

**KARPOX TOLERA**

PRODUCT CODE: KBK 03017  
SURFACE TOLERANT EPOXY PRIMER

**1. DESCRIPTION OF PRODUCT AND THE PRODUCER**

|                           |   |
|---------------------------|---|
| GENERIC TYPE              | Anticorrosive, Universal Epoxy Primer   |
| DESCRIPTION, AREAS OF USE | KarpoX Tolera is a two component, general purpose and surface tolerant epoxy primer for industrial applications. It has excellent adhesion, chemical resistance, humidity resistance and high-build properties. Could also be used as intermediate or topcoat for multilayer heavy duty applications. Recoatability, flexibility and cure-ability are improved. Has outstanding in can and application stability. Provides even better results than coal-tar epoxy systems. Suitable for impressed current systems. |
| PRODUCER INFORMATION      | Kartallar Boya ve Kimya Sanayi Ticaret Limited Sirketi<br>Kosklucesme Mahallesi, Yeni Bagdat Caddesi, No:136, 41400<br>Gebze / KOCAELI / TURKIYE  |
| PRODUCT HOTLINE           | Monday-Saturday (08:30 - 18:00) Tel: 0262 641 49 67 Fax : 0262 641 49 68  |
| EMERGENCY LINE            | Uludag University Poison Research Center (7/24) - +90 224 442 82 93   |

**2. PRODUCT'S TECHNICAL & APPLICATION PARAMETERS**

|                                    |  |
|------------------------------------|--|
| COLOUR(S) / TEXTURE                | Redbrown, Gray, Black, White   |
| APPEARANCE                         | Semi Matt (ASTM D 523)   |
| SPECIFIC GRAVITY                   | 1,35±05 g/cm <sup>3</sup> (ASTM D 1475)  |
| SOLID BY VOLUME                    | %60±1 (ASTM D 2697)  |
| THINNER CODE                       | K- Solv 1500   |
| THINNING RATE                      | %5-8   |
| VOC CONTENT                        | 356 g/L (ASTM D 3960)  |
| SPREADING RATE                     | 7 sqm per liter when applied as single coat (120 microns DFT)  |
| SURFACE DRY TIME                   | 3 hours @20 °C   |
| THROUGH DRY                        | 18 hours @20 °C  |
| COMPLETELY CURED                   | 9 days @20 °C  |
| HARDENER TYPE - COMP. MIXING RATIO | K-Cure 22000 , <b>8:1 on Weight</b>  |
| METHOD OF APPLICATION              | Airless Spray, HVLP Spray, lint free roller, brush   |
| NOZZLE INFO                        | 0.019" - 0.023"  |
| PRESSURE INFO                      | 160-200 bars   |
| RECOMMENDED WET THICKNESS          | 200 microns  |
| DRY FILM THICKNESS                 | 120 microns  |
| MINIMUM RECOATING INTERVAL         | <b>18 hours</b> @20 °C   |
| MAXIMUM RECOATING INTERVAL         | <b>Not limited</b>   |
| POT LIFE                           | <b>5 hours</b> @20 °C  |
| SHelf LIFE                         | <b>2 years</b> for Component A and <b>2 year</b> for Component B from the date of manufacture, as long as stored at proper conditions and unopened |

**3. SURFACE PREPARATION & ENVIRONMENTAL CONDITIONS DURING APPLICATION**

|                     |  |
|---------------------|--|
| NEW APPLICATION     | Oil and grease should be removed by solvent cleaning according to SSPC-SPI. Steel surfaces should be abrasive blasted to Sa2 <sup>1/2</sup> as per ISO 8501-1:2007) If a suitable temporary protecting primer was applied, loose debris and any type of contamination should be cleaned thoroughly prior to the final application. |
| REPAIRS             | Corroded areas should be blast cleaned to Sa2 <sup>1/2</sup> or SSPC SPI0. Existing systems should be dry and free from loose paint, salt, grease and other contaminants prior to the overcoating.   |
| SURFACE SALT LIMITS | 35µg/sqm   |

DATE OF ISSUE : 24.09.2018

**KARTALLAR BOYA VE KIMYA SANAYI TICARET LIMITED SIRKETI**

Address : Kosklucesme Mahallesi, Yeni Bagdat Caddesi, No:136, 41400- Gebze/ Kocaeli /TURKIYE  
Tel : +90 262 641 49 67 E-mail : [info@kartallarboya.com](mailto:info@kartallarboya.com) Website : [www.kartallarboya.com](http://www.kartallarboya.com)



## KARPOX TOLERA

PRODUCT CODE: KBK 03017  
SURFACE TOLERANT EPOXY PRIMER



### 3. SURFACE PREPARATION & ENVIRONMENTAL CONDITIONS DURING APPLICATION (CONTINUED)

#### ENVIRONMENT CONDITIONS

The temperature of the surface should be at least 3°C higher than the DewPoint of the air. Temperature and relative humidity should be measured in the vicinity of the substrate. The maximum recommended surface temperature is 40°C. In extreme cases, it may be necessary to reduce film thickness in order to avoid sagging. When applying the paint in confined spaces, provide adequate ventilation during application and drying. The temperature of the mixed paint should be at least 15°C. Otherwise extra solvent may be needed to obtain a proper application viscosity. Relative humidity must not be over %80

### 4. PACKING & STORAGE CONDITIONS

#### PACKING DETAILS

24 Kg Component A + 3 Kg Component B in steel pails

#### STORAGE CONDITIONS

Storing areas should be dry and well ventilated where the temperature is always between 5-30°C. These areas should be separated from the manufacturing fields to eliminate the risks of fire.

### 5. ENVIRONMENTAL RESPONSIBILITY, HEALTH & SAFETY

#### GENERAL RULES

Observe the precautionary notices on the label of the container. A material safety data sheet is available upon request and national or local safety regulations should be followed. This product is intended for use by professional applicators.

#### HEALTH

Avoid skin- and eye contact by wearing overalls, gloves, goggles, mask, etc. Spillage on the skin should immediately be removed by thorough washing with lukewarm water and soap or a suitable industrial cleaner. Eyes should be flushed with fresh water and medical attention sought immediately. Spraying should be carried out under well-ventilated conditions. Avoid inhalation of solvent vapors and paint mist by wearing an air mask.

#### SAFETY

This product contains flammable materials and should be kept away from sparks and open flames. Smoking in the area should not be permitted.

### 6. DISCLAIMER

#### DISCLAIMER

The information in this data sheet is provided to the best of our knowledge. However, we have no control over either quality or condition of the substrate and other factors affecting the use and application of this product. Therefore, we cannot accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising from the use of this product. We reserve the right to change the product without notice.

DATE OF ISSUE : 24.09.2018



#### KARTALLAR BOYA VE KIMYA SANAYI TICARET LIMITED SIRKETI

Address : Kosklucesme Mahallesi, Yeni Bagdat Caddesi, No:136, 41400- Gebze/ Kocaeli /TURKIYE  
Tel: +90 262 641 49 67 E-mail : [info@kartallarboya.com](mailto:info@kartallarboya.com) Website : [www.kartallarboya.com](http://www.kartallarboya.com)