Carboguard E-19

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy polyamide
Description	A general purpose corrosion resistant primer/intermediate coating containing zinc phosphate pigment. Used either as a primer or an intermediate coat over steel and inorganic zinc primers. Recommended as a blast primer on steel that needs temporary protection. Performs extremely well under a wide variety of topcoats.
Features	• Excellent corrosion protection • Excellent film build and edge protection • Used as primer or an intermediate • One year recoat window
Color	Red (0500); Grey (0700)
Finish	Flat
Primer	May be applied over organic and Inorganic zinc rich primers. A mist coat may be required to minimize bubbling over zinc rich primers.
Dry Film Thickness	51 microns (2 mils) as holding primer 76 microns (3 mils) for mild environments and as an intermediate coat over inorganic zincs 102 - 152 microns (4 - 6 mils) for more severe environments
Solids Content	By Volume 52% +/- 2%
Theoretical Coverage Rate	20.5 m²/l at 25 microns (834 ft²/gal at 1.0 mils) 10.2 m²/l at 50 microns (417 ft²/gal at 2.0 mils) 3.4 m²/l at 150 microns (139 ft²/gal at 6.0 mils) Allow for loss in mixing and application.
VOC Value(s)	As supplied: 3.0 lbs/gal (362 g/l) This is a nominal value and may vary slightly with color.
Dry Temp. Resistance	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F) Discoloration and loss of gloss is observed above 200°F (93°C).
Limitations	Not recommended for immersion service without topcoat.
Topcoats	Acrylics, Alkyds, Epoxies, Polyurethanes

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	SSPC–SP6 with a 1.0-2.0 mils (25-50 microns) surface profile
Concrete	Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix
Thinning	Spray: Up to 13 oz/gal (10%) with Thinner/ #2 Brush: Up to 19 oz/gal (15%) with Thinner/ #2 Roller: Up to 19 oz/gal (10%) with Thinner/ #2 Use of thinner other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	2:1 Ratio (A to B)
Pot Life	12 Hour at 75°F (24°C) Pot life ends when coating loses body and begins to sag. Pot life time will be less at higher temperatures.

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	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. 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, .070" 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 : .017-.021" Output PSI : 2100-2300 Filter Size : 60 mesh Teflon 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. Avoid excessive rebrushing or rerolling. For best results, tie in within 10 minutes at 75°F (24°C).
Brush	Use a medium bristle brush or a short-nap synthetic roller cover with phenolic core
Roller	Use a short-nap synthetic roller cover with phenolic core

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	13°C (55°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	32°C (90°F)	57°C (135°F)	43°C (109°F)	85%

This product simply requires the substrate temperature to be 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.	Final Cure	Between Coats
10°C (50°F)	12 Days	20 Hours
16°C (61°F)	6 Days	12 Hours
24°C (75°F)	3 Days	5 Hours
32°C (90°F)	2 Days	3 Hours

***50% Relative Humidity**
These times are based on a 4.0 mils (100 microns) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperature will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. During high humidity conditions, it is recommended that the application be done while temperatures are increasing. If the maximum recoat time has been exceeded, the surface must be abraded by sweep blasting or sanding before the application of additional coats.

CLEANUP & SAFETY

Cleanup	Use Thinner #2 or Acetone. 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 and product is thinned through air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapour concentration from reaching the lower explosion limit for the solvents used. Users 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 supplied air respirator.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen 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)	**5.7-Liter Kit** 9 Kg **28.5-Liter Kit** 43 Kg
Storage Temperature & Humidity	Storage Temperature: 40° - 110°F (4°- 43°C) Relative Humidity: 0 - 90%
Flash Point (Setaflash)	Part A: 46°F (8°C) Part B: 60°F (16°C)
Storage	Store indoors

WARRANTY

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