

Selection & Specification Data

Generic Type	Cicloaliphatic Amine Epoxy
Description	<u>High solid corrosion resistant primer and intermediate.</u> Used either as a primer or as an intermediate coat over steel and inorganic zinc primers. Can be topcoated with a broad variety of high performance finish coatings.
Features	<ul style="list-style-type: none"> ▪ Excellent corrosion protection ▪ Excellent film build and edge protection ▪ Used as a primer or as an intermediate coating ▪ <u>Can be pigmented with micaceous iron oxide (MIO version)</u> ▪ Good abrasion resistance ▪ VOC compliant to current AIM regulation
Color	Red or light gray only
Finish	Eggshell
Primers	Self-priming. May be applied over organic and inorganic zinc primers. A mist coat may be required to minimize bubbling over inorganic zinc primers.
Topcoats	Acrylics, Epoxies, Polyurethanes, Alkyds
Dry Film Thickness	75 µm (3.0 mils) for mild environments and as an intermediate coat over inorganic zinc. 100-150 µm (4.0-6.0 mils) for more severe environments. Don't exceed 250 µm (10 mils) in a single coat. Excessive film thickness over inorganic zincs may increase damage during shipping or erection.
Solids Content	By Volume: 77 ± 2 %
Theoretical Coverage Rate	30,8 m ² /l at 25 microns (1235 mil ft ²) Allow for loss in mixing and application
VOC Values	As supplied: 195 g/l (1.60 lbs./gal) Thinned: 12% BV Th# 2: 261 g/l (2.2 lbs/gal) 25% BV Th# 33: 329 g/l (2.7 lbs/gal) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 93°C (250°F) Non-Continuous: 121°C (300°F) Discoloration and loss of gloss is observed above 93°C (200°F).
Limitations	Not recommended for immersion service

Substrates & Surface Preparation

General	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.
Steel	SSPC-SP6 (ISO 8501-1 SA 2) <u>Surface profile:</u> 25-50 µm (1-2 mils)
Concrete	Concrete must be cured 28 days at 24°C (75°F) and RH 50% or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.

Application Equipment

Spray Application (General)	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, De Vilbiss and Graco
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.) GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .017"-.021" Output PSI: 2100-2300 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding: Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 24°C (75°F)
Brush	Use a medium bristle brush
Roller	Use a short nap synthetic roller cover with phenolic core

Mixing & Thinning

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS
Ratio	1:1 Ratio by volume
Thinning	Spray : up to 12% by volume with Th.#2 Brush : up to 25% by volume with Th.#33 Roller : up to 25% by volume with Th.#33 Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Pot Life	4 Hours at 24°C (75°F) Pot-life ends when coating loses body and begins to sag. Pot-life times will be less at higher temperatures. Thinning rates above 12% BV will shorten the working time to 2 hours

Cleanup & Safety

Cleanup	Use #2 Thinner or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
Ventilation	When used as a tank lining or in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16-29°C	16-29°C	16-32°C	0-80%
Minimum	10°C	10°C	10°C	0%
Maximum	32°C	57°C	43°C	80%

Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions. Do not apply when the surface temperature is less than 3°C above the DEW- POINT

Curing Schedule

Surf. Temp. & 50% RH	Dry to Touch	Dry to Handle	Dry to Topcoat
10°C	5 Hours	16 Hours	24 Hours
16°C	4 Hours	12 Hours	16 Hours
24°C	3 Hours	6 Hours	8 Hours
32°C	2 Hours	3 Hours	4 Hours

Surf. Temp. & 50% RH	Maximum Recoat Time w/ Epoxy	Maximum Recoat Time w/ Polyurethanes	Maximum Recoat Time w/ Acrylics
10°C	30 Days	90 Days	14 Days
24°C	30 Days	90 Days	14 Days
32°C	15 Days	30 Days	14 Days

These are based on a 100 µm DFT. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. During high humidity conditions, it is recommended that the application be done while temperatures are increasing. **Maximum recoat/topcoat times are 30 days for epoxies and 90 days for polyurethanes at 75°F (24°C).** If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats.

Packaging, Handling & Storage

Kit Standard	Part A: 10 liters	Part B: 10 liters
Flash Point (Setaflash)	16°C (61°F) for Part A; 15°C (59°F) for Part B;	
Storage Temperature & Humidity	4° - 43°C (40°-110°F) Store indoors. 0-90% Relative Humidity	
Shelf Life	36 months at 24°C (75° F)	

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