

Selection & Specification Data

Generic Type	Two - component Epoxy Polyamide Primer
Description	SC Epoxy Primer is an excellent general purpose corrosion primer with good resistance to salts, water and alkalies. Also resistant to splash and spillage from mild acids and solvents. The cured film is tough and abrasion resistant.
Features	<ul style="list-style-type: none"> • Versatile general purpose epoxy primer. • Excellent for use as a "holding primer". • Good resistance to salts, water and alkalies. • Can be used as a "tie-coat" over zinc silicate, metallized steel and aluminium. Thin 40% for "tie-coat" application. • Widely used within the petrochemical, offshore and shipping industries. • Very good abrasion resistance.
Color	Red and Grey
Finish	Flat
Topcoats	May be topcoated with epoxy, vinyl, acrylic, polyurethane and other coatings as recommended by Carboline.
Dry Film Thickness	30 - 200 microns, standard 100 microns.
Wet Film Thickness	60 - 400 microns, standard 200 microns.
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 aromatic or ketone solvents and strong oxidizing acids. Epoxies discolour and eventually chalk in sunlight exposure.

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 blast to min. ISO 8501-1 Sa 2½ with a 50 – 75 microns surface profile. Alternatively ultra high pressure water jetting to the standard of min. CHB2 M.
Concrete	Normally applied over clean, dry concrete. Concrete must be cured at least 28 days at 20°C at 50% Rh or equivalent time.

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.												
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .086" I.D. fluid tip and appropriate air cap.												
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, recommended dry film thickness and adequate hiding.												
Brush	Use a medium bristle brush.												
Roller	Use a medium nap phenolic core roller.												

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)
Thinning	May be thinned up to 40% with Carboline Thinner #15.
Pot Life	6 Hours at 23°C and longer 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. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.
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	15-30°C	15-30°C	15-30°C	35-80%
Minimum	5°C	5°C	5°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 Touch	Recoating Min.	Recoating Max.
5°C	4 Hours	20 Hours	N.A.
15°C	2 Hours	15 Hours	N.A.
25°C	1 Hour	5 Hours	N.A.
30°C	20 Min.	3 Hours	N.A.

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

Packaging, Handling & Storage

Kit Standard	Part A 13,3 litres Part B 6,7 litres
Storage (General)	Store indoors
Storage Temperature & Humidity	4°-43°C 0-95% Relative Humidity
Shelf Life	Maximum 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.



CARBOLINE NORGE AS
P.O Box 540, 3412 Lierstranda
Tel. +47 32 85 74 00 Fax +47 32 85 74 96

An RPM Company

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