

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy, zinc rich primer
Description	<p>A two-component, high solids, zinc-rich primer designed to provide excellent corrosion, humidity, damage and chemical resistance. This product can be applied via spray, brush, roll and flow coat. Fully-cured films exhibit extreme hardness, abrasion resistance and excellent corrosion resistance on steel surfaces. The two-component epoxy portion exhibits excellent chemical resistance and barrier properties, while the zinc portion offers excellent sacrificial galvanic corrosion protection for steel.</p> <p>When used as a primer with approved top-coats, the system exceeds the requirements of numerous IEEE/ANSI enclosure integrity specifications as well the high-corrosion requirements of ISO 12944, ISO 20340 and numerous OEM specifications. If 4010 Zinc is allowed to weather before topcoating ensure all zinc salts are removed prior to topcoating.</p>
Color	Metallic Grey
Dry Film Thickness	<p>2 - 5 mils (51 - 127 microns) per coat</p> <p>Not to exceed 5 mil DFT</p>
Typical Uses	<p>Designed for use in durable metal applications where corrosion resistance, chemical resistance and durability are required.</p> <p>Applications include rail, power generation and transformer equipment, oil and gas, infrastructure, wind energy, water processing and industrial.</p> <p>For optimum corrosion resistance, one of the Strathmore 4015 epoxy series topcoats should be used as a topcoat. Excellent overall corrosion resistance and color retention can be obtained with Strathmore 3380 Polyester over this product. Please contact your Carboline representative for specific product and application recommendations.</p>
Total Zinc Dust in Dry Film	83%
Solids Content	By Volume 78% +/- 2%
Theoretical Coverage Rate	<p>1251 ft²/gal at 1.0 mils (30.7 m²/l at 25 microns)</p> <p>626 ft²/gal at 2.0 mils (15.4 m²/l at 50 microns)</p> <p>250 ft²/gal at 5.0 mils (6.1 m²/l at 125 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Values	<p>As Supplied : 1.67 lbs/gal (200 g/l)</p> <p>These are nominal values and may vary slightly with color.</p>

SUBSTRATES & SURFACE PREPARATION

Steel	Steel surfaces must be clean and dry prior to application of any zinc-rich primer. All oils, dust and contamination must be removed prior to application. Surfaces should be blasted to a SSPC-SP6 (1 – 3 mils) profile per SSPC-SP1.
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MIXING & THINNING

Ratio	4:1 by volume, Part A to Part B (Part B formerly known as C86-0192)
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Strathmore 4010 Roller Coat

PRODUCT DATA SHEET



MIXING & THINNING

Pot Life | 24 hours at 72°F (22°C)

APPLICATION PROCEDURES

Application | Typically applied by roller or brush.
Contact Carboline if assistance is needed.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat	Dry to Topcoat	Dry to Topcoat with Solvent Base	Dry to Touch	Immersion Service
72°F (22°C)	4 Hours	1 Hour	10 Hours	5 Hours	1 Hour	7 Days

Dry to Topcoat with Water Systems: 10 hours at 72°F (22°C).
Please note drying times are temperature and film thickness dependent.

Force Cure | 1 hour at 200°F (93°C)

CLEANUP & SAFETY

Cleanup | Handling and disposal should be done in accordance to local, state and federal safety regulations.
Please consult the Material Safety Data Sheets for more specific handling and disposal information.

TESTING / CERTIFICATION / LISTING

This product has been tested in accordance with multiple accelerated aging tests per ASTM and ISO standards as well as in accordance with specific ANSI and IEEE specifications.
In general, this system exceeds the requirements of many Industrial OEM specifications.

Applicable ASTM Methods:

Weight/gallon: ASTM D1475-90
VOC content/gal: ASTM D3960-90
Solids by weight: ASTM D2369-90
Solids by volume: ASTM D2697-86
Viscosity: ASTM D4212-88

General

Industry Specifications and Reference:

IEEE Std C57.12.28™ - 2005: IEEE Standard for Pad-Mounted Equipment – Enclosure Integrity
IEEE Std C57.12.29™ - 2005: IEEE Standard for Pad-Mounted Equipment – Enclosure Integrity for Coastal Environments
IEEE Std C57.12.32™ - 2002: IEEE Standard for Submersible Equipment – Enclosure Integrity
ISO 12944: "Paint and Varnishes – Corrosion Protection of Steel Structures By Protective Paint Systems"
ISO 20340: "Paint and Varnishes – Performance Requirements For Protective Paint Systems for Offshore and Related Structures"
For specific test results and adherence to specific specifications, please contact your Carboline representative.



PACKAGING, HANDLING & STORAGE

Shelf Life | Part A: 6 months
Part B: 24 months

Storage Temperature & Humidity | Parts A and B should not be stored below 40°F (4°C) and above 110°F (43°C).

Storage | Materials should be stored in sealed containers when not in use. Do not store containers near sources of heat.

Shipping Weight (Approximate) | One Gallon Kit: 26 lbs (11.8 kg)

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.