



Selection & Specification Data

Generic Type	Waterborne Acrylic
Description	Water-based acrylic primer used to promote adhesion over galvanizing and other non-ferrous metal substrates. Unique formula is very low VOC and accepts two-component, solvent containing finishes like epoxies and urethanes.
Features	<ul style="list-style-type: none">▪ Single component▪ Low odor, low VOC▪ Contains no heavy metals or mineral acids▪ Extended recoat time▪ Accepts two-component finishes▪ Fast dry
Colors	Buff-yellow
Finish	Flat
Primers	Self-priming, typically used over galvanizing
Dry Film Thickness (as finish)	0.5-1.0 mils (12-25 microns)
Solids Content	By Volume: 31% ± 2%
Theoretical Coverage Rate	497 mil ft ² (12.1 m ² /l at 25 microns) Allow for loss in mixing and application.
VOC Values	As supplied: 0.29 lbs/gal (34 g/l) EPA Method 24: 0.82 lbs/gal (99 g/l) (Calculated minus water and exempt solvent.) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Slight discoloration and loss of gloss is observed above 200°F (93°C).

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-SP1
Galvanized Steel or Other Non-Ferrous Substrates	SSPC-SP1. When using thin film finishes (2-3 mils) like polyurethanes or acrylics, use Galoseal WB as a primer direct to substrate to promote adhesion. For high build finishes (4-6 mils or greater) like epoxies, it is recommended to clean, and then profile the surface by sanding, brush-blasting, or mechanically abrading the surface to provide a more suitable anchor pattern. Caution: Check for surface treatments such as chromates or silicates. If any treatment is present the surface must be aged 12 months or a brush blast must be performed to remove treatment to ensure adequate adhesion.

Galoseal WB

Application Equipment

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 Guidelines:

Spray Application (General) The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .043" 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: .013 - .015"
Output PSI: 1500 - 1800
Filter Size: 60 mesh
*Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) Normally for touch-up only. Avoid excessive re-brushing or re-rolling.

Brush Use a synthetic bristle brush.

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

Mixing & Thinning

Mixing Power mix until uniform in consistency. Avoid excessive air entrapment.

Thinning Not required. Material is ready to be applied as supplied. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Cleanup & Safety

Cleanup Use warm, soapy water. If material has dried or if equipment is to be used with solvent based coatings, use Thinner #2 or Acetone. Flush spray equipment with Thinner #2 or Acetone after cleanup. 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 MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	60°-90°F (16°-32°C)	65°-85°F (18°-29°C)	65°-90°F (18°-32°C)	10-85%
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	100°F (38°C)	130°F (54°C)	120°F (49°C)	85%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point. Water-based products are sensitive to moisture during cure. Protect from rain for 72 hours at 75°F (24°C). Do not apply if temperatures are expected to drop below 50°F (10°C) within 24 hours of application. 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. & 50% Relative Humidity	Dry to Touch	Dry to Topcoat
50°F (10°C)	1 hour	2 hours*
75°F (24°C)	30 minutes	1 hour
90°F (32°C)	15 minutes	30 minutes

These times are based on a 1.0 mil (25 micron) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times. Film must appear (feel) dry before topcoating.

High humidity, high film thickness, insufficient ventilation or cooler temperatures will lengthen the Dry to Touch and Dry to Topcoat times due to slower water evaporation rate. Waterborne acrylics are sensitive to moisture during early cure and are susceptible to handling damage.

* If the temperature is expected to drop near or below freezing within 2 hours after topcoating, allow Galoseal WB to cure for 6 hours before topcoating (or overnight).

Packaging, Handling & Storage

Shipping Weight (Approximate)

<u>1 Gallon</u>	<u>5 Gallons</u>
12 lbs (5 kg)	55 lbs (25 kg)

Flash Point (Setaflash) >200°F (93°C)

Storage (General) Store Indoors. **Keep from Freezing**

Storage Temperature & Humidity 40° -110°F (4°-43°C)
0-90% Relative Humidity

Shelf Life 12 months at 75°F (24°C)

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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