's</u>	<u>10's</u>
Carboline 1340 Clear	18lbs.(8kg)	86lbs.(39kg)
Carboline Thinner #15	9lbs.(4kg) In 1's	45lbs.(20kg) In 5's

FLASH POINT : (Pensky-Martens Closed Cup)

Carboline 1340 Clear Part A	34°F (1°C)
Carboline 1340 Clear Part B	48°F (9°C)
Carboline Thinner #15	74°F (23°C)

Application Instructions

SURFACE PREPARATION Remove any oil grease from surface to be coated with clean rags soaked in Carboline Thinner #2 in accordance with SSPC-SP 1-82.

STEEL For non-immersion service, abrasive blast to a Commercial Finish in accordance with SSPC-SP 6-85 to a degree of cleanliness in accordance with NACE #3 to obtain a 1-2 mil (25-50μ) blast profile.

Concrete Curing Compound-Walls Only: Apply immediately after forms have been stripped.

Floors must have cured concrete. Carboline 1340 Clear cannot be used as a curing membrane for concrete floors.

Form Release Compound: Use clean, dry, untreated Grade 1 plywood. Apply at least two coats, thin first coat 50%. Refresher coats may be applied as needed.

Carboline 1340 Clear is not a substitute for blasting or acid etching for immersion service.

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Application Instructions

NOTE: While Carboline 1340 Clear may be applied to green concrete walls, generally additional coats or other coatings should not be applied until the concrete has cured 28 days at 75°F(24°C) and 50% R.H. or equivalent.

Primed surface - Remove fins and other protrusions by stoning, sanding or grinding. Remove form oils, incompatible curing agents and hardeners by abrasive blasting. For large holes or pits, use an epoxy surfacer for leveling and uniformity prior to application of Carboline 1340 Clear.

Immersion Service - Abrasive blast to open all voids and obtain a surface similar to medium grit sandpaper (horizontal surfaces may be acid etched). Blow or vacuum off sand and dust.

Non-immersion - Horizontal surfaces must be acid etched or abrasive blasted to remove laitance. For other surfaces, blow off with compressed air to remove dust.

Wood : Should be free of chips and splinters. Excessively rough wood should be sanded before coating.

MIXING power mix separately, then combine and mix in the following proportions:

Mfr. & Gun	2 Gal. Kit	10 Gal. Kit
Carboline 1340 ClearPart A	1 gallon	5 gallons
Carboline 1340 ClearPart B	1 gallon	5 gallons

For spray or brush application, may be thinned up to 25% by volume with Carboline Thinner #15. When coating wood, the first coat should be thinned 50% by volume with Carboline Thinner #15.

Allow a 1 hour "sweat-in" prior to application.

NOTE : Use of thinners other than those supplied or approved by Carboline may adversely affect product performance and void product warranty whether expressed or implied.

POT LIFE Twenty-four hours at 75°F(24°C) and less at higher temperatures. Pot life ends when coating become too viscous to use.

APPLICATION TEMPERATURES :

	<u>Material</u>	<u>Surfaces</u>
Normal	50-85°F(10-29°C)	50-85°F(10-29°C)
Minimum	39°F(4°C)	39°F(4°C)
Maximum	90°F(32°C)	129°F(54°C)

	<u>Ambient</u>	<u>Humidity</u>
Normal	50-90°F(10-32°C)	30-85%
Minimum	39°F(4°C)	0%
Maximum	120°F(49°C)	90%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point.

Special thinning and application techniques may be required above or below normal conditions.

SPRAY Use sufficient air volume for correct operation of equipment.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

NOTE : The following equipment has been found suitable; however, equivalent equipment may be substituted.

Conventional Use a 3/8" minimum I. D. material hose. Hold gun approximately 12-14 inches from the surface and at a right angle to the surface.

<u>Mfr. & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	63B	63PB
DeVilbiss P-MBC or JGA	FX	704
	Approx. .043" I.D.	

Airless Use a 3/8" minimum I.D. material hose. Hold gun approximately 18-20 inches from the surface and at a right angle to the surface.

<u>Mfr. & Gun</u>	<u>Pump*</u>
DeVilbiss JGB or JGN	QFA-514 or QFA-519
Graco 205-591 or 208-663	President 30:1 or Bulldog 30:1
Binks Model 700	B5-18 or B8-36

*Teflon packings are recommended and are available from pump manufacturer. Use a .013-.015" tip with 2000 psi.

BRUSH OR ROLLER Use a natural bristle brush or short nap roller with phenolic core. Lambswool applicator may also be used.

DRYING TIMES BEFORE TOPCOATING :

<u>Temperature</u>	<u>Minimum</u>	<u>Maximum*</u>
40°F (4°C)	24 Hours	48 Hours
50°F (10°C)	12 Hours	42 Hours
60°F (16°C)	6 Hours	35 Hours
75°F (24°C)	2 Hours	24 Hours
90°F (32°C)	2 Hours	18 Hours

* If maximum drying times are exceeded, surface must be wiped with Carboline Thinner #2. If more than one week has elapsed, another coat of Carboline 1340 Clear must be applied before topcoating. Failure to take these measures may result in poor adhesion or delamination between coats.

CLEAN UP Use Carboline Thinner #2.

STORAGE CONDITION : (Store Indoors)

Temperature : 45-110°F(7-43°C) *
Humidity : 0-90%

*Return to minimum application temperature before use.

