

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Two component high solids polyamide epoxy primer
<b>Description</b>	A 1:1, two component high solids polyamide epoxy primer designed to provide very good direct to metal corrosion resistance for railcars and other structures.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Single coat direct to metal high solids epoxy</li> <li>• Very Low HAPS</li> <li>• Low VOC</li> <li>• Easy one coat high build coverage</li> <li>• Excellent adhesion</li> <li>• Very good resistance to corrosion and spillage /splash of mild chemical</li> <li>• Fast re-coat</li> <li>• Compatible with various topcoats</li> </ul>
<b>Color</b>	Beige, red, white or per customer requirements
<b>Gloss</b>	Low
<b>Dry Film Thickness</b>	4 - 6 mils (102 - 152 microns) per coat
<b>Solids Content</b>	By Volume 62% +/- 3%
<b>Theoretical Coverage Rate</b>	994 ft <sup>2</sup> /gal at 1.0 mils (24.4 m <sup>2</sup> /l at 25 microns) 249 ft <sup>2</sup> /gal at 4.0 mils (6.1 m <sup>2</sup> /l at 100 microns) 166 ft <sup>2</sup> /gal at 6.0 mils (4.1 m <sup>2</sup> /l at 150 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : Per EPA Method: 1.5 lbs/gal (180 g/l)  These are nominal values and may vary slightly with color.

## SUBSTRATES & SURFACE PREPARATION

<b>Steel</b>	Severe service applications – blasted to SSPC-SP-10 to a 1.5-2.5 mil angular profile Lesser service applications – blasted to SSPC-SP-6 Surface to be free of all looser rust, dirt, grease and other contaminants
<b>Aluminum</b>	Remove all surface contaminants and treat with Strathmore's Wash Primer or equivalent.

## PERFORMANCE DATA

Test Method	Results
Adhesion (ASTM D3359)	5A (no peeling or removal)
Conical Mandrel (ASTM D522)	Passes 1/2"
Hardness (ASTM D3363)	2H-3H
Impact Resistance (ASTM D2794)	Up to 60 lbs.in (Direct) and 20 lbs.in (Rev)

**Corrosion Resistance (ASTM B117):** 1500 hours salt fog with suitable topcoat

**Chemical Resistance:** No effect on film on various chemicals on 4 hrs and 8 hrs spot tests

# Railplex EE-LV Epoxy Primer

## PRODUCT DATA SHEET



### MIXING & THINNING

<b>Mixing</b>	Agitate thoroughly each component before combining Mix (combine) 1:1 by volume Part A and Part B Agitate thoroughly again after combining
<b>Thinning</b>	5-15 % by volume maximum If necessary reduce up to 15% after combining components  Consult Carboline for recommendations
<b>Ratio</b>	1:1 Part A to Part B  Allow 20 minutes @75°F (23°C) of induction time to attain maximum gloss.
<b>Pot Life</b>	6 hours @70°F (21°C)

### 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.

<b>Airless Spray</b>	45:1 Airless spray equipment Tip Size: 0.017 to 0.021 Pump Pressure: 2500-3500 psi (17-24 MPa)  To minimize or eliminate thinner use in-line heated equipment with insulated hoses to reach application vis. Do not exceed 165°F (74°C).
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### APPLICATION PROCEDURES

**General** | Designed to be applied direct to metal in a single or two coat application.

### APPLICATION CONDITIONS

Condition
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Must be a minimum of 5°F (3°C) above the dew point during the surface preparation and coating application.

### CURING SCHEDULE

Surface Temp.	Dry to Touch	Minimum Recoat Time	Dry to Handle	Maximum Recoat Time
72°F (22°C)	2 Hours	4 Hours	5 Hours	3 Days

**Force Cure** | If car is force dried, 1 hr minimum air dry @75°F (23°C) before oven. Then force dry @145°F (60°C) for 1 hour, adjusting for ambient maximum conditions.

### CLEANUP & SAFETY

**Cleanup** | MEK may be used for clean up. Batch mixed material will set up in the lines and equipment if left overnight. With plural component equipment, be sure to flush from the mixing head through the delivery hose and guns.

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**CLEANUP & SAFETY**

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<b>Safety</b>	Handle with care. Before and during use, observe all safety labels on packaging and paint containers and follow all caution statements on this product data sheet. Consult Safety Data Sheet (SDS) for this product and follow all local or national safety regulations. Employ normal workmanlike safety precautions.
<b>Ventilation</b>	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. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

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**PACKAGING, HANDLING & STORAGE**

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<b>Packaging</b>	55 gal drums or 5 gal pails
<b>Shelf Life</b>	Generally one year from date of manufacturing when kept at recommended storage conditions at 70°F (21°C) and in original unopened containers.  Do not use material beyond shelf life.
<b>Storage Temperature &amp; Humidity</b>	Do not store at temperatures above 100°F (38°C).
<b>Storage</b>	Containers must be closed tightly. Do not store outside. Rotate stock.
<b>Flash Point (Setaflash)</b>	Part A: 12°F (-11°C) Part B: 79°F (26°C)

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**WARRANTY**

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