

SELECTION & SPECIFICATION DATA

Generic Type	High performance, rust inhibitive, epoxy primer
Designation	<p>This is a Carboline Specialty Product</p> <p>Minimum order quantities and special pricing will apply in North America. Contact your Carboline Sales Representative for more details.</p>
Description	One of the most durable primers known to industry. Excellent application properties are experienced over steel surfaces. This primer has excellent adhesion to steel and concrete also.
Features	<ul style="list-style-type: none"> • Two component heavy duty primer • Good prime coat for high performance paint systems • Durable primer under insulation • Contains high performance rust inhibitors
Typical Uses	This product is used as a base coating for high performance paint systems. It may be topcoated with Epoxies, Phenolics, Polyesters, Vinyl Esters and Polyurethanes. It is an excellent coating under insulated surfaces.
Color	Red (0500)
Finish	Flat
Dry Film Thickness	1 - 2 mils (25 - 51 microns) single coat
Solids Content	By Volume 43% +/- 2%
Theoretical Coverage Rate	<p>690 ft²/gal at 1.0 mils (16.9 m²/l at 25 microns)</p> <p>345 ft²/gal at 2.0 mils (8.5 m²/l at 50 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Values	As Supplied : 3.95 lbs/gal (473 g/l)
Dry Temp. Resistance	Continuous: 225°F (107°C)
Temperature Resistance (Immersion)	175°F (79°C)
Topcoats	<p>Thin mil lining systems applied over this product include, polyester, vinyl ester, epoxy phenolics, epoxies and polyurethanes. Thick mil lining systems applied over this product include 100% solids epoxy, polyesters, and vinyl esters.</p> <p>Note: Topcoat within 3 – 5 days @ 77°F (25°C) to be assured of good adhesion.</p>

SUBSTRATES & SURFACE PREPARATION

General	Non Immersion Service and/or Moderate Services: Commercial Sandblast (SSPC-SP6-63) (Sa2)
Galvanized Steel	Acid etch with TH 950 or Sandblast
Aluminum	Acid etch with TH 950 or Sandblast
Immersion Service	Immersion and/or Severe Service: White Metal Sandblast (SSPC-SP5-63) (Sa3)

American EX Series Primer

PRODUCT DATA SHEET



MIXING & THINNING

Mixing	Mix 4 parts resin (Part A) to 1 part catalyst (Part B) by volume. Allow material to stand 30 minutes before thinning.
Ratio	4:1 by volume
Pot Life	6-8 hours @ 77°F (25°C)

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.

General | Use Conventional Spray, Airless Spray, Brush, or Roller.

Conventional Spray	Spray Pot Dual Regulation Air Gauges for Pot Pressure and Atomization Pressure Air Supply (in): 100 psi Material Hose Diameter (ID): 1/2" (1.3 cm) Material Hose Length: 50' (15 m) Air Hose (ID): 5/16" (7.9 mm) Fluid Pressure: 10-25 psi Atomization Pressure: 50-75 psi Fluid Tip Orifice Size: 0.071" (1.8 mm)
	Pump Ratio: 30:1 Air Supply (in): 100 psi Hose Diameter (ID): 1/4" (0.64 cm) Hose Length: 100' (30.5 m) Tip Size: 0.013-0.019" (0.33-0.48 mm) Atomization Pressure: 2,200 psi
Airless Spray	

APPLICATION CONDITIONS

Condition	Ambient
Minimum	50°F (10°C)

Do not apply if temperature is below 50°F (10°C) and/or above 85% relative humidity.

CURING SCHEDULE

Surface Temp.	Maximum Recoat	Dry to Touch	Firm	Dry to Topcoat
77°F (25°C)	30 Days	2 Hours	5 Hours	7 Hours

Curing Details | Catalytic cure

CLEANUP & SAFETY

Cleanup	Use Thinner 2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
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CLEANUP & SAFETY

Safety	Keep away from heat, sparks or flame. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after application unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.
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WARNING! FLAMMABLE! HARMFUL IF INHALED. CAUSES IRRITATION

PACKAGING, HANDLING & STORAGE

Packaging	<p>One Gallon Kit Part A: 1 Gallon<nbr> Part B: 1 Quart</p> <p>Five Gallons Kit Part A: 5 Gallons<nbr> Part B: 1 Gallon</p> <p>UN No. 1263</p>
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Shelf Life	1 year
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Shipping Weight (Approximate)	<p>One Gallon Kit: Part A: 11.5 lbs (5.2 kg) Part B: 2 lbs (0.9 kg)</p> <p>Five Gallon Kit: Part A: 49 lbs (22.2 kg) Part B: 8.5 lbs (3.9 kg)</p>
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Flash Point (Setaflash)	<p>Part A: 69°F (20.5°C)</p> <p>Part B: 45°F (7vC)</p>
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