

SELECTION & SPECIFICATION DATA

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| Generic Type | Two-components epoxy polyamide primer containing zinc phosphate. |
| Description | Carboguard E 19 Primer is a versatile epoxy primer with excellent resistance to salts, water and alkalies. Very good resistance to mild acids and solvents. |
| Features | <ul style="list-style-type: none"> • Excellent corrosion resistance • Cured film is tough and abrasion resistant • Used 40% diluted as a tie-coat over zinc silicate and metallized steel • Excellent adhesion to aluminium • Widely used within petrochemical-, offshore and shipping industries |
| Color | Red and Grey |
| Finish | Flat |
| Primer | Self-priming |
| Wet Film Thickness | 60 – 400 µm per coat, normally 150 µm. |
| Dry Film Thickness | 30 - 200 microns (1.18 - 7.87 mils) per coat Normally 75 µm. |
| Solid(s) Content | By volume: 50 ± 2% |
| Theoretical Coverage Rates | 5,0 m²/l at 100 µm Allow for loss in mixing and application. |
| Dry Temp. Resistance | Continuous: 120°C (248°F) Non-Continuous: 150°C (302°F) |
| Limitations | Not recommended for immersion service in strong acids or exposures in areas where chalking is undesirable |
| Topcoats | May be topcoated with epoxy, vinyl, polyurethane or other coatings as recommended by Carboline. |

SUBSTRATES & SURFACE PREPARATION

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| General | Surface 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 | Abrasive blasting to min. Sa 2½ (ISO 8501-1). Alternatively, ultra high pressure water jetting to Nace No. 7 min. C Vis WJ-2. Max flash rust; C Vis WJ-2M. |
| Concrete | Concrete must be cured at least 28 days at 24°C and 50% relative humidity or equivalent. Prepare surfaces in accordance with with ASTM D42582 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing. |

MIXING & THINNING

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| Mixing | Power mix separately, then add part B to Part A and power mix. DO NOT MIX PARTIAL KITS. |
| Thinning | May be thinned up to 40% with Carboline Thinner #15. |

Carboguard E 19 Primer

PRODUCT DATA SHEET



MIXING & THINNING

Ratio | 2 : 1 (A to B) by volume

Pot Life | 6 hours at 23°C and higher at lower 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.

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

Airless Spray | Pump ratio: 30:1 (min.) *
GMP Output: 3.0 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .015-.021"
Output PSI: 2000
Filter Size: 60 mesh

* Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) | For small areas and stripe coating. Multiple coats may be required to obtain desired appearance, and recommended dry film thickness.

Brush | Use a medium bristle brush.

Roller | Use a medium nap phenolic core roller.

APPLICATION CONDITIONS

| Condition | Material | Surface | Ambient | Humidity |
|-----------|--------------|--------------|--------------|----------|
| Minimum | 5°C (41°F) | 5°C (41°F) | 5°C (41°F) | 0% |
| Maximum | 40°C (104°F) | 50°C (122°F) | 50°C (122°F) | 85% |

Industry standards are for substrate temperatures to be 3°C 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. | Dry to Touch | Dry to Recoat | Final Cure |
|---------------|--------------|---------------|------------|
| 5°C (41°F) | 4 Hours | 20 Hours | 21 Days |
| 15°C (59°F) | 2 Hours | 15 Hours | 14 Days |
| 25°C (77°F) | 1 Hour | 5 Hours | 10 Days |

These times are based on 75 µm DFT. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

CLEANUP & SAFETY

Cleanup | Use Carboline Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

CLEANUP & SAFETY

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| 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, 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. |
| 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 applicable regulations. 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

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| Shelf Life | Part A: 24 months at 24°C Part B: 36 months at 24°C |
| Storage Temperature & Humidity | 5° - 45°C 0 - 95% relative humidity |
| Storage | Store indoors. |
| Packaging | Part A 13,3 litres Part B 6,7 litres |

WARRANTY

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