

## Selection Data

**GENERIC TYPE** : Solvent Free, Modified Aliphatic amine cured epoxy. Parts A and B mixed prior to application.

**GENERAL PROPERTIES** : CARBOGUARD 6201N(K) is a high solids high gloss, high build epoxy that can be applied by spray, brush, or roller. The cured film provides a tough, cleanable surface. Available in wide variety of colors.

- Good flexibility and lower stress upon curing than most epoxy coatings.
- Very good abrasion resistance
- Attractive gloss appearance.
- Meets VOC (Volatile Organic Content) regulations.
- **Tested for Nuclear Service Level I,II (Approved for APR1400)**

Features include : **RECOMMENDED USES** : CARBOGUARD 6201N(K) is recommended where a high performance, chemically resistant epoxy topcoat is desired. offers outstanding protection for interior floors, walls, piping, equipment and structural steel or as an exterior coating for railcars, structural steel and equipment in various corrosive environments. Recommended industrial environments include Chemical Processing, Offshore Oil and Gas, Food Processing and Water and Waste Water Treatment, Pulp and Paper, Power Generation among others. May be used as a two coat system direct to metal or concrete for Water and Municipal Waste Water immersion.

**NOT RECOMMENDED FOR** : prolonged exposure to strong solvents.

### TYPICAL CHEMICAL RESISTANCE :

#### Splash &

Exposure	Spillage	Fumes
Acids	Good	Good
Alkalies	Good	Good
Solvents	Good	Good
Salt water	Very Good Excellent	Very Good Excellent

### TEMPERATURE RESISTANCE : (Non-immersion)

Continuous : 250°F (121°C)

Non-continuous : 300°F (149°C)

Discoloration and loss of gloss is observed above 200°F (93°C)

**SUBSTRATES** : Apply over properly prepared metal or concrete surfaces.

**COMPATIBLE COATINGS** : May be applied directly over inorganic zincs, galvanizing, catalyzed epoxies, phenolics as instructed. May be used as a tiecoat over inorganic zincs. A mist coat of CARBOGUARD6201N(K) is required when applied over inorganic zincs to minimize bubbling. May be topcoated to upgrade weathering resistance. Not recommended over chlorinated rubber or latex coatings. Consult Carboline Technical Service Department for specific recommendation

## Specification Data

### THEORETICAL SOLIDS CONTENT OF MIXED

**MATERIAL** : By Volume

CARBOGUARD 6201N(K) 98% ± 2%

### VOLATILE ORGANIC CONTENT (VOC, Theoretical):

The following are nominal values :

**As supplied** : 0.13 lbs./gal. (16 g/l)

**Thinned** : Utilizing Thinner #2 (by Volume)

% Thinned	Fluid Ounces/Gal	Pounds /Gallon	Grams /Liter
6%	8.55	0.53	64

\* May vary slightly with color.

### RECOMMENDED DRY FILM THICKNESS PER COAT :

Primer : 3-8mils , Finish : 4-16 mils

### THEORETICAL COVERAGE PER MIXED GALLON :

314.4 sq. ft. at 5 mils (7.84 sq. m/l at 125 microns)

\* Mixing and application losses will vary and must be taken into consideration when estimating job requirements.

### STORAGE CONDITIONS :

Store indoors.

Temperature : 40-110°F (4- 43°C)

Humidity : 0-100%

**SHELF LIFE** : 24 months when stored at 75°F (24°C).

**Primer** : Gray

**Finish** : Refer Carboline color Guide.

**Finish** : gloss. (Epoxies lose gloss, discolor and will eventually chalk in sunlight exposures.

## Ordering Information

Prices may be obtained from your local carboline Sales.

Sales Representative or Carboline Customer Service Department.

### APPROXIMATE SHIPPING WEIGHT :

	Gal.Kit	5Gal.Kit
CARBOGUARD6201N(K)	15 lbs.(7 kg)	73 lbs.(33 kg)
Thinner #2	8 lbs.(3.6kg) in 1' s 38 lb. (17.3 kg) in 5's	

### FLASH POINT : (Setaflash)

CARBOGUARD6201N(K) Part A	200°F (93°C)
CARBOGUARD6201N(K) Part B	200°F (93°C)
Thinner #2	24°F (-4°C)

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To the best of our knowledge the technical data contained herein are true and accurate at the date of issuance and are subject to change without prior notice. User must contact Carboline 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 or injuries resulting from use. Liability, if any, is limited to replacement of products. Prices and cost data if shown, are subject to change without prior notice. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY THE SELLER EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OR LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE

# CARBOGUARD® 6201N(K) Primer & Finish

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

**SURFACE PREPARATION :** Remove any oil or grease or loose rust from the surface to be coated with clean rags soaked in Thinner #2 or Surface Cleaner #3 in accordance with SSPC-SP 1. Consult Surface Cleaner #3 Product Data Sheet for specific instructions. If existing coating is loose, flaking or otherwise failed, sweep blasting is recommended.

**STEEL :** For immersion service, abrasive blast to a minimum Near White Metal Finish in accordance with SSPC-SP10, to a degree of cleanliness in accordance with NACE #2 to obtain a 1.5-3 mil (40-75 micron) blast profile. For non-immersion, abrasive blast to a Commercial Grade Finish in accordance with SSPC-SP6, to a degree of cleanliness in accordance with NACE #3 to obtain a 1.5-3 mil (40-75 micron) blast profile.

**Concrete :** Apply over clean, dry recommended surfer.  
Remove laitance by abrasive blasting or other means.

Do not coat concrete treated with hardening solutions unless test patches indicate satisfactory adhesion. Do not apply coating unless concrete has cured at least 28 days at 70°F(21°C) and 50% RH or equivalent time.

**MIXING :** Power mix separately, then combine and mix in the following proportions :

	<u>1 Gallon Kit</u>	<u>5 Gallon Kit</u>
CARBOGUARD 6201N(K) Part A	0.67 gallon	3.33 gallons
CARBOGUARD 6201N(K) Part B	0.33 gallon	1.67 gallons

**DO NOT MIX PARTIAL KITS .**

**THINNING :** May be thinned up to 8% by volume with Thinner #2

\*Plural component equipment : Not recommended.  
Refer to Specification Data for VOC information.

Use of thinners other than those supplied or approved by carboline may adversely affect product performance and void product warranty, whether express or implied.

**POT LIFE :** 1.5 hrs 75°F (24°C) and less at higher temperatures.  
Pot life ends when coating loses body and begins to sag.

**APPLICATION TEMPERATURES :**

	<u>Material</u>	<u>Surfaces</u>
Normal	59-90°F(15-32°C)	50-90°F(10-29°C)
Minimum	50°F(10°C)	41°F(5°C)
Maximum	90°F(32°C)	135°F(57°C)

	<u>Ambient</u>	<u>Humidity</u>
Normal	50-90°F(10-29°C)	0~80%
Minimum	41°F(5°C)	0%
Maximum	110°F(43°C)	85%

Special thinning and application techniques may be required above or below normal conditions.

**SPRAY :** This is a high solids coating and may require slight adjustments in spray techniques. Wet film thicknesses are easily found and quickly achieved. The following spray equipment has been found suitable and is available from manufactures such as Binks, DeVilbiss and Graco.

**CONVENTIONAL :** Pressure pot equipped with dual regulators,  
**SPRAY :** Flush equipment with Thinner #2 prior to use.  
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**AIRLESS :**

Pump Ratio	: 45 : 1 (min.)
GPM Output	: 3.0 (min.)
Material Hose	: 3/8" I.D.(min.)
Tip Size	: 0.13-0.17"
Output PSI	: 2500-4000
Filter Size	: 80-100 mesh

\*Plural component equipment may also be used if the material can not be sprayed within the working time of the mixed material.

**BRUSH OR ROLLER (General) :** Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 75°F(24°C).

**BRUSH :** Use a medium bristle brush.

**ROLLER :** Use a short-nap synthetic roller cover with phenolic core.

**DRYING TIMES :** These times are at the recommended dry film thickness of 7 mils. High film thicknesses will lengthen cure time.

**CLEAN UP :** Use Thinner #2

<u>Temperature</u>	<u>Dry to Handle</u>	<u>Dry to Topcoat</u>	<u>Maximum Recoat</u>
61°F(16°C)	20 hours	3 days	30 days
75°F(24°C)	10 hours	24 hours	30 days
90°F(32°C)	8 hours	24 hours	15 days

**CAUTION : READ AND FOLLOW ALL CAUTION STATEMENTS ON THIS PRODUCT DATA SHEET AND ON THE MATERIAL SAFETY DATA SHEET FOR THIS PRODUCT.**

CAUTION: CONTAINS FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST. WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.

