

SELECTION & SPECIFICATION DATA

Generic Type	Long Oil Epoxy Ester
Description	Single-component maintenance primer used as a primer for Carbocoat 2901 and other alkyds. Formulated with a unique pigment system that inhibits corrosion through ion exchange technology. Fast dry characteristics well suited for the Power, Transmission/Distribution and Bridge markets.
Features	<ul style="list-style-type: none"> • Good corrosion protection and weatherability • Unique method of corrosion resistance • Excellent application properties • Single component • Pre-thinned; ready-to-apply • VOC-compliant for most areas
Color	Yellow (0600), Gray (0700), Red (0500)
Finish	Semi-Gloss
Dry Film Thickness	2 - 3 mils (51 - 76 microns) per coat Do not exceed 3.0 mils in a single coat.
Solids Content	By Volume 70% +/- 2%
Theoretical Coverage Rate	1123 ft ² /gal at 1.0 mils (27.6 m ² /l at 25 microns) 561 ft ² /gal at 2.0 mils (13.8 m ² /l at 50 microns) 374 ft ² /gal at 3.0 mils (9.2 m ² /l at 75 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 2.08 lbs/gal (249 g/l) Thinner 45 : 20 oz 2.7 lbs/gal (324 g/l) These are nominal values and may vary slightly with color.
Topcoats	May be coated with Alkyds depending on exposure and need. Also Carbocoat 2901

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-SP2 or SP3 normally acceptable.
Galvanized Steel	*Aged Galvanized - SSPC-SP1. Minimal surface preparation required. Areas of heavy pitting should be wire brushed.
Rusted Steel	SSPC-SP2 or SP3 normally acceptable. SSPC-SP6 or SP7 for steel with extensive deterioration.
Previously Painted Surfaces	Lightly sand or abrade to roughen and de-gloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

MIXING & THINNING

Mixing | Power mix until uniform in consistency.

Thinning | Normally not required. May be thinned up to 20 oz/gal (16%) with Thinner 45 where conditions dictate. Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

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" 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: 0.013-0.017"
Output PSI: 1800-2000
Filter Size: 60 mesh
*PTFE packings are recommended and available from the pump manufacturer.

Flow Coating | Consult Carboline Technical Service for recommendations.

Brush & Roller (General) | Multiple coats may be required to achieve desired appearance, hiding and recommended dry film thickness over rough surfaces. Avoid excessive re-brushing or re-rolling. This application may result in a streaky appearance due to orientation of the aluminum pigment. For the best aesthetic appearance, spray application is required.

Brush | Use a synthetic bristle brush.

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

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)	165°F (74°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 interferes with proper adhesion of the substrate.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry to Topcoat
75°F (24°C)	4 Hours	12 Hours	8 Hours

These times are based on a 2.0 mil (50 micron) 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. A **tack coat** followed by a full coat technique is required for best appearance and ease of application. Minimum time between coat and full coat is one minute to allow solvent to flash.

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. Use adequate ventilation and wear gloves or use protective cream on face and hands. Keep container closed when not in use.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. In confined areas workers must wear appropriate respiratory protection. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 75 °F (24 °C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	35-110 °F (2-43 °C) 0-90% Relative Humidity
Storage	Store indoors.
Shipping Weight (Approximate)	1 Gallon - 15 lbs (7 kg) 5 Gallons - 74 lbs (34 kg)
Flash Point (Setaflash)	96 °F (35 °C)

WARRANTY

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