SELECTION & SPECIFICATION DATA

**Generic Type** | A single package high solids alkyd primer

**Description** | A single package high solids alkyd primer designed to provide very good corrosion resistance and dry speed for rail car exterior. Wide flexibility to various top coats.

**Features**
- Single coat direct to metal high solids
- Very Low HAPS & VOC
- Easy one coat high build coverage
- Excellent adhesion
- Very good resistance to corrosion
- Ready to use viscosity

**Color** | Black, Grey or per customer requirements

**Gloss** | 5-15° (ASTM D523 @ 60° angle)

**Dry Film Thickness** | 2 - 4 mils (51 - 102 microns) per coat

**Solids Content** | By Volume 54% +/- 3%

**Theoretical Coverage Rate**
- 866 ft²/gal at 1.0 mils (21.3 m²/l at 25 microns)
- 433 ft²/gal at 2.0 mils (10.6 m²/l at 50 microns)
- 217 ft²/gal at 4.0 mils (5.3 m²/l at 100 microns)
  Allow for loss in mixing and application.

**VOC Values** | As Supplied: 2 lbs / gal (240 g/l)

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

<table>
<thead>
<tr>
<th>Test Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Adhesion (ASTM D359)</td>
<td>5B</td>
</tr>
<tr>
<td>Conical Mandrel (ASTM D522)</td>
<td>Passes 1/8”</td>
</tr>
<tr>
<td>Hardness (ASTM D3363)</td>
<td>2B</td>
</tr>
<tr>
<td>Impact Resistance (ASTM D2794)</td>
<td>Up to 40 lbs.in (Direct) and 40 lbs.in (Rev)</td>
</tr>
</tbody>
</table>

Corrosion Resistance (ASTM B117): 500 hrs at 2-3 mils DFT

MIXING & THINNING

**Mixing** | Agitate thoroughly
MIXING & THINNING

**Thinning**  |  Not Recommended, consult Carboline for recommendations.

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.

| Airless Spray | 45:1 Airless spray equipment  
|              | Tip Size: 0.015 to 0.019  
|              | Pump Pressure: 2500-3500 psi (17-24 MPa)  

To minimize or eliminate thinner use in-line heated equipment with insulated hoses to reach application viscosity. Do not exceed 165°F (74°C).

APPLICATION PROCEDURES

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

APPLICATION CONDITIONS

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

CURING SCHEDULE

<table>
<thead>
<tr>
<th>Surface Temp.</th>
<th>Dry to Touch</th>
<th>Dry to Handle</th>
<th>Minimum Recoat Time</th>
<th>Dry Hard</th>
<th>Maximum Recoat Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>72°F (22°C)</td>
<td>20 Minutes</td>
<td>90 Minutes</td>
<td>2 Hours</td>
<td>24 Hours</td>
<td>7 Days</td>
</tr>
</tbody>
</table>

**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.

**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  |  55 gal drums or 5 gal pails

Shelf Life  |  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.

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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