

## Selection & Specification Data

<b>Generic Type</b>	Modified Alkyd Primer
<b>Description</b>	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 topcoated with conventional alkyds or acrylics for color, aesthetics or additional protection.
<b>Features</b>	<ul style="list-style-type: none"> <li>▪ Rapid cure</li> <li>▪ VOC compliant for most areas</li> <li>▪ Good for filling properties on rough and pitted steel</li> </ul>
<b>Color</b>	Red / Brown (0500), Gray (0700), White (0800)
<b>Finish</b>	Flat
<b>Topcoats</b>	Acrylics, Alkyds
<b>Dry Film Thickness</b>	1.5-2.0 mils (37-50 microns) per coat. Don't exceed 3.0 mils in a single coat.
<b>Solids Content</b>	By Volume: 51% ± 2%
<b>Theoretical Coverage Rate</b>	721 mil ft <sup>2</sup> (18 m <sup>2</sup> /l at 25 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	As supplied: 3.50 lbs./gal (419 g/l) Thinned 6 oz/gal w/ Thinner #10 : 3.65 lbs./gal (437 g/l) These are nominal values and may vary slightly with color.
<b>Dry Temp. Resistance</b>	Continuous: 200°F (93°C) Non-Continuous: 250°F (121°C) Discoloration and loss of gloss is observed above 200°F (93°C).

## Substrates & Surface Preparation

<b>General</b>	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.
<b>Steel</b>	SSPC-SP6 with a 1.0-2.0 mil (25-50 microns) surface profile for maximum protection. SSPC-SP2 or SP3 as minimum requirement.

## Application Equipment

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 Guidelines:

<b>Spray Application (General)</b>	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .052" I.D. fluid tip and appropriate air cap.
<b>Airless Spray</b>	Pump Ratio: 30:1 (minimum)* GPM Output: 3.0 (minimum) Material Hose: 3/8" I.D. (minimum) Tip Size: .013-.017" Output PSI: 1800-2000 Filter Size: 60 mesh *Teflon packings are recommended and available from the pump manufacturer.
<b>Brush &amp; Roller (General)</b>	For small areas and touch-up only. Avoid excessive rebrushing or rerolling.
<b>Brush</b>	Use a synthetic bristle brush.
<b>Roller</b>	Use a short-nap natural roller cover with phenolic core.

# Carbocoat® 115

## Mixing & Thinning

**Mixing** Power mix until uniform in consistency.

**Thinning** May be thinned up to 6 oz/gal (5%) with Thinner #10. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

## 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. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

**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, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	50°-90°F (10°-32°C)	55°-90°F (13°-32°C)	55°-100°F (13°-38°C)	30-90%
Minimum	35°F (2°C)	35°F (2°C)	35°F (2°C)	0%
Maximum	120°F (49°C)	120°F (49°C)	120°F (49°C)	95%

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. & 50% Relative Humidity	Dry to Touch	Dry to Handle	Dry to Topcoat*
35°F (2°C)	30 Minutes	2 Hours	4 Hours
60°F (16°C)	20 Minutes	60 Minutes	3 Hours
75°F (24°C)	10 Minutes	30 minutes	2 Hours

These times are based on a 1.5 mil (35 microns) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times and could result in solvent entrapment or premature failure.

\*Dry to topcoat with itself other alkyds.

## Packaging, Handling & Storage

<b>Shipping Weight (Approximate)</b>	<u>5 Gallon Kit</u>	<u>55 Gallon Kit</u>
	65 lbs. (29.5 kg)	675 lbs. (307 kg)

**Flash Point (Setaflash)** 83°F

**Storage Temperature & Humidity** 40° - 110°F (4° - 43°C) Store indoors.  
0-90% Relative Humidity

**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.



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