Carbocoat® 115 VOC

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Modified Alkyd Resin
Description	Carbocoat 115 VOC is a fast drying, low VOC industrial maintenance, lead and chromate free, shop and field primer. It is especially designed for architectural ferrous metal or exposed structural steel, and is best applied by spray only. Carbocoat 115 VOC can be top coated with acrylics, alkyds or single package polyurethane finishes. It is often used as a construction primer for structural steel that will eventually reside in interior spaces.
Features	• Fast Dry • VOC compliant to 340 g/l
Color	0700 Gray, 0500 Red Contact your Carboline Representative for availability.
Finish	Flat
Dry Film Thickness	1.5 - 2 mils (38 - 51 microns) per coat
Solids Content	By Volume 56% +/- 2%
Theoretical Coverage Rate	898 ft²/gal at 1.0 mils (22.0 m²/l at 25 microns) 599 ft²/gal at 1.5 mils (14.7 m²/l at 38 microns) 449 ft²/gal at 2.0 mils (11.0 m²/l at 50 microns) Allow for loss in mixing and application.
VOC Values	**As Supplied** : 2.8 lbs/gal (336 g/l)
Dry Temp. Resistance	Continuous: 180°F (82°C) Non-Continuous: 200°F (93°C)
Topcoats	May be coated with Acrylics or Alkyds depending on exposure and need. May be topcoated with other products, as recommended by Carboline Technical Service.

SUBSTRATES & SURFACE PREPARATION

Galvanized Steel	This product is NOT RECOMMENDED for galvanized steel. When using under fireproofing products, defer to the primer surface preparation requirements in the product data sheet of the fireproofing product
Special Instruction	**This primer should be applied the same day as cleaning to prevent re-rusting.** Spray is the preferred application method due to the quick drying nature of the product. Not recommended for prolonged exterior exposure. May discolor or chalk. Where color is used extensively, intermix cans of the same color.
Ferrous Metal	The surface should be thoroughly cleaned to remove dirt, grease, chalk and air pollution deposits, ideally by power washing. For aggressive environments, in order to obtain adhesion, a Commercial Blast (SSPC-SP6), or Near White Metal Blast (SSPC-SP10) is recommended. For noncorrosive environments, depending on the condition of the steel, the surface preparation shall be either SSPC-SP2 Hand Tool Cleaning, SSPC-SP3 Power Tool Cleaning, or SSPC-SP11 Power Tool Cleaning, or SSPC-SP6 Commercial Blast Cleaning. Follow the SSPC guidelines for removing mill scale, rust, loose paint, and other detrimental foreign matter.

MIXING & THINNING

Mixing	Power mix to a uniform consistency.
Thinning	Thinning is not necessary. Ready to airless spray.

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.

Conventional Spray	Binks #18 or #62 gun or equal cup or pressure pot Fluid Nozzle: 66 or 63C Air Nozzle: 63PB or 66P Fluid Pressure: 10-15 psi Air Atomizing Pressure: 60 psi **Note:** Can be electrostatically sprayed.
Airless Spray	Apply using a piston pump having a flow rate of 3.0 GPM or higher, and able to deliver 2000-3000 psi. Material Hose: 3/8" x 150’ max Tip Size: .011-.015" High Pressure Filter: 60 Mesh

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)	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 interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions. Proper airflow is critical for adequate cure.

CURING SCHEDULE

Surface Temp.	Dry Hard	Dry to Handle	Dry to Recoat	Dry to Touch
35°F (2°C)	24 Hours	2 Hours	24 Hours	30 Minutes
50°F (10°C)	8 Hours	90 Minutes	16 Hours	20 Minutes
77°F (25°C)	4 Hours	1 Hour	8 Hours	15 Minutes
90°F (32°C)	2 Hours	45 Minutes	4 Hours	10 Minutes

Dry to Recoat: after 8 hours for best adhesion.
Recoat intervals may vary from those listed above when using under intumescent fireproofing products. Consult Carboline Technical Service for recommended cure times before applying Carboline intumescent products.
Allow additional drying time at lower temperature or higher humidity.

CLEANUP & SAFETY

Cleanup	Clean up all tools and equipment promptly with xylene or toluene. Flush spray equipment with the same cleaning solvent to prevent rusting.
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 if hypersensitive. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months
Storage Temperature & Humidity	40° - 110°F (4°-43°C) 0-100% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	1 Gal Kit - 14 lbs 5 Gal Kit - 66 lbs
Flash Point (Setaflash)	50°F setaflash

WARRANTY

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