

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Single package fast drying modified alkyd zinc phosphate primer.
<b>Description</b>	An economical primer for protection of steel surfaces. Has desirable characteristics for shop application. Easy to apply by spray, fast drying with good wetting properties. Good resistance to atmospheric weathering. Most alkyd topcoats can be applied over Carbocoat GP-55 Primer FD.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Recommended as a shop primer with appropriate topcoat for use on structural steel, equipment and other ferrous surfaces in mild industrial and architectural environments</li> <li>• Good flexibility</li> <li>• Good weathering (chalks)</li> <li>• Good abrasion resistance</li> <li>• Apply direct to steel substrates</li> <li>• Not recommended for immersion service, exposure to acids, alkalis or strong solvents</li> </ul>
<b>Color</b>	Red & Grey
<b>Finish</b>	Flat
<b>Dry Film Thickness</b>	75 Microns
<b>Solid(s) Content</b>	By Volume 55% ± 2%
<b>Theoretical Coverage Rates</b>	7.3m <sup>2</sup> /litre at 75 microns NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
<b>Dry Temp. Resistance</b>	Continuous: 85°C (185°F) Non-Continuous: 110°C (230°F)  NON-IMMERSION
<b>Topcoats</b>	Should be topcoated with alkyds, silicone-alkyds, oil based or others as recommended. Do not topcoat directly with coatings containing strong solvents such as epoxies and vinyls.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Remove any oil or grease from surface to be coated prior to application.
<b>Steel</b>	For enhanced protection, dry abrasive blast to near white metal in accordance with ISO 8501 Sa2½ to obtain a profile less than 40 microns. Minimum surface preparation is hand tool clean in accordance with ISO 8501 St2.

## MIXING & THINNING

<b>Mixing</b>	Mix to a uniform consistency before thinning.
<b>Thinning</b>	Thin up to 20% by volume with Thinner # 10. NOTE: Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether expressed or implied.

# Carbocoat GP-55 Primer FD

## 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>Spray Application</b>	Use adequate air volume for correct operation. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.
<b>Conventional Spray</b>	Use a 10mm minimum I.D. material hose. Hold gun 200 to 250mm from the surface and at a right angle to the surface. <b>Gun:</b> 905 Spray Gun <b>Fluid Tip:</b> 1.8mm <b>Air Cap:</b> 905-PV
<b>Airless Spray</b>	Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface. <b>Gun:</b> TRITECH T360 Spray Gun <b>Pump:</b> 47:1  Use a .015" to .017" tip and 1800 to 2000 psi (122 to 138 bar) * Teflon packings are recommended and available from the pump manufacturer.
<b>Brush &amp; Roller (General)</b>	For small areas or touch-up only. Use a natural bristle brush, applying with full strokes. Avoid rebrushing. Use short nap mohair roller with phenolic core.

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	49°C (120°F)	60°C (140°F)	49°C (120°F)	95%
Optimum	21°C (70°F)	21°C (70°F)	25°C (77°F)	55%

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 or Recoat
10°C (50°F)	12 Hours
16°C (61°F)	8 Hours
24°C (75°F)	4 Hours
32°C (90°F)	2 Hours

**Curing Details** | **Relative Humidity: 50%**  
Drying times at 75 microns D.F.T.

### CLEANUP & SAFETY

<b>Cleanup</b>	Use Thinner # 2.
<b>Safety</b>	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**

- 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**

- 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:  
Carbocoat GP-55: 7.5kg  
Thinner # 10: 4.9kg  
20 Litre:  
Carbocoat GP-55: 30kg
- Storage Temperature & Humidity** | 2 to 43°C  
0 to 100%  
Store indoors
- Flash Point (Pensky Martens Closed Cup)** | Carbocoat GP-55: 19°C  
Thinner # 10: 23°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.