

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Aliphatic Acrylic Polyurethane
<b>Description</b>	Carboline 134 is an excellent weatherable finish for exterior exposures in industrial and marine environments. It has wide versatility as a high gloss aesthetically pleasing finish for a variety of exposures. It is an ideal topcoat over epoxy primers or intermediates to enhance appearance and longer term weathering characteristics.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Very good weathering (75% gloss retention after 4000 hours QUV-A exposure)</li> <li>• Exceeds SSPC-Paint Spec 36; Level 3</li> <li>• 6 hours dry to handle time</li> <li>• High gloss appearance</li> <li>• Brush, roll, or spray application</li> <li>• Minimum 2 hours working time</li> </ul>
<b>Color</b>	Custom colors (Rapid Tint Service)
<b>Finish</b>	High Gloss
<b>Primer</b>	Acceptable primers include Carboguard epoxies.
<b>Dry Film Thickness</b>	1.5 - 2 mils (38 - 51 microns) per coat
<b>Solids Content</b>	By Volume 48% +/- 2%
<b>Theoretical Coverage Rate</b>	770 ft <sup>2</sup> /gal at 1.0 mils (19.2 m <sup>2</sup> /l at 25 microns) 513 ft <sup>2</sup> /gal at 1.5 mils (12.6 m <sup>2</sup> /l at 38 microns) 385 ft <sup>2</sup> /gal at 2.0 mils (9.6 m <sup>2</sup> /l at 50 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 480 g/l  These are nominal values and may vary slightly with color.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	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.
<b>Steel</b>	Prime with appropriate primers as recommended in section on "Primers".

## PERFORMANCE DATA

Test Method	System	Results
QUV-A	Carboline 134	Minimum 75% gloss retention after 4000 hours

## MIXING & THINNING

<b>Mixing</b>	Power mix Part A separately, then combine with Part B and power mix. DO NOT MIX PARTIAL KITS.
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<b>Thinning</b>	May be thinned up to 13oz/gal(10%) with Thinner#25 or 25(K). Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
<b>Ratio</b>	7:1 by volume (Part A to Part B)
<b>Pot Life</b>	4 Hours at 75°F (24°C) and less at higher temps. Pot life ends when coating becomes too viscous to use. MOISTURE CONTAMINATION WILL SHORTEN POT LIFE AND CAUSE GELLATION.

## 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.

<b>Spray Application (General)</b>	The following spray equipment has been found suitable and is available from equipment manufacturers.
<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.
<b>Airless Spray</b>	*Pump Ratio: 30:1 (min.) GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .015-.017" Output PSI: 1800-2200 Filter Size: Remove filters *PTFE packings are recommended and available from the pump manufacturer.
<b>Brush &amp; Roller (General)</b>	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or rerolling. For best results, tie-in within 10 minutes at 75°F (24°C).
<b>Brush</b>	Use a synthetic bristle brush.
<b>Roller</b>	Use a short-nap mohair roller cover with solvent resistant core.

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	40°F (4°C)	40°F (4°C)	40°F (4°C)	0%
Maximum	110°F (43°C)	130°F (54°C)	120°F (49°C)	85%

Do not apply when the surface temperature is less than 3°C (5°F) above the dew point. Do not apply if temperatures are expected to drop below 40°F (4°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 Recoat
60°F (16°C)	10 Hours	6 Hours
75°F (24°C)	6 Hours	3 Hours
90°F (32°C)	3 Hours	30 Minutes

These times are based on a 40 microns (1.58 mil) dry film thickness. Higher film thicknesses, insufficient ventilation, or cooler temperatures will require longer cure times. The material is typically ready to recoat when it passes a "dry to handle" test (thumb twist test).

## PACKAGING, HANDLING & STORAGE

**Shelf Life** | Min. 24 months at 75°F (24°C)  
\*Shelf Life: when kept at recommended storage conditions and in original unopened containers.

**Storage Temperature & Humidity** | 40° -110°F (4°-43°C)  
0-100% Relative Humidity

**Storage** | Store Indoors.

**Shipping Weight** 4 Liters - 5.6 kg  
**(Approximate)** 18 Liters – 24.5 kg

**Flash Point (Pensky-  
Martens Closed Cup)** Carboline 134 Part A 63 °F(24°C)  
Urethane Convert 134/134GS Part B 91 °F(33°C)  
Carboline Thinner #25,25(K) 87 °F(31°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.