

Selection & Specification Data

Generic Type	Reinforced Zinc-Rich Primer
Description	A corrosion resistant, zinc containing primer with special reinforcing fillers. Carbozinc 808 is an excellent corrosion resistant, low VOC, fast cure topcoat primer with quick turnaround features for shop or field use. It can be used in moderate to corrosive applications for architectural, marine, and industrial markets.
Features	<ul style="list-style-type: none"> • Rapid cure. Dry to recoat in 90 minutes at 75°F (24°C) and 50% relative humidity. • Low temperature cure down to 35°F (2°C) • Meets Class A slip co-efficient and creep testing criteria for use on faying surfaces • Excellent adhesion • Protects against undercutting corrosion • Supplied as ASTM D520, Type II zinc • VOC compliant to current AIM regulations
Color	Green (0300)
Finish	Flat
Primer	Self Priming
Dry Film Thickness	2 - 4 mils (51 - 102 microns) per coat
	Dry film thickness in excess of 8.0 mils (200 microns) per coat is not recommended.
Theoretical Coverage Rates	978 mil sq. ft./gal
	Measured in accordance with ASTM D 2697. Allow for loss in mixing and application.
VOC Values	Thinner 10 13 oz/gal: 2.63 lbs/gal (315 g/l) Thinner 225 E 13 oz/gal: 2.16 lbs/gal (259 g/l) As Supplied 2.16 lbs/gal (259 g/l)
	These are nominal values when measured in accordance with EPA Method 24.
Dry Temp. Resistance	Continuous: 350 °F (177 °C) Non-Continuous: 400 °F (204 °C)
Topcoats	Normally topcoated with epoxies, polyurethanes, acrylics, polysiloxanes, and others as recommended by your Carboline sales representative. Under certain conditions, a mist coat is required to minimize topcoat bubbling.

Substrates & Surface Preparation

General	Surfaces must be clean and dry. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
Steel	SSPC-SP6 with a 1.0-3.0 mil (25-75 micron) surface profile. SSPC-SP2 or SP3 for touch-up.

Mixing & Thinning

Mixing	Power mix Part A completely. Then slowly add the Part B under agitation. Pour mixture through a 30 mesh screen. DO NOT MIX PARTIAL KITS.
Thinning	Normally not required but may be thinned up to 13 oz/gal (10%) with Thinner 10 or 225E. Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	<u>1 Gal. Kit</u> Part A: 0.90 gallons Part B: 0.10 gallons <u>5 Gal. Kit</u> Part A: 4.50 gallons Part B: 0.50 gallons
Pot Life	8 Hours at 70°F (21°C) and less at higher temperatures.

Application Equipment Guidelines

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Spray Application (General)	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco. Keep material under mild agitation during application.
Conventional Spray	Agitated pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 45:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .017-.021" Output PSI: 3000-3500 Filter Size: 60 mesh *PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	For small areas and touch-up only. Preferred method for large areas is spray application.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	40 °F (4 °C)	20 °F (-7 °C)	20 °F (-7 °C)	10%
Maximum	90 °F (32 °C)	130 °F (54 °C)	120 °F (49 °C)	95%

Industry standards are for the substrate temperatures to be 5°F (3°C) above the dew point. This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions which are as follows: material 60°F-85°F (16°C-29°C), surface & ambient 60°F-90°F (16°C-32°C) and humidity 50-90%.

Carbozinc[®] 808

Curing Schedule

Surface Temp.*	Dry to Handle	Dry to Topcoat
35 °F (2 °C)	36 Hours	10 Hours
50 °F (10 °C)	18 Hours	4 Hours
75 °F (24 °C)	6 Hours	90 Minutes
100 °F (38 °C)	2 Hours	30 Minutes

These times are based on a 3.0 mil (75 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

Maximum Recoat: 6 months. Must have a clean, dry surface for topcoating. "Loose" chalk or salts must be removed in accordance with good painting practice. Consult Carboline Technical Service for specific information.

Cleanup & Safety

- Cleanup** Use Thinner 2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
- Safety** Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions.
- Ventilation** When used in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.
- This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Packaging, Handling & Storage

- Shelf Life** Part A: Min. 12 months at 75°F (24°C)
Part B: Min. 12 months at 75°F (24°C)
- *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
- Shipping Weight (Approximate)** 1 Gallon Kit - 20 lbs (9.2 kg)
5.00 Gallon Kit - 101 lbs (45.9 kg)
- Storage Temperature & Humidity** 40° – 110°F (4° - 43°C)
0-95% Relative Humidity
- Flash Point (Setaflash)** Part A: 93°F (34°C)
Part B: 103°F (39°C)
- Storage** Store Indoors.



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