

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	One component Zinc Phosphate pigmented Alkyd Primer, air drying.
<b>Description</b>	Carbocoat 1310 Primer is a multipurpose primer with excellent adhesion to steel, iron and cast iron. The primer is fast drying and can be used for most industrial services in normal corrosive environment. Recommended for OEM and maintenance applications.
<b>Color</b>	Red, Grey and Black.
<b>Finish</b>	Flat
<b>Wet Film Thickness</b>	85-165 µm per coat, normally 125 µm.
<b>Dry Film Thickness</b>	35 - 70 microns (1.38 - 2.76 mils) per coat Normally 50 µm.
<b>Solid(s) Content</b>	By volume: 42 ± 2%
<b>Theoretical Coverage Rates</b>	8,4 m <sup>2</sup> /l at 50µm. Allow for loss in application.
<b>Dry Temp. Resistance</b>	Continuous: 60°C (140°F) Non-Continuous: 100°C (212°F)
<b>Topcoats</b>	May be topcoated with alkyd resin based paints or others as recommended by Carboline.
<b>Density</b>	1.25 g/cm <sup>3</sup> depending on colour.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Surface must be clean and dry. Employ adequate methods such as alkaline degreasing, phosphate process or Thinner #10, #17 or #41 to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
<b>Steel</b>	Blast cleaning to Sa 2½ (ISO 8501-1).

## MIXING & THINNING

<b>Mixing</b>	Power mix to uniform consistency.
<b>Thinning</b>	May be thinned up to 25 % with Thinner #10, #17 or Thinner #41.

## 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.

<b>General</b>	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .086" I.D. fluid tip and appropriate air cap.

# Carbocoat 1310 Primer

## PRODUCT DATA SHEET



### 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.

<b>Airless Spray</b>	Pump ratio: 30:1 (min.) * GMP Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .013-.017" Output PSI: 2000 Filter Size: 60 mesh
	* Teflon packings are recommended and available from the pump manufacturer.
<b>Brush &amp; Roller (General)</b>	For small areas and touch up.
<b>Brush</b>	Use a medium bristle brush.
<b>Roller</b>	Use a medium nap phenolic core roller.

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	2°C (36°F)	0%
Maximum	50°C (122°F)	50°C (122°F)	50°C (122°F)	85%

Industry standards are for substrate temperatures to be 3°C above the dew point. Special application techniques may be required above or below normal application conditions.

### CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Recoat	Dry to Handle
5°C (41°F)	30 Minutes	1 Hour	2 Hours
10°C (50°F)	15 Minutes	30 Minutes	1 Hour
20°C (68°F)	15 Minutes	30 Minutes	1 Hour
30°C (86°F)	10 Minutes	20 Minutes	1 Hour

These times are based on recommended DFT. Higher film thickness, insufficient ventilation or cooler temperatures will require longer drying times and could result in solvent entrapment and premature failure.

### CLEANUP & SAFETY

<b>Cleanup</b>	Use Thinner #41 or Thinner #10. 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 MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
<b>Ventilation</b>	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. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

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## CLEANUP & SAFETY

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**Caution** | This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

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## PACKAGING, HANDLING & STORAGE

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**Shelf Life** | 24 months at 24°C

**Storage Temperature & Humidity** | 4°-43°C  
0-95% Relative Humidity

**Storage** | Store indoors in dry and cool conditions

**Packaging** | Standard 10 and 20 litres, 200 litres drums and 1000 litres container.

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## WARRANTY

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