product data

Carboline® 0505 RC

Selection Data

GENERIC TYPE : polyamide cured recoatable epoxy coating. Part A and Part B mixed prior to application

GENERAL PROPERTIES : High-build finish or intermediate coat. Can be over coated with two component and conventional coating even after long weathering period. Has excellent durability, tough film with long term flexibility and good resistance to water and splash of mild chemical. Will cure even at temperature down to 23℉ (-5℃)

RECOMMENDED USES : Recommended as a general purpose epoxy finish or intermediate coat in protective coatings for steel and concrete structures exposed to atmospheric land or marine conditions. Can be used for protection of above water hulls, decks and super-structure

NOT RECOMMENDED FOR : Immersion service or exposure to strong acids and solvents.

TYPICAL CHEMICAL RESISTANCE :

Exposure	Splash & Spillage	Fumes
Acids	Good	Very Good
Alkalies	Very Good	Very Good
Solvents	Good	Very Good
Salt	Excellent	Excellent
Water	Excellent	Excellent

TEMPERATURE RESISTANCE : (Non-Immersion)

Continuous : 200℉(93℃)
Non-Continuous : 250℉(121℃)

FLEXIBILITY : Very Good

WEATHERING : Very Good (better than normal epoxy)

SUBSTRATES : Apply over suitably primed metal or other surface as recommended.

COMPATIBLE COATINGS : May be top-coated with polyurethanes, chlorinated rubber, vinyl, epoxies, alkyd or others as recommended. Can not over coated with coal tar epoxy. Can be applied over good aged alkyd, chlorinated rubber, vinyl and epoxies. A Mist-coat is required to minimize bubbling over inorganic zincs.

Specification Data

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL :

	By Volume
Carboline 0505 RC	63% ± 2%

RECOMMENDED DRY FILM THICKNESS PER COAT :
4-6 mils (100-150μ)

THEORETICAL COVERAGE PER MIXED GALLON :
1010 mil sq. ft. (25.2 sq. m/ℓ at 25μ)
252 sq. ft. at 4 mils (6.3 sq. m/ℓ at 100μ)

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

SHELF LIFE : 12 months when stored at 75℉ (24℃)

GLOSS : Low gloss (Epoxies lose gloss and chalk in sun-light exposure)

COLORS : Available in Carboline color chart colors.

Ordering Information

Prices may be obtained from Carboline sales representative or main office.

APPROXIMATE SHIPPING WEIGHT :

	1 Gal. Kit	5 Gal. Kit
Carboline 0505 RC	11.3 lbs. (5.1 kg)	56.5 lbs. (25.5 kg)
Carboline Thinner #433	7 lbs. (3.2 kg)	35 lbs. (16 kg)

FLASH POINT : (Pensky-Martens Closed Cup)

Carboline 0505 RC Part A	79℉(26℃)
Carboline 0505 RC Part B	77℉(25℃)
Carboline Thinner #433	79℉(26℃)

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

STEEL : Apply over clean, dry recommended primer.

MIXING : Power mix Part A, then combine and mix in the following proportions.

	1 Gal. Kit	5 Gals. Kit
Carboline 0505 RC Part A	0.8 Gal	4 Gals
Carboline 0505 RC Part A	0.2 Gal	1 Gal

Thin up to 20% by volume with Carboline Thinner #433.

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

INDUCTION TIME : 20 minutes if applied at temperature below 50°F (10℃)

POT LIFE : Four hours at 75°F (24℃) and less at higher temperature. Pot life ends when coating becomes too viscous to use.

APPLICATION TEMPERATURES :

	Material	Surfaces
Normal	60-85°F(16-29℃)	60-90°F(16-32℃)
Minimum	50°F(10℃)	23°F(-5℃)
Maximum	90°F(32℃)	135°F(57℃)

	Ambient	Humidity
Normal	65-85°F(16-29℃)	NA
Minimum	23°F(-5℃)	0%
Maximum	110°F(43℃)	95%

Do not apply when the surface temperature is less than 5°F(3℃) 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 3/8" minimum I.D material hose.
Hold gun approximately 12-14 inches from the surface and at a right angle to the surface.

Mfr. & Gun	Fluid Tip	Air Cap
Binks #18 or #62	66	63PB
DeVilbiss P-MBC or JGA	E	704
	Approx..070" I.D.	

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

Mfr. & Gun	Pump*
Devilbis JGA-507	QFA-514 or QFA-519
Graco 205-291	President 30 : 1 or Bulldog 30 : 1

* Teflon packing is recommended and is available from pump manufacturer.

Use a 0.019"~0.023" tip with 2000psi.

BRUSH OR ROLLER : For small area or touch-up only. Use a medium natural bristle brush, with full strokes. Avoid rebrushing. Use a short nap mohair roller with phenolic core.

DRY TIME :

Temperature	Dry to Top coat	Final Cure
23°F(-5℃)	48 Hours	20 Days
32°F(0℃)	30 Hours	10 Days
50°F(20℃)	12 Hours	6 Days
68°F(30℃)	6 Hours	4 Days
86°F(40℃)	4 Hours	3 Days

NOTE : Maximum recoat intervals : No limitation.
Chalking should be removed by water washing and surface should be dry and free from any contaminants.

CLEAN UP : Use Carboline Thinner #15.

STORAGE CONDITIONS :

Temperature : 50°F-90°F(10-32℃)
Humidity : 0-100%

CAUTION: CONTAINS FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST. WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.