

SELECTION & SPECIFICATION DATA

Generic Type	Polyamide Epoxy
Description	Carboguard 894 is a high performance, versatile, immersion-grade, VOC compliant, high build, self-priming epoxy. It is suitable for industrial and marine environments in fresh or salt water immersion. It can also be used for tank exteriors, structural steel, piping, or process equipment. Carboguard 894 may be used on barges, vessels and other marine applications where a high quality epoxy is needed.
Features	<ul style="list-style-type: none"> • Immersion- grade epoxy • High solids, low VOC • Excellent adhesion • Excellent flexibility • Long recoat window
Color	Refer to Carboline color chart.
Finish	Satin
Primer	Self-priming
Dry Film Thickness	5 - 7 mils (127 - 178 microns) per coat (Two coats are normally required for immersion service)
Solids Content	By Volume 86% +/- 2%
Theoretical Coverage Rate	1379 ft ² /gal at 1.0 mils (33.9 m ² /l at 25 microns) 276 ft ² /gal at 5.0 mils (6.8 m ² /l at 125 microns) 197 ft ² /gal at 7.0 mils (4.8 m ² /l at 175 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 1.0 lbs/gal (120 g/l)
Topcoats	For non-immersion applications, can be topcoated with polyurethanes.

SUBSTRATES & SURFACE PREPARATION

General	All 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 in accordance with SSPC-SP 1. Contact Carboline Technical Service for recommendations.
Steel	<p><u>Immersion Service</u>: minimum Near White Metal Blast Clean with 1.5 to 3 mils (37 to 75 microns) anchor profile in accordance with NACE No. 2/SSPC-SP 10.</p> <p><u>Non-immersion Service New Steel</u>: it is recommended that the steel be abraded, preferably to a minimum of Commercial Blast Clean with 1.5 to 3 mils (37 to 75 microns) anchor profile in accordance with NACE No. 3/SSPC-SP 6. For alternative methods contact Carboline Technical Service.</p> <p><u>Non-immersion Service Weathered (corroded) Steel</u>: for optimum performance abrasive blast clean to a minimum of commercial Blast with 1.5 to 3 mils (37 to 75 microns) anchor profile in accordance with NACE No. 3/SSPC-SP 6. Alternative methods may include SSPC-SP 2, SSPC-SP 3, NACE No. 4/SSPC-SP 7, or NACE/SSPC WJ-1 to WJ-4. Contact Carboline Technical Service for recommendations.</p>

SUBSTRATES & SURFACE PREPARATION

Concrete or CMU	Concrete shall be designed, placed, cured, and prepared per NACE No. 6/SSPC-SP 13, latest edition. Abrade to remove all laitance, loose concrete, etc. and to create surface profile in accordance with the appropriate ICRI CSP standard for the coating system.
Previously Painted Surfaces	Clean and lightly sand or abrade to roughen and degloss the surface. Existing coating must attain a minimum 3A rating in accordance with ASTM D3359 adhesion test.

MIXING & THINNING

Mixing	Thoroughly mix each component using mechanical agitation. Pour the activator, part B, into part A (mixing ratio by volume: 1 part activator, part B, to 1 part, part A) and mix well using mechanical agitation.
Thinning	Mixed Carboguard 894 may be thinned up to allowable local VOC regulations with Thinner 248.
Pot Life	8 hours at 75 °F (24 °C). Allow 15 minutes induction time at 75 °F (24 °C). Do not mix more than can be applied during the product's useful pot life.

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)	Apply using airless spray. Use a 50% overlap with each pass when spraying to eliminate holidays and pinholes.
Airless Spray	<ul style="list-style-type: none">• Material Hose: 3/8" I.D. (min.)• Tip Size: 0.019-0.023"• Output PSI: 3000 minimum• High Pressure Filter: 30 Mesh
Brush	A natural bristle or nylon/polyester
Roller	1/4-3/8" woven, solvent resistant core for smooth surfaces, 3/4-1 1/4" nap for rough surfaces

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Recoat	Final Cure
50°F (10°C)	18 Hours	36 Hours	21 Days
75°F (24°C)	6 Hours	18 Hours	7 Days
90°F (32°C)	3 Hours	9 Hours	3 Days

The above cure times are based on 5 mils (125 microns). 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.

CLEANUP & SAFETY

Cleanup	Clean up all tools and equipment promptly with Thinner 2.
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CLEANUP & SAFETY

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.
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PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 36 months Part B: 36 months *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40- 110 °F (4-43 °C) 0-90% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	2 Gal Kit - 28 lbs 10 Gal Kit - 136 lbs
Flash Point (Setaflash)	Part A: 89 °F (32 °C) Part B: 84 °F (29 °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.