

## Selection & Specification Data

<b>Generic Type</b>	Single package vinyl copolymer	
<b>Description</b>	Carboclad 938 Primer is a medium build corrosion resistant primer which is easy to apply, fast drying and has good weathering properties.	
<b>Features</b>	<ul style="list-style-type: none"> <li>- Intended as a shop or maintenance primer for the Carboclad 938 system, over clean steel or tightly adhering old coatings</li> <li>- Good flexibility</li> <li>- Very good weathering</li> <li>- Good abrasion resistance</li> <li>- May be applied over aged alkyds, vinyls and acrylics (a test patch is recommended to check adhesion of Carboclad 938 Primer over other coatings)</li> <li>- Not recommended for solvent exposure or immersion service</li> </ul>	
<b>Colour</b>	Red Oxide	
<b>Finish</b>	Flat	
<b>Topcoat</b>	May be topcoated with vinyls, acrylics or others as recommended.	
<b>Dry Film Thickness</b>	75 Microns	
<b>Solids Content</b>	By Volume 37% ± 2%	
<b>Theoretical Coverage Rate</b>	4.9m <sup>2</sup> /litre at 75 microns	
	<b>NOTE:</b> Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.	
<b>Temp Resistance</b>	<b>Non-immersion</b>	
	Continuous	50°C
	Non-continuous	66°C

## Substrates & Surface Preparation

<b>General</b>	Remove all oil or grease from the surface to be coated prior to abrasive blast, power or hand tool.
<b>Uncoated Steel</b>	<p><b>Preferred:</b> Abrasive blast cleaning to ISO 8501 Sa2½ to obtain a 25 to 50 micron blast profile.</p> <p><b>Acceptable:</b> Wire brush to ISO 8501 St3 for less severe exposure.</p> <p>For application over intact existing coating, the surface must be clean, dry and free of any contaminants. Loose edges should be feathered into sound coating and spot primed.</p>

November 2016 replaces March 2012

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# Carboclad® 938 Primer

## Application Equipment

**Spray** Use sufficient air volume for correct operation of equipment.

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 &amp; Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks # 18 or # 62	66	63PB
DeVilbiss P-MBC or JGA	E	704

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

<u>Mfr &amp; Gun</u>	<u>Pump *</u>
DeVilbiss JGN-502	QFA-514 or QFA-519
Graco 205-591	President 30:1 or Bulldog 30:1
Binks Model 700	B5-18 29:1 or B8-36 37:1

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

Use a .017" to .021" tip with 2000 psi (138 bar)

**Brush** Use natural bristle brush, applying with full strokes. Avoid rebrushing.

**Roller** Not recommended for application by roller.

## Mixing & Thinning

**Mixing** Power mix to a smooth consistency before thinning.

**Thinning** Thin up to 15% by volume with Thinner # 10.

**NOTE:** The use of thinners other than those supplied or approved by StonCor Africa may adversely affect the product performance and void product warranty, whether express or implied.

## Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16-32°C	18-29°C	13-38°C	10-85%
Minimum	4°C	4°C	4°C	0%
Maximum	38°C	43°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

Surface Temp. & 50% Relative Humidity	Dry to Handle	Dry to Topcoat
4°C	4 Hours	24 Hours
10°C	3 Hours	16 Hours
16°C	2 Hours	8 Hours
25°C	1 Hour	4 Hours

## Cleanup & Safety

**Cleanup** Use 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

<b>Shipping Weight (Approximate)</b>	Carboclad 938 Primer	<u>5 Litre</u>
	Thinner # 10	6.9kg
		4.9kg

<b>Flash Point (Pensky Martens Closed Cup)</b>	Carboclad 938 Primer	23°C
	Thinner # 10	24°C

**Storage Temperature & Humidity** 4 to 43°C  
0 to 100%  
Store indoors

**Shelf Life** 24 Months minimum when stored at 25°C

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



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