

Selection & Specification Data

Generic Type	Cycloaliphatic Amine Epoxy
Description	High solids corrosion resistant primer and intermediate. Used either as a primer or an intermediate coat over steel and inorganic zinc primers. Can be topcoated with a broad variety of high performance finish coats.
Features	<ul style="list-style-type: none"> • Excellent corrosion protection • Excellent film build and edge protection • Used as a primer or an intermediate coating • Good abrasion resistance • Cures down to 40°F • VOC compliant to current AIM regulations
Color	Red (0500); Gray (0700); White (0800); Yellow (0600)
Finish	Eggshell
Primer	Self-priming. May be applied over organic and inorganic zinc rich primers. A mist coat may be required to minimize bubbling over zinc rich primers.
Dry Film Thickness	3.0 mils (76 microns) per coat 4.0 - 6.0 mils (102 - 152 microns) per coat 3.0 mils for mild environments and as an intermediate coat over inorganic zincs. 4-6 mils for more severe environments. Do not exceed 10.0 mils (250 microns) 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	1235 ft ² at 1.0 mils (30.3 m ² /l at 25 microns) 412 ft ² at 3.0 mils (10.1 m ² /l at 75 microns) 206 ft ² at 6.0 mils (5.1 m ² /l at 150 microns)
VOC Values	Allow for loss in mixing and application. Thinner 2 16 oz/gal = 2.2 lbs/gal (261 g/l) Thinner 230 13 oz/gal = 2.1 lbs/gal (252 g/l) Thinner 33 32 oz/gal = 2.7 lbs/gal (329 g/l) As Supplied 1.6 lbs/gal (195 g/l) These are nominal values and may vary slightly with color. *Maximum thinning for 250 g/l restricted areas is 12 oz/gal with Thinner 2, and 11 oz/gal with Thinner 33 or 230. Use Thinner 76 where non-photochemically reactive solvents are required (up to 11 oz/gal)
Dry Temp. Resistance	Continuous: 200 °F (93 °C) Non-Continuous: 250 °F (121 °C) Discoloration and loss of gloss is observed above 200 F (93 C).
Limitations	Not recommended for immersion service
Topcoats	May be coated with Acrylics, Epoxies, Alkyds, or Polyurethanes depending on exposure and need.

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 with a 1.0-2.0 mil (25-50 micron) surface profile.

Substrates & Surface Preparation

Galvanized Steel	Prime with specific Carboline primers as recommended by your Carboline Sales Representative. Refer to the specific primer's Product Data Sheet for substrate preparation requirements.
Concrete or CMU	Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D42582 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.

Performance Data

Test Method	System	Results
ASTM B117 Salt Fog	Blasted Steel 1ct. IOZ 1 ct. 893	No blistering, rusting and no creepage at scribe after 4000 hours
ASTM D 1735 Water Fog	Blasted Steel 1ct. IOZ 1 ct. 893	No blistering softening or rusting after 5000 hours
ASTM D2583 Hardness	Blasted Steel 1 ct. 893	73, Barcol Test, 1 week cure, 5 mils DFT
ASTM D4060 Abrasion	Blasted Steel 1ct. 893	88 mg. loss after 1000 cycles, CS17 wheel, 1000 gm. load
ASTM G26 Weatherometer	Blasted Steel 1ct. IOZ 1 ct. 893	No blistering softening or rusting after 4000 hours

Test reports and additional data available upon written request.

Mixing & Thinning

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS. A 30-minute "sweat-in" time is highly recommended for applications below 50°F and will improve cure response.
Thinning	Spray: Up to 16 oz/gal (12%) w/ Thinner 2 or up to 13 oz/gal (10%) w/ Thinner 230 Brush: Up to 32 oz/gal (25%) w/ Thinner 33 Roller: Up to 32 oz/gal (25%) w/ Thinner 33 Mist coating: Thin up to 32 oz/gal with Thinner 2 or 33 in VOC restricted (2.8lb/gal) areas. May thin up to 48 oz/gal where VOC restricted levels are at 3.5 lb/gal for mist coat only. If necessary, use Thinner 230 only in hot (above 100°F/38°C) and windy conditions, to slow down the evaporation rate. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied. *See VOC values for thinning limits. Carboline Thinner 236E or 225E (up to 10% or 13 oz/gal) may also be used to thin this product to minimize HAP and VOC emissions. Consult Carboline Technical Service for guidance.
Ratio	1:1 Ratio (A to B)
Pot Life	4 Hours at 75°F (24°C) Pot life ends when coating loses body and begins to sag. Pot life times will be less at higher temperatures. Thinning rates above 16 oz/gal will shorten the working time to 2 hours.

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