

SELECTION & SPECIFICATION DATA

Generic Type	Two-components epoxy polyamide primer containing zinc phosphate.
Description	Carboguard E 19 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 • 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
Primer	Self-priming
Wet Film Thickness	60 – 400 µm per coat, normally 150 µm.
Dry Film Thickness	30 - 200 microns (1.18 - 7.87 mils) per coat Normally 75 µm.
Solid(s) Content	By volume: 50 ± 2%
Theoretical Coverage Rates	5,0 m²/l at 100 µm Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 120°C (248°F) Non-Continuous: 150°C (302°F)
Limitations	Not recommended for immersion service in strong acids or exposures in areas where chalking is undesirable
Topcoats	May be topcoated with epoxy, vinyl, polyurethane or other coatings as recommended by Carboline.

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.

MIXING & THINNING

Mixing	Power mix separately, then add part B to Part A and power mix. DO NOT MIX PARTIAL KITS.
Thinning	May be thinned up to 40% with Carboline Thinner #15.

Carboguard E 19 Primer

PRODUCT DATA SHEET



MIXING & THINNING

Ratio | 2 : 1 (A to B) by volume

Pot Life | 6 hours at 23°C and higher at lower temperatures.

APPLICATION EQUIPMENT GUIDELINES

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 | The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Airless Spray | 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

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

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.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	40°C (104°F)	50°C (122°F)	50°C (122°F)	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.	Dry to Touch	Dry to Recoat	Final Cure
5°C (41°F)	4 Hours	20 Hours	21 Days
15°C (59°F)	2 Hours	15 Hours	14 Days
25°C (77°F)	1 Hour	5 Hours	10 Days

These times are based on 75 µm DFT. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

CLEANUP & SAFETY

Cleanup | Use Carboline Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

CLEANUP & SAFETY

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.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 24 months at 24°C Part B: 36 months at 24°C
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Storage	Store indoors.
Packaging	Part A 13,3 litres Part B 6,7 litres

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.