

Selection & Specification Data

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| Generic Type | Water-based vinyl copolymer |
| Description | Single package primer, resistant to spillage of mild acids and alkalies, aliphatic solvents, etc., with suitable topcoat. Easy to apply by brush, roller or spray. |
| Features | <ul style="list-style-type: none"> - Primer for blasted or hand-cleaned steel - Good flexibility - Very good weathering - Fair abrasion resistance - Can be applied over certain tightly adherent aged coatings - Accepts most generic topcoats - Not recommended for immersion service, aromatic or ketone solvent exposure or where welding will take place |
| Colour | Red only |
| Finish | Matt |
| Topcoat | May be topcoated with most generic types. Consult StonCor Africa for specific recommendations. |
| Compatibility with Other Coatings * | <p>May be applied over certain tightly adherent aged coatings. Accepts most generic topcoats.</p> <p>* NOTE: A test patch is recommended to assure adhesion of Carboclad 900 over other coatings or the adhesion of topcoats to Carboclad 900.</p> |
| Dry Film Thickness | 40 Microns |
| Solids Content | By Volume 43% ± 2% |
| Theoretical Coverage Rate | 10.8m ² /litre at 40 microns |
| | NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements. |
| VOC Values | As supplied 22 g/litre |
| Temp Resistance | Continuous 70°C Non-continuous 93°C |

Substrates & Surface Preparation

| | |
|----------------|---|
| General | Remove any oil or grease from surface to be coated prior to abrasive blast, power or hand tool cleaning. |
| Steel | For severe exposure, abrasive blast clean to a near white metal finish in accordance with ISO 8501 Sa2½ to obtain a 40 micron maximum blast profile. For mild exposure, power or hand tool clean in accordance with ISO 8501 St3 or St2 respectively. |

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Application Equipment

Spray Use adequate air volume for correct application.
Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

NOTE: The following equipment has been found suitable, however equivalent equipment may be substituted.

Conventional Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface.

| <u>Mfr & Gun</u> | <u>Fluid Tip</u> | <u>Air Cap</u> |
|----------------------|------------------|----------------|
| DeVilbiss JGA | FX | 704 |
| Sagola ALM | EX | 43 |

Airless Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface.

| <u>Mfr & Gun</u> | <u>Pump</u> |
|----------------------|--------------------------------|
| Graco 205-591 | President 30:1 or Bulldog 30:1 |
| DeVilbiss JGN-502 | QFA-514 or QFA-519 |

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

Use a 0.015" to 0.019" tip with 1800 psi (124 bar)

Brush or Roller Use a medium, natural bristle brush. Apply with full strokes. Avoid rebrushing. Use a short nap mohair roller with a phenolic core. Avoid rerolling.

Mixing & Thinning

Mixing Mix to a uniform consistency before thinning.

Thinning Thin up to 15% with clean potable water.

Application Conditions

| Condition | Material | Surface | Ambient | Humidity |
|-----------|----------|---------|---------|----------|
| Normal | 23-32°C | 23-32°C | 18-32°C | 10-85% |
| Minimum | 10°C | 10°C | 4°C | 0% |
| Maximum | 38°C | 44°C | 43°C | 95% |

Do not apply when the surface temperature is less than 3°C above the dew point.

Special thinning and application techniques may be required above or below normal conditions.

Curing Schedule

| Temperature | Between Coats | Final Cure |
|-------------|---------------|------------|
| 10°C | 12 Hours | 48 Hours |
| 16°C | 8 Hours | 36 Hours |
| 25°C | 6 Hours | 24 Hours |
| 32°C | 3 Hours | 16 Hours |

Cleanup & Safety

Cleanup Use warm soapy water. If material has dried, use Carboline Thinner # 2.

Safety Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product. Employ normal workmanlike safety precautions.

Ventilation When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured.

Caution This product contains flammable solvents. Keep away from sparks and open flames.

Packaging, Handling & Storage

Shipping Weight (Approximate) **5 Litre** 7.0kg **20 Litre** 34.5kg

Flash Point (Pensky Martens Closed Cup) N/A (water-based)

Storage Temperature & Humidity 10 to 43°C
0 to 100%
Store indoors

Shelf Life 24 Months minimum when stored at 25°C.
NOTE: Freezing may drastically affect shelf life and product quality.

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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