

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Phenolic modified alkyd
<b>Description</b>	Heavy-duty primer formulated to provide long term protection of structural steel. It provides excellent adhesion and can be welded through to yield sound welds.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Good for extended exposure demands</li> <li>• Ability to be welded through</li> <li>• Heavy-metal free</li> <li>• VOC compliant for most areas</li> </ul>
<b>Color</b>	Red (0500); Gray (0700)
<b>Finish</b>	Flat (0-10)
<b>Dry Film Thickness</b>	<p>51 - 76 microns (2 - 3 mils) per coat</p> <p>Don't exceed 3.0 mils (75 microns) in a single coat. Weldable areas should be limited to less than 1 mil in thickness.</p>
<b>Solids Content</b>	By Volume 52% +/- 2%
<b>Theoretical Coverage Rate</b>	<p>20.5 m<sup>2</sup>/l at 25 microns (834 ft<sup>2</sup>/gal at 1.0 mils)</p> <p>10.2 m<sup>2</sup>/l at 50 microns (417 ft<sup>2</sup>/gal at 2.0 mils)</p> <p>6.8 m<sup>2</sup>/l at 75 microns (278 ft<sup>2</sup>/gal at 3.0 mils)</p> <p>Allow for loss in mixing and application.</p>
<b>VOC Values</b>	<p><b>As Supplied</b> : 3.4 lbs./gal (407 g/l)</p> <p>Thinner 10 : 6 oz/gal: 3.7 lbs./gal (443 g/l)</p> <p>These are nominal values and may vary slightly with color.</p>
<b>Dry Temp. Resistance</b>	<p>Continuous: 93°C (200°F)</p> <p>Non-Continuous: 121°C (250°F)</p> <p>Discoloration and loss of gloss is observed above 200 °F (93 °C).</p>
<b>Topcoats</b>	May be coated with Acrylics, Epoxies, Alkyds, or Polyurethanes depending on exposure and need. Call for specific recommendations.

## 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>	SSPC-SP6 with a 1.0-2.0 mil (25-50 micron) surface profile for maximum protection. SSPC-SP2 or SP3 as minimum requirement.

## MIXING & THINNING

<b>Mixing</b>	Power mix until uniform in consistency.
<b>Thinning</b>	Normally not required but may thin as follows: Spray, brush or roller may be thinned up to 6 oz/gal (5%) with Thinner 10. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

# Carbocoat OEM Universal Primer

## PRODUCT DATA SHEET



### 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.

**Spray Application (General)** | The following spray equipment has been found suitable and is available from manufacturers.

**Conventional Spray** | Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.052" fluid tip and appropriate air cap.

**Airless Spray** | Pump Ratio: 30:1 (minimum)\*  
GPM Output: 3.0 (minimum)  
Material Hose: 3/8" I.D. (minimum)  
Tip Size: 0.013" - 0.017"  
Output PSI: 2000-2300  
Filter Size: 60 mesh  
\*PTFE packings are recommended and available from the pump manufacturer.

**Brush & Roller (General)** | Multiple coats may be required to achieve desired appearance, hiding and recommended dry film thickness. Avoid excessive rebrushing or rerolling.

**Brush** | Use a natural bristle brush.

**Roller** | Use a short-nap synthetic roller cover with phenolic core.

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	2°C (35°F)	2°C (35°F)	2°C (35°F)	0%
Maximum	49°C (120°F)	49°C (120°F)	49°C (120°F)	90%

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.

### CURING SCHEDULE

Surface Temp.	Dry to Touch	Tack Free	Dry to Topcoat w/ itself or other alkyds	Dry to Topcoat w/ epoxies or urethanes
2°C (35°F)	60 Minutes	4 Hours	4 Hours	8 Hours
13°C (55°F)	35 Minutes	60 Minutes	2 Hours	2 Hours
24°C (75°F)	10 Minutes	25 Minutes	30 Minutes	30 Minutes

These times are based on a 2.0 mil (50 microns) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times and could result in solvent entrapment or premature failure.

### CLEANUP & SAFETY

**Cleanup** | Use Thinner 2 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 SDS for this product. Employ normal workmanlike safety precautions. Keep container closed when not in use.

### CLEANUP & SAFETY

<b>Ventilation</b>	When used 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 respirator.
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### PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	24 months at 75 °F (24 °C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
<b>Shipping Weight (Approximate)</b>	1 Gallon - 13 lbs. (6 kg) 5 Gallon - 66 lbs. (30 kg) 50 Gallon - 660 lbs. (300 kg)
<b>Storage Temperature &amp; Humidity</b>	35-110 °F (2-43 °C) 0-100% Relative Humidity
<b>Flash Point (Setaflash)</b>	62 °F (17 °C)
<b>Storage</b>	Store Indoors.

### 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 to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. 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. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.