

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	A single package, low VOC, water reducible alkyd primer
<b>Designation</b>	<p><b>This is a Carboline Specialty Product</b></p> <p>Minimum order quantities and special pricing will apply in North America. Contact your Carboline Sales Representative for more details.</p>
<b>Description</b>	Railplex VOC W/R Primer is designed to provide good corrosion resistance and dry speed for railcar exterior, with wide flexibility to various top coats.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Single coat direct to metal high solids</li> <li>• Water reducible &amp; near VOC</li> <li>• Excellent adhesion</li> <li>• Good resistance to corrosion</li> <li>• Ready to use viscosity</li> </ul>
<b>Color</b>	Grey
<b>Finish</b>	Flat
<b>Dry Film Thickness</b>	2 - 4 mils (51 - 102 microns) per coat
<b>Solids Content</b>	By Volume 40% +/- 3%
<b>Theoretical Coverage Rate</b>	<p>642 ft<sup>2</sup>/gal at 1.0 mils (15.7 m<sup>2</sup>/l at 25 microns)</p> <p>321 ft<sup>2</sup>/gal at 2.0 mils (7.9 m<sup>2</sup>/l at 50 microns)</p> <p>160 ft<sup>2</sup>/gal at 4.0 mils (3.9 m<sup>2</sup>/l at 100 microns)</p> <p>Allow for loss in mixing and application.</p>
<b>VOC Values</b>	<p><b>As Supplied</b> : Per EPA Method 24: 0.09 lbs/gal (11 g/l)</p> <p>These are nominal values and may vary slightly with color.</p>

## SUBSTRATES & SURFACE PREPARATION

<b>Steel</b>	<p>Severe service applications – blasted to SSPC-SP-10 to a 1.5-2.5 mil angular profile</p> <p>Lesser service applications – blasted to SSPC-SP-6</p> <p>Surface to be free of all looser rust, dirt, grease and other contaminants.</p>
<b>Aluminum</b>	Remove all surface contaminants and treat with Strathmore's Wash Primer or equivalent.

## PERFORMANCE DATA

**All test data was generated under laboratory conditions. Field testing results may vary.**

Test Method	Results
Adhesion (ASTM D3359)	5B (no peeling or removal)
Flexibility (ASTM D522)	Passes 1/8" conical mandrel
Hardness (ASTM D3363)	2B
Impact Resistance (ASTM D2794)	Up to 40 lbs.in (Direct) and 40 lbs.in (Rev)
QUV Resistance (ASTM G154)	200 hrs- QUV UVA-340 Bulb

**Corrosion Resistance (ASTM B117):** 500 hrs at 3 mils DFT

## MIXING & THINNING

**Mixing** | Agitate thoroughly

**Thinning** | Not Recommended, consult Carboline for recommendations

## 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.

**General** | Designed to be applied direct to metal in a single or two coat application.

**Airless Spray** | 45:1  
Tip Size: 0.017-0.021" (0.43-0.53 mm)  
Pump Pressure: 2500-3500 psi (17-24 MPa)  
  
To minimize or eliminate thinner use in-line heated equipment with insulated hoses to reach application vis. Do not exceed 165°F (74°C).

## APPLICATION CONDITIONS

Condition
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Must be a minimum of 5°F (3°C) above the dew point during the surface preparation and coating application.

## CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Minimum Recoat Time	Dry Hard	Maximum Recoat Time
72°F (22°C)	30 Minutes	1 Hour	12 Hours	24 Hours	7 Days

**Force Cure** | If car is force dried, 1 hr minimum air dry @ 75°F (23°C) before oven. Then force dry @ 145°F (60vC) for 1 hour, adjusting for ambient maximum conditions

## CLEANUP & SAFETY

**Cleanup** | Water may be used for clean up.

**Safety** | Handle with care. Before and during use, observe all safety labels on packaging and paint containers and follow all caution statements on this product data sheet. Consult the Safety Data Sheet (SDS) for this product and follow all local or national safety regulations. Employ normal workmanlike safety precautions.

**Ventilation** | 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 ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

## PACKAGING, HANDLING & STORAGE

**Packaging** | 5 gallon pails  
55 gallon drums

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## PACKAGING, HANDLING & STORAGE

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<b>Shelf Life</b>	Six months from date of manufacturing when kept at recommended storage conditions at 70°F (21°C) and in original unopened containers.  Do not use material beyond shelf life.
<b>Storage Temperature &amp; Humidity</b>	Do not store at temperatures above 100°F (38°C).
<b>Storage</b>	Containers must be closed tightly. Do not store outside. Rotate stock.

## 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 Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. 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.