



CARBOGUARD 193 P

(formerly : CARBOLINE 193 PRIMER)

- Epoxy polyamide primer
- Primer for non-immersed***steel, etched primer for light metals and old coats of epoxy paints.
- Can be used as tie coat over CARBOZINC 11.

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| <p>SPECIFIC GRAVITY 1.27 (±0.05)</p> <p>SOLIDS CONTENT BY WEIGHT 67.5 % (±2)</p> <p>SOLIDS CONTENT BY VOLUME 52 % (±2)</p> <p>DELIVERY VISCOSITY AT 20°C A/ 70-85 KU at 25 °C B/ 25-35 sec 20°C</p> <p>FLASH POINT A/ 25°C B/ 25°C</p> <p>PACKING 2 components</p> <p>GLOSS Semi-gloss</p> <p>COLOUR Red iron oxide / grey</p> <p>STANDARD DRY FILM THICKNESS Antic 50 µ Tie Coat 30 µ</p> <p>STANDARD WET FILM THICKNESS 96 µ 57 µ</p> <p>THEORITICAL COVERAGE 10.4 m²/L 17.3 m²/L</p> | <p>CONDITIONS OF USE</p> <p>- TEMPERATURE >5 °C *</p> <p>- HUMIDITY < 85% *</p> <p>MIXING RATIO A/B by weight 82/18 by volume 75/25</p> <p>MATURATION BEFORE USE AT 20°C 10 mn</p> <p>POT LIFE AT 20°C 8 hours</p> <p>DRYING TIME BETWEEN COATS at 10°C 20°C 30°C</p> <p>MINIMUM 24 h 8 h 4 h</p> <p>MAXIMUM ** without</p> <p>DRYING TIME AT 20°C (Humidity 70%)</p> <p>DUST DRY 45 minutes</p> <p>TACK FREE 4 hours</p> <p>DRY HARD 8 hours</p> |
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| <p>SURFACE PREPARATION</p> <p>PRECEDING COAT</p> <p>TOP COAT</p> | <p>Steel : dry abrasive blast to SA 2,5 grade – Profile 25/50 microns, if necessary, mechanical wire brushing to ST3 grade. Galvanised steel : Degreasing, chemical treatment, rinsing.</p> <p>Over bare steel or over steel coated with Carboweld, Carbozinc, Corrozinc N°1, Primer SP.</p> <p>Epoxy, modified epoxy, tar, acrylurethane, chlorinated rubber (for this last one, when applied more than 48 hours after the epoxy primer, special thinning with thinner N° 42 will be necessary)</p> |
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| APPLICATION CONDITIONS | AIRLESS SPRAY | CONV. SPRAY | BRUSH/ROLLER |
|------------------------------------|---------------|-------------|--------------|
| PAINT PRESSURE (Bars) | 100 – 120 | 1 - 3 | |
| AIR PRESSURE (Bars) | / | 3 - 5 | |
| NOZZLE SIZE Ø (mm) | 0.4 – 0.5 | 1.2 – 1.5 | |
| APPLICATION VISCOSITY AT 20°C AF 4 | 40 – 100 sec | 40 – 60 sec | 120 sec |
| THINNING (% BY VOLUME) | 5 to 10% | 5 to 15% | 0 to 5% |
| RECOMMENDED THINNER | N°15 | N° 15 | N° 15 |

REMARKS : * Do not apply when the surface temperature is less than 2°C above the dew point.
 ** Under special conditions, after 6 months, a mist coat of Carboguard 193 Primer with 25% of thinner may be necessary – Consult our technical dept.
 Storage conditions : 4°C mini / 43°C maxi – Store indoors, in closed containers.
 Shelf life : 2 years when stored at 20°C – Temperature resistance, non immersion : 90°C continuous.
 *** Not recommended for immersion since except in case of use of a topcoating paint sytem recommended for immersion service.