

Selection & Specification Data

Generic Type	Two-components, low temperature curing epoxy polyamide primer.
Description	Carboguard E 19 LT 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 • Fast drying at low temperatures • 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
Primers	Self-priming
Topcoats	May be topcoated with epoxy, vinyl, polyurethane or other coatings as recommended by Carboline.
Dry Film Thickness	30 - 200 µm per coat, normally 75 µm.
Wet Film Thickness	120 - 400 µm per coat, normally 150 µm.
Solids Content	By volume: 50 ± 2%
Theoretical Coverage Rate	5,0 m ² /l at 100µm Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 120°C Non-continuous: 150°C
Limitations	Not recommended for immersion service in strong acids or exposures in areas where chalking is undesirable.

Substrates & Surface Preparation

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.

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.

Spray Application (General)	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.												
Airless Spray	<table border="0"> <tr> <td>Pump ratio:</td> <td>30:1 (min.) *</td> </tr> <tr> <td>GMP Output:</td> <td>3.0 (min.)</td> </tr> <tr> <td>Material Hose:</td> <td>3/8" I.D. (min.)</td> </tr> <tr> <td>Tip Size:</td> <td>.015-.021"</td> </tr> <tr> <td>Output PSI:</td> <td>2000</td> </tr> <tr> <td>Filter Size:</td> <td>60 mesh</td> </tr> </table> <p>* Teflon packings are recommended and available from the pump manufacturer.</p>	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
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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.												

May 2009 replaces October 2008

Mixing & Thinning

Mixing	Power mix separately, then add part B to Part A and power mix. DO NOT MIX PARTIAL KITS.
Ratio	2 : 1 (A to B) by volume
Thinning	May be thinned up to 40% with Carboline Thinner #15.
Pot Life	2 hours at 20°C and higher at lower temperatures.

Cleanup & Safety

Cleanup	Use Carboline 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, 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.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	15-30°C	15-30°C	15-30°C	35-80%
Minimum	5°C	2°C	2°C	0%
Maximum	40°C	50°C	50°C	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. & 50% Relative Humidity	Dry to Recoat	Final Cure
2°C	10 Hours	21 Days
5°C	8 Hours	18 Days
10°C	4 Hours	12 Days
15°C	3 Hours	10 Days
25°C	1½ Hours	8 Days
30°C	1 Hour	5 Days

Packaging, Handling & Storage

Kit Standard	Part A 13,3 litres Part B 6,7 litres
Storage (General)	Store indoors
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Shelf Life	24 months at 24°C

Note

This product shall only be used as a single-coat or in a system with other recommended Carboline products. Otherwise an approval shall be issued by Carboline.

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