

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Single Component Phenolic Modified Alkyd
<b>Description</b>	Universal alkyd metal primer formulated with rust inhibitors to provide long term protection of structural steel. It provides excellent adhesion and can be welded through to yield sound welds. It can be topcoated with a variety of finishes such as polyurethanes, epoxies, alkyds, and acrylics.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Fast dry, rust inhibitive alkyd primer</li> <li>• High Solids, Low VOC (245 g/l)</li> <li>• Ability to be welded through</li> <li>• Can be topcoated with a wide variety of finishes</li> </ul>
<b>Color</b>	Red (0500); Gray (0700)
<b>Finish</b>	Flat
<b>Dry Film Thickness</b>	2 - 3 mils (51 - 76 microns) per coat Don't exceed 3.0 mils (75 microns) in a single coat. Welding is best achieved when thicknesses do not exceed 1 mil (25 microns).
<b>Solids Content</b>	By Volume 52% +/- 2%
<b>Theoretical Coverage Rate</b>	834 ft <sup>2</sup> /gal at 1.0 mils (20.5 m <sup>2</sup> /l at 25 microns) 417 ft <sup>2</sup> /gal at 2.0 mils (10.2 m <sup>2</sup> /l at 50 microns) 278 ft <sup>2</sup> /gal at 3.0 mils (6.8 m <sup>2</sup> /l at 75 microns) Allow for loss in mixing and application.
<b>VOC Value(s)</b>	Per EPA Method 24: 2.05 lbs/gal (245 g/l) 6 oz/gal of Thinner 236 E: 2.05 lbs/gal (245 g/l) 6 oz/gal of Thinner 255 E: 2.05 lbs/gal (245 g/l)  These are nominal values and may vary slightly with color. Product contains VOC-exempt dimethyl carbonate. Check local regulations regarding product usage.
<b>Dry Temp. Resistance</b>	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C)  Discoloration and loss of gloss is observed above 200 F (93 C).
<b>Topcoats</b>	Polyurethanes, Epoxies, Alkyds, and Acrylics

## 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.
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## MIXING & THINNING

<b>Thinning</b>	Normally not required but may thin as follows: Spray, brush or roller may be thinned up to 5 oz/ gal (5%) with Thinner #236E or Thinner #255E. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
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## 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:

**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 re-brushing or re-rolling.

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

**Roller** | Use a short-nap synthetic roller cover with a solvent resistant 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)	120°F (49°C)	120°F (49°C)	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/ Urethanes	Dry to Topcoat w/ Acrylics or Epoxies
35°F (2°C)	60 Minutes	4 Hours	12 Hours	12 Hours	36 Hours
55°F (13°C)	35 Minutes	90 Minutes	5 Hours	5 Hours	24 Hours
75°F (24°C)	10 Minutes	35 Minutes	30 Minutes	30 Minutes	16 Hours

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.

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## CLEANUP & SAFETY

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<b>Cleanup</b>	Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions.
<b>Ventilation</b>	When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured.
<b>Caution</b>	This product contains flammable solvents. Keep away from sparks and open flames.

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## PACKAGING, HANDLING & STORAGE

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<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>Storage Temperature &amp; Humidity</b>	35° - 100°F (2° - 43°C) 0-100% Relative Humidity
<b>Storage</b>	Store Indoors.
<b>Shipping Weight (Approximate)</b>	1 Gallon - 13 lbs. (6 kg) 5 Gallon - 66 lbs. (30 kg) 55 Gallon - 730 lbs. (331 kg)
<b>Flash Point (Setaflash)</b>	63°F (17°C)

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## WARRANTY

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