

SELECTION & SPECIFICATION DATA

Generic Type	Modified Alkyd Primer
Description	Fast drying steel primer that provides corrosion protection on structural steel. Well suited for fabrication shops that need fast cure to dry and handle times. May be topcoated with conventional alkyds and acrylics for color, aesthetics, or additional protection.
Features	Fast Dry VOC compliant less than 250 g/l
Color	0500 (Tile Red), 0700 (Grey) are standard. 0900 (Black), 0800 (White) available by special order.
Finish	Flat
Dry Film Thickness	2 mils (51 microns) per coat Average thickness 1.5-2.0 mils (37-50 microns)
Solids Content	By Volume 56% +/- 2%
Theoretical Coverage Rate	898 ft ² /gal at 1.0 mils (22.0 m ² /l at 25 microns) 449 ft ² /gal at 2.0 mils (11.0 m ² /l at 50 microns) Allow for loss in mixing and application.
VOC Value(s)	Per EPA Method 24: 2.08 lbs/gal (249 g/l) These are nominal values and may vary slightly with color. Product contains VOC-exempt t-butyl acetate. Check local regulations regarding product usage.
Dry Temp. Resistance	Continuous: 180°F (82°C) Non-Continuous: 200°F (93°C)
Topcoats	May be topcoated with other products, as recommended by Carboline Technical Service.

SUBSTRATES & SURFACE PREPARATION

Galvanized Steel	NOT RECOMMENDED for galvanized steel.
Special Instruction	This primer should be applied the same day as cleaning to prevent re-rusting. Spray is the preferred application method due to the quick drying nature of the product.
Ferrous Metal	The surface should be thoroughly cleaned to remove dirt, grease, chalk and air pollution deposits, ideally by power washing. For aggressive environments, in order to obtain adhesion, a Commercial Blast (SSPC-SP6. For noncorrosive environments, depending on the condition of the steel, the surface preparation shall be either SSPC-SP2 Hand Tool Cleaning, SSPC-SP3 Power Tool Cleaning, or SSPC-SP11 Power Tool Cleaning, or SSPC-SP6 Commercial Blast Cleaning.

MIXING & THINNING

Mixing	Power mix to a uniform consistency.
Thinning	Thinning is not normally required. Can use up to 5% by volume thinner 242 E. Material is ready to spray.

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.

Conventional Spray | Binks #18 or #62 gun or equal cup or pressure pot
Fluid Nozzle: 66 or 63C
Air Nozzle: 63PB or 66P
Fluid Pressure: 10-15 psi
Air Atomizing Pressure: 60 psi
Note: Can be electrostatically sprayed.

Airless Spray | Apply using a piston pump having a flow rate of 3/4 GPM or higher, and able to deliver 2000-3000 psi.
Material Hose: 3/8" x 150' max
Tip Size: 0.011-0.015"
High Pressure Filter: 60 Mesh

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	35°F (2°C)	35°F (2°C)	35°F (2°C)	0%
Maximum	120°F (49°C)	120°F (49°C)	120°F (49°C)	95%

This product simply requires the substrate temperature to be above the dew point. 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. Proper airflow during curing process is critical.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat	Dry to Touch
35°F (2°C)	2 Hours	24 Hours	30 Minutes
50°F (10°C)	90 Minutes	16 Hours	20 Minutes
77°F (25°C)	1 Hour	8 Hours	15 Minutes
90°F (32°C)	45 Minutes	4 Hours	10 Minutes

Cure time based on 1.5-2.0 mils (37.5-50 microns) DFT.
Allow additional drying time at lower temperature or higher humidity.
Contact Carboline Tech Service if you have additional questions.

CLEANUP & SAFETY

Cleanup | Clean up all tools and equipment promptly with xylene, toluene, or VOC exempt solvent. Flush spray equipment with the same cleaning solvent.

Safety | Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life | 24 months

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

PACKAGING, HANDLING & STORAGE

Storage | Store Indoors.

Shipping Weight | 1 Gal Kit - 14 lbs (6.35 kgs)
(Approximate) | 5 Gal Kit - 68 lbs (30.85 kgs)

Flash Point (Setaflash) | 50°F (10°C) setaflash

WARRANTY

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