product data



Carboguard® 504 Marine & GP Epoxy Primer

Selection & Specification Data

Generic Type

Carboguard® 504 is an inert non-inhibitive anticorrosive modified polyamide cured epoxy

primer.

Description

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.

Features

Excellent primer for water and many aqueous chemicals immersion service when top-coated with an approved finish

Excellent adhesion to difficult substrates

Excellent holding primer

Excellent corrosion resistance

Complies with AS/NZS 3750.13 (2 pack epoxy primer), Types 1, 2 & 3.

Good abrasion resistance

Very good aged re-coatability

Resists splash and spillage or fumes of a wide range of chemicals

Easy application by brush, roller or spray

Ideal tie-coat over inorganic zincs

Versatile - can be used on most substrates under many different types of topcoat

Long pot-life

Excellent maintenance touch-up primer for

hand-cleaned substrates

A user-friendly primer for epoxy or polyurethane systems in environments not suited to zinc primers due to acidic or alkaline fallout or splash & spill.

Gloss

Flat

Colour

Grey (10 litre kits only)

Topcoats

Epoxies, Polyurethanes, Intumescent Base-

Coats & Anti-Foulings

Dry Film **Thickness** 40 - 75 microns; optimum 50 microns DFT

Solids Content 50% ± 2% (ASTM D2697 - 7 days)

Theoretical Coverage Rate

10 square metres per litre at 50 microns DFT 80 - 150 microns WFT; 40 - 75 microns DFT

Mix Ratio

4:1 by volume (Part A : Part B)

VOC Values

432 g / litre

Dry Temp. Resistance 121°C - maximum

Limitations

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

General

Remove any oil or grease from surface to be coated by the two rag method with clean rags

soaked in Thinner #2.

Steel

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 21/2 (SSPC

SP10).

Galvanized Steel & Aluminium

Sweep abrasive blast to a matte finish with non-metallic blast media or thorough mechanical abrasion using 80-100 grit discs.

Previously Painted Surfaces

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 that 1/8" (3mm) undercutting at scribe, less than 4% rusting at edges.
Pencil Hardness	ASTM D3363	F

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