

SELECTION & SPECIFICATION DATA

Generic Type	Modified Alkyd Primer
Description	Fast drying steel primer that provides corrosion protection on structural steel. Well suited for fabrication shops that need fast cure to dry and handle times. May be overcoated with conventional alkyds or acrylics for color, aesthetics or additional protection.
Features	<ul style="list-style-type: none"> • One component product • Rapid cure • Lead and chromate free • Can be applied by Airless- and conventional spray, roller and brush • Ideal for the architectural market • Approved as a primer under certain Carboline fireproofing materials <p>For specific performance data, please contact your Carboline sales representative.</p>
Color	Light Grey
Finish	Matte
Primer	Self-priming
Dry Film Thickness	35 - 60 microns per coat
Solids Content	By Volume 51% +/- 2%
Theoretical Coverage Rate	20.1 m ² /l at 25 microns (818 ft ² /gal at 1.0 mils) Allow for loss in mixing and application.
VOC Values	As Supplied : 430 g/l These are nominal values.
Dry Temp. Resistance	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F)
Topcoats	Acrylics or Alkyds

SUBSTRATES & SURFACE PREPARATION

General	Surfaces 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.
Steel	ISO 8501-1, Sa 2 with a 25-50 micron (1.0-2.0 mil) surface profile for maximum protection. ISO 8501-1 St2 or St3 as minimum requirement.

MIXING & THINNING

Mixing	Mix carefully until an even consistency is achieved. Avoid excessive air admixture.
Thinning	<p>Spray: may be thinned up to maximum 20% with Thinner 10.</p> <p>Brush and Roller: may be thinned up to maximum 5% with Thinner 25.</p> <p>Use of thinners other than those supplied or recommended by Carboline adversely affect product performance and void product warranty, whether expressed or implied.</p>

Carbocoat 1421 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.

Spray Application (General) | The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Conventional Spray | Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.052" I.D. fluid tip and appropriate air cap.

Airless Spray | Pump Ratio: 30:1 (min.)*
GPM Output: 3.0 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: 0.013-0.017"
Output BAR: 140-162
Filter Size: 60 mesh
*PTFE packings are recommended and available from the pump manufacturer.

Brush & Roller (General) | Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding.

Brush | Use a medium bristle brush.

Roller | Use a good quality roller with phenolic core.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	4°C (39°F)	2°C (36°F)	0%
Maximum	49°C (120°F)	49°C (120°F)	49°C (120°F)	95%

Substrate temperatures should be 3°C above the dew point. This product is moisture sensitive in the liquid stage and until fully cured. Protect from high humidity, dew and direct moisture contact until fully cured. Application and/or curing in humidity above maximum, or exposure to moisture from rain or dew may result in a loss of gloss.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry to Recoat
4°C (39°F)	NR	NR	NR
16°C (61°F)	NR	NR	NR
25°C (77°F)	30 Minutes	60 Minutes	60 Minutes

These times are based on a 50 microns dry film thickness and 50% relative humidity. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times and could result in solvent entrapment or premature failure.

CLEANUP & SAFETY

Cleanup | Use Thinner 10 or Thinner. 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.

CLEANUP & SAFETY

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 insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.
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, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 75 °F (24 °C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	<u>20 Liter</u> 29 Kg
Storage Temperature & Humidity	41-104°F (5-40°C) 0-90% Relative Humidity
Flash Point (Setaflash)	10°C
Storage	Store Indoors.

WARRANTY

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