

SELECTION & SPECIFICATION DATA

Generic Type	Two-components amine cured epoxy.
Description	Carboguard E19 Sealer is a tie-coat specially designed for application on top of metalized steel and inorganic zinc silicate. To be used to avoid pore development in successive coat.
Features	Widely used within offshore- and shipping industries on top of metallized surfaces and zinc silicate where excellent corrosion resistance is expected.
Color	Red and Grey
Finish	Semi-Gloss
Wet Film Thickness	60 – 120 µm per coat.
Dry Film Thickness	25 - 50 microns (0.98 - 1.97 mils) per coat
Solid(s) Content	By volume: 42 ± 2%
Theoretical Coverage Rates	17 m ² at 25 µm DFT 8,4 m ² /l at 50 µm DFT Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 120°C (248°F) Non-Continuous: 140°C (284°F)
Limitations	Not recommended for immersion service in aromatic or ketone solvents and strong oxidizing acids.
Topcoats	May be top coated with epoxy, vinyl, acryl, polyurethane or other coatings as recommended by Carboline.

SUBSTRATES & SURFACE PREPARATION

General	Surface 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. Carboline Thinner #2 or Carboline Surface Cleaner #3 can be used. Substrates: Metallized steel and zinc silicate
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MIXING & THINNING

Mixing	Power mix separately, then add part B to Part A and power mix. DO NOT MIX PARTIAL KITS.
Thinning	The product is pre-thinned and should normally not be thinned any further. In case thinning is required, use Carboline Thinner #2.
Ratio	2 : 1 (A to B) by volume
Pot Life	4 hours at 23°C and higher at lower temperatures.

Carboguard E19 Sealer

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.

General	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Airless Spray	Pump ratio: 30:1 (min.) * GMP Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .014-.019" Output PSI: 2100 Filter Size: 60 mesh * Teflon packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Can be used for small areas.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	40°C (104°F)	50°C (122°F)	50°C (122°F)	85%

Industry standards are for substrate temperatures to be 3°C 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	Dry to Recoat	Final Cure
5°C (41°F)	5 Hours	24 Hours	16 Days
10°C (50°F)	2 Hours	18 Hours	14 Days
25°C (77°F)	1 Hour	6 Hours	7 Days
40°C (104°F)	30 Minutes	3 Hours	3 Days

The above times are based on 50µm DFT. Higher DFT, insufficient ventilation or lower ambient temperatures would cause longer curing times.

CLEANUP & SAFETY

Cleanup	Use Carboline Thinner #2. 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. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
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.

CLEANUP & SAFETY

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 applicable regulations. 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

Shelf Life	Part A: 24 months at 24°C Part B: 24 months at 24°C
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Storage	Store indoors.
Packaging	Part A 13,3 litres Part B 6,7 litres

WARRANTY

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