

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	High chemical resistant epoxy lining
<b>Description</b>	Carboguard 896S is a two component, high solids, modified epoxy formulated for use as a seal coat under Carboguard 896 High Chemical Service Lining.
<b>Features</b>	Complies with 21CFR175.300(b)(3)(viii)(a)
<b>Color</b>	Red 0500
<b>Finish</b>	Semi-Gloss
<b>Primer</b>	Welds should be striped with Carboguard 896S by brush or spray
<b>Weld Preparation</b>	NACE RP0178-89, Weld Prep Designation C
<b>Wet Film Thickness</b>	3 to 5 mils per coat
<b>Dry Film Thickness</b>	2 - 3 mils (51 - 76 microns) per coat
<b>Typical Uses</b>	Dry bulk service for hopper cars carrying EVA, PTA, polyethylene (PE), polypropylene (PP), polystyrene (PS), polyvinyl chloride (PVC) plastic pellets, and other commodities, which may contain residual process acid.
<b>Solids Content</b>	By Volume 59% +/- 2%
<b>Theoretical Coverage Rate</b>	946 ft <sup>2</sup> /gal at 1.0 mils (23.2 m <sup>2</sup> /l at 25 microns) 473 ft <sup>2</sup> /gal at 2.0 mils (11.6 m <sup>2</sup> /l at 50 microns) 315 ft <sup>2</sup> /gal at 3.0 mils (7.7 m <sup>2</sup> /l at 75 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 2.86 lbs/gal (343 g/l) Mixed.
<b>Dry Temp. Resistance</b>	Continuous: 225°F (107°C)

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminants.
<b>Steel</b>	NACE No.2/SSPC-SP 10 Near White Metal Blast. Anchor (surface) profile should be a sharp, angular and dense 2.5 to 3.5 mil profile.

## MIXING & THINNING

<b>Ratio</b>	1:1 by volume
<b>Pot Life</b>	4 hours at 77 °F (25 °C)

# Carboguard 896S

## PRODUCT DATA SHEET



### 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.

**Airless Spray** | • Pump Ratio: 45:1  
• Gun Tip: 0.017" to 0.019"

**Brush** | A small brush can be used for touch-up or small repair areas.

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	70°F (21°C)	60°F (16°C)	50°F (10°C)	0%
Maximum	90°F (32°C)	90°F (32°C)	90°F (32°C)	90%

Non-contaminated profile (pretreat and blast contaminated surfaces. Dry, dust-free metal surface.

### CURING SCHEDULE

Surface Temp.	Set to Touch	Tack Free	Dry Hard	Dry to Recoat
77°F (25°C)	4 Hours	7 Hours	12 Hours	16 Hours

**Note:** Normal recoat is within 72 hours at 77 °F (25 °C)

**Air Dry Schedule:** Circulate warm air at 85-90°F (29-32 °C) for 12 hours minimum. Perform electrical holiday test for discontinuities. All touch-ups must be made before force cure.

**Force Cure Schedule:**

Ramp rate @ 1 °F/min.

150 °F soak temperature @ 6 hours

### CLEANUP & SAFETY

**Cleanup** | Use Thinner 2 or Acetone.

**Safety** | Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation. Keep container closed when not in use.

### PACKAGING, HANDLING & STORAGE

**Shelf Life** | 24 Months

**Shipping Weight (Approximate)** | Approx. 12 lbs/gallon  
Part A - 13 lbs (1 gal)  
Part B - 10 lbs (1 gal)

**Flash Point (Setaflash)** | Part A - 60 °F (16 °C)  
Part B - 80 °F (27 °C)

## WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company 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, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.