

## Selection & Specification Data

<b>Generic Type</b>	Carboguard® 504 is an inert non-inhibitive anti-corrosive modified polyamide cured epoxy primer.
<b>Description</b>	Carboguard® 504 is a high performance and immersion grade (fresh & salt water) chemically cured epoxy primer. Carboguard® 504 may be applied over suitably prepared mild steel, non-ferrous metals and most GRP substrates.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Excellent primer for water and many aqueous chemicals immersion service when top-coated with an approved finish</li> <li>• Excellent adhesion to difficult substrates</li> <li>• Excellent holding primer</li> <li>• Excellent corrosion resistance</li> <li>• Complies with AS/NZS 3750.13 (2 pack epoxy primer), Types 1, 2 &amp; 3.</li> <li>• Good abrasion resistance</li> <li>• Very good aged re-coatability</li> <li>• Resists splash and spillage or fumes of a wide range of chemicals</li> <li>• Easy application by brush, roller or spray</li> <li>• Ideal tie-coat over inorganic zincs</li> <li>• Versatile - can be used on most substrates under many different types of topcoat</li> <li>• Long pot-life</li> <li>• Excellent maintenance touch-up primer for hand-cleaned substrates</li> <li>• A user-friendly primer for epoxy or polyurethane systems in environments not suited to zinc primers due to acidic or alkaline fallout or splash &amp; spill.</li> </ul>
<b>Gloss</b>	Flat
<b>Colour</b>	Buff Grey (10 litre kits only)
<b>Topcoats</b>	Epoxies, Polyurethanes, Intumescent Base-Coats & Anti-Foulings
<b>Dry Film Thickness</b>	40 – 75 microns; optimum 50 microns DFT
<b>Solids Content</b>	50% ± 2% (ASTM D2697 – 7 days)
<b>Theoretical Coverage Rate</b>	10 square metres per litre at 50 microns DFT 80 – 150 microns WFT; 40 – 75 microns DFT
<b>Mix Ratio</b>	4:1 by volume (Part A : Part B)
<b>VOC Values</b>	432 g / litre
<b>Dry Temp. Resistance</b>	121°C - maximum
<b>Limitations</b>	Not suitable for exposure to strong solvents. Avoid excessive dry film thickness. Exceeding 75 microns will compromise rate of cure and may result in solvent entrapment. Low temperatures, high humidity and poor ventilation will exacerbate the problem.

## Substrates & Surface Preparation

<b>General</b>	Remove any oil or grease from surface to be coated by the two rag method with clean rags soaked in Thinner #2.
<b>Steel</b>	Interior & moderate exterior exposure, abrasive blast AS1627.4 Class 2 or power tool clean to SSPC SP3. Exterior industrial & marine immersion, abrasive blast to AS1627.4 Class 2½ (SSPC SP10).
<b>Galvanized Steel &amp; Aluminium</b>	Sweep abrasive blast to a matte finish with non-metallic blast media or thorough mechanical abrasion using 80-100 grit discs.
<b>Previously Painted Surfaces</b>	Check existing surface for solvent-resistance and compatibility before commencing work. Spot abrasive blast as required, sweep blast or sand existing sound coating.

## Typical Performance Data

Test	Method	Result
Abrasion Resistance	ASTM D4060; CS17 Wheel 250gm load, 1000 cycles	39 mg loss
Adhesion	ASTM D4541	900 psi (6.2 Mpa)
Humidity Resistance	ASTM D2247, 1000 hours	No effect
Impact Resistance	ASTM D2794, 16 gauge (1.6mm) steel	88 inch-pounds (101 kg-cm)
Salt Fog Resistance	ASTM B117, 1000 hr	No effect on film integrity or adhesion, less than 1/8" (3mm) undercutting at scribe, less than 4% rusting at edges.
Pencil Hardness	ASTM D3363	F