

SELECTION & SPECIFICATION DATA

Generic Type	Modified zinc phosphate silicone alkyd primer
Description	Modified anti-corrosive silicone primer for steel that may be exposed to temperatures up to 260°C. Extremely suitable for maintenance of chimneys, pipes, tanks, exterior of heat exchangers, etc. when optimal preparation of the substrate is not possible.
Features	• Single component • Temperature resistant up to 232°C continuously • Excellent flexibility • Good corrosion protection on blasted and St2/St3 pre-treated substrates • Suitable for both new construction and maintenance • Can be applied with a spray, roller or brush
Color	Oxide red (approximate RAL 3009)
Finish	Matte
Primer	Self-priming
Dry Film Thickness	50 microns per layer.
Solid(s) Content	By volume: 45% ± 2%
Theoretical Coverage Rates	9m ² /l at 50 microns. Take into account mixing and spraying losses.
VOC Values	As Supplied : 450 g/l These are average values and may vary slightly depending on the colour.
Dry Temp. Resistance	Continuous: 232°C (450°F) Non-Continuous: 260°C (500°F)

SUBSTRATES & SURFACE PREPARATION

General	The surface must be clean and dry. Use appropriate methods to remove all dirt, dust, oil and other contaminants that could prevent the coating from adhering properly.
Steel	Sa 2½ for maximum protection. Surface profile 30-40 microns. St2, St3 and Sa1 are also acceptable methods.

MIXING & THINNING

Mixing	Mix the product thoroughly. Avoid air mixing.
Thinning	Spraying: may be diluted up to 25% with Thinner 85. Brush and roller: may be diluted up to 10% with Thinner 85. The use of thinners other than those specified and supplied by Carboline may adversely affect the product and will invalidate the product warranty, regardless of whether this was done intentionally or accidentally.

Carbocoat HM 21

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.

Spray Application | The following spray equipment has been found to be suitable and is available from suppliers such as Binks, DeVilbiss, Graco, etc.

Conventional Spray | Pressure vessel with mixer equipped with dual control, 3/8" I.D. minimum material hose, .043" I.D. spray tip and appropriate air cap.

Airless Spray | Pump Ratio: 30:1 (min.)
GPM Output: 3.0 (min.)
Hoses: 3/8" I.D. (min.)
Tip size: .013-.017"
Pressure BAR: 125-140
Filter size: 60 mesh
Teflon gaskets are recommended and available from pump suppliers.

Brush & Roller (General) | Multiple coats may be required to achieve the required film thickness, coverage and desired appearance. Avoid repeated brushing and rolling.

Brush | Use a medium bristle brush.

Roller | Use a good quality roller that does not shed.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	2°C (36°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	49°C (120°F)	66°C (151°F)	49°C (120°F)	95%

This product requires the surface temperature to be 3°C above the dew point. Condensation on the surface due to surface temperatures below the dew point can cause flash rust on the blasted surface and will adversely affect adhesion. Special techniques may be required when working above or below the specified conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat
4°C (39°F)	48 Hours	60 Hours
10°C (50°F)	36 Hours	48 Hours
16°C (61°F)	30 Hours	30 Hours
24°C (75°F)	24 Hours	24 Hours
32°C (90°F)	24 Hours	24 Hours

These times are based on a dry film thickness of 50 microns and 50% relative humidity. Higher film thicknesses may result in entrapment of thinner and premature failure of the coating.

CLEANUP & SAFETY

Cleanup | Use Thinner 85. In case of spillage, absorb and clean up in accordance with local regulations.

CLEANUP & SAFETY

Safety	Carefully read and follow all safety rules listed on the product information sheet and safety data sheet. Use the safety equipment normally specified for this work. Hypersensitive persons should wear protective clothing and gloves and apply a protective cream to the face, hands and all other unprotected areas.
Ventilation	When used in confined spaces, a good ventilation system must be used during application and drying of the product. The ventilation system must be capable of preventing the evaporated thinner from reaching the lower explosion limit applicable to the thinner used. In addition to ventilation, personnel must use appropriate respiratory protection.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 24°C Shelf life: (actual shelf life stated) when stored under the recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	<u>20 Liters</u> 27 kg
Storage Temperature & Humidity	4°-43°C 0-90% relative humidity
Flash Point (Setaflash)	41°C
Storage	Store covered and frost-free.

WARRANTY

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