

SELECTION & SPECIFICATION DATA

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| Generic Type | Single package vinyl copolymer |
| Description | Carboclad 938 Primer is a medium build corrosion resistant primer which is easy to apply, fast drying and has good weathering properties. |
| Features | <ul style="list-style-type: none"> • Intended as a shop or maintenance primer for the Carboclad 938 system, over clean steel or tightly adhering old coatings • Good flexibility • Very good weathering • Good abrasion resistance • May be applied over aged alkyds, vinyls and acrylics (a test patch is recommended to check adhesion of Carboclad 938 Primer over other coatings) • Not recommended for solvent exposure or immersion service |
| Color | Red Oxide |
| Finish | Flat |
| Dry Film Thickness | 75 Microns |
| Solid(s) Content | By Volume 37% ± 2% |
| Theoretical Coverage Rates | 4.9m ² /litre at 75 microns NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements. |
| Dry Temp. Resistance | Continuous: 50°C (122°F) Non-Continuous: 66°C (151°F) |
| Topcoats | May be topcoated with vinyls, acrylics or others as recommended. |

SUBSTRATES & SURFACE PREPARATION

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| General | Remove all oil or grease from the surface to be coated prior to abrasive blast, power or hand tool. |
| Steel | UNCOATED. Preferred: Abrasive blast cleaning to ISO 8501 Sa2½ to obtain a 25 to 50 micron blast profile. Acceptable: Wire brush to ISO 8501 St3 for less severe exposure. For application over intact existing coating, the surface must be clean, dry and free of any contaminants. Loose edges should be feathered into sound coating and spot primed. |

MIXING & THINNING

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| Mixing | Power mix to a smooth consistency before thinning. |
| Thinning | Thin up to 15% by volume with Thinner # 10. NOTE: The use of thinners other than those supplied or approved by StonCor Africa may adversely affect the product performance and void product warranty, whether express or implied. |

Carboclad 938 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** | Use sufficient air volume for correct operation of equipment.
Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

- Conventional Spray** | Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface.
Gun:905 Spray Gun
Fluid Tip:1.8mm
Air Cap:905-PV

- Airless Spray** | Use a 10mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface.
Gun:TRITECH T360 Spray Gun
Pump:47:1

* Teflon packings are recommended and are available from pump manufacturer.
Use a .017" to .021" tip with 2000 psi (138 bar)

- Brush** | Use natural bristle brush, applying with full strokes. Avoid rebrushing.

- Roller** | Not recommended for application by roller.

APPLICATION CONDITIONS

| Condition | Material | Surface | Ambient | Humidity |
|-----------|--------------|--------------|--------------|----------|
| Minimum | 4°C (39°F) | 4°C (39°F) | 4°C (39°F) | 0% |
| Maximum | 38°C (100°F) | 43°C (109°F) | 43°C (109°F) | 95% |
| Optimum | 24°C (75°F) | 24°C (75°F) | 20°C (68°F) | 45% |

Do not apply when the surface temperature is less than 3°C above the dew point.
Special thinning and application techniques may be required above or below normal conditions.

CURING SCHEDULE

| Surface Temp. | Dry to Handle | Dry to Topcoat |
|---------------|---------------|----------------|
| 4°C (39°F) | 4 Hours | 24 Hours |
| 10°C (50°F) | 3 Hours | 16 Hours |
| 16°C (61°F) | 2 Hours | 8 Hours |
| 25°C (77°F) | 1 Hour | 4 Hours |

Curing Details | Relative Humidity: 50%

CLEANUP & SAFETY

- Cleanup** | Use Thinner # 2

- Safety** | Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product. Employ normal workmanlike safety precautions.

CLEANUP & SAFETY

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| Ventilation | When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. |
| Caution | This product contains flammable solvents. Keep away from sparks and open flames. |

PACKAGING, HANDLING & STORAGE

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| Shelf Life | 24 Months minimum when stored at 25°C *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. |
| Shipping Weight (Approximate) | 5 Litre: Carboclad 938 Primer: 6.9kg Thinner # 10: 4.9kg |
| Storage Temperature & Humidity | 4 to 43°C 0 to 100% Store indoors |
| Flash Point (Pensky Martens Closed Cup) | Carboclad 938 Primer: 23°C Thinner # 10: 24°C |

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.