

SELECTION & SPECIFICATION DATA

Generic Type	A single package, low VOC, water reducible alkyd primer
Description	Railplex VOC W/R Primer is designed to provide good corrosion resistance and dry speed for railcar exterior, with wide flexibility to various top coats.
Features	<ul style="list-style-type: none"> • Single coat direct to metal high solids • Water reducible & near VOC • Excellent adhesion • Good resistance to corrosion • Ready to use viscosity
Color	Grey, Black or per customer requirements
Finish	Flat
Dry Film Thickness	2 - 4 mils (51 - 102 microns) per coat
Solids Content	By Volume 40% +/- 3%
Theoretical Coverage Rate	642 ft ² /gal at 1.0 mils (15.7 m ² /l at 25 microns) 321 ft ² /gal at 2.0 mils (7.9 m ² /l at 50 microns) 160 ft ² /gal at 4.0 mils (3.9 m ² /l at 100 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : Per EPA Method 24: 0.09 lbs/gal (11 g/l) These are nominal values and may vary slightly with color.

SUBSTRATES & SURFACE PREPARATION

Steel	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.
Aluminum	Remove all surface contaminants and treat with Strathmore's Wash Primer or equivalent.

PERFORMANCE DATA

Test Method	Results
Adhesion (ASTM D3359)	5B (no peeling or removal)
Flexibility (ASTM D522)	Passes 1/8" conical mandrel
Hardness (ASTM D3363)	2B
Impact Resistance (ASTM D2794)	Up to 40 lbs.in (Direct) and 40 lbs.in (Rev)
QUV Resistance (ASTM G154)	200 hrs- QUV UVA-340 Bulb

Corrosion Resistance (ASTM B117): 500 hrs at 3 mils DFT

MIXING & THINNING

Mixing	Agitate thoroughly
Thinning	Not Recommended, consult Carboline for recommendations

Railplex VOC W/R Primer

PRODUCT DATA SHEET



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	Designed to be applied direct to metal in a single or two coat application.
Airless Spray	45:1 Tip Size: 0.017-0.021" (0.43-0.53 mm) 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).

APPLICATION CONDITIONS

Condition

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	Dry to Handle	Minimum Recoat Time	Dry Hard	Maximum Recoat Time
72°F (22°C)	30 Minutes	1 Hour	12 Hours	24 Hours	7 Days

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

CLEANUP & SAFETY

Cleanup	Water may be used for clean up.
Safety	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 the Safety Data Sheet (SDS) for this product and follow all local or national safety regulations. 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. 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.

PACKAGING, HANDLING & STORAGE

Packaging	5 gallon pails 55 gallon drums
Shelf Life	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.

PACKAGING, HANDLING & STORAGE

Storage Temperature & Humidity | Do not store at temperatures above 100°F (38°C).

Storage | Containers must be closed tightly. Do not store outside. Rotate stock.

WARRANTY

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