

Selection & Specification Data

Generic Type	Cross-linked epoxy
Description	Carboguard 8922 is a versatile corrosion resistant coating. May be topcoated with itself, or a broad variety of high performance finish coats. Carboguard 8922 has surface tolerant properties.
Features	<ul style="list-style-type: none"> • Ready to apply after mixing; no sweat-in time or thinning required. • Economical fit for use epoxy • Used as a primer or intermediate coat • Can be applied over power tool cleaned surfaces • Wet on wet application at 75 ° F (24 °C) substrate temperature • Acceptable over iron phosphate preparation
Color	Primer color (0700) gray
Finish	Satin
Dry Film Thickness	2 - 4 mils (51 - 102 microns) per coat
Solids Content	By Volume 61% +/- 2%
Theoretical Coverage Rate	978 ft ² /gal at 1.0 mils (24.0 m ² /l at 25 microns) 489 ft ² /gal at 2.0 mils (12.0 m ² /l at 50 microns) 245 ft ² /gal at 4.0 mils (6.0 m ² /l at 100 microns)
VOC Values	Allow for loss in mixing and application. Thinner 10 12 oz/gal: 3.20 lbs./gal (383 g/l) As Supplied 2.79 lbs./gal (335 g/l) These are nominal values and may vary slightly with color.
Dry Temp. Resistance	Continuous: 200 °F (93 °C) Non-Continuous: 250 °F (121 °C) Discoloration and loss of gloss is observed above 200°F (93°).
Limitations	Epoxies lose gloss, discolor and eventually chalk in sunlight exposure. Not recommended for immersion service.
Topcoats	May be coated with Acrylics, Epoxies, Alkyds, or Polyurethanes depending on exposure and need.

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	Also acceptable over SSPC SP2 & SSPC SP3 and over blasted steel (SSPC SP6) with a low 1-2 mil blast profile.
Phosphatized Steel	For most applications: Apply 8922 direct to dry, properly phosphatized substrate. Perform adhesion tests to ensure proper, uniform and acceptable adhesion of 8922 direct to phosphatized metal substrate.

Mixing & Thinning

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
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Mixing & Thinning

Thinning	Normally not required but may thin as follows: Spray: Up to 12 oz/gal (10%) w/ Thinner 10. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	1:1 Ratio (A to B)
Pot Life	3 Hours at 75°F (24°C) Pot life ends when coating loses body and begins to sag. Pot life times will be 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.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.070" I.D. fluid tip and appropriate air cap.
Airless Spray	<ul style="list-style-type: none"> • Pump Ratio: 30:1 (min.) • GPM Output: 2.5 (min.) • Material Hose: 3/8" I.D. (min.) • Tip Size: 0.017"-0.021" • Output PSI: 2100-2300 • Filter Size: 60 mesh <p>*PTFE packings are recommended and available from the pump manufacturer.</p>
Brush & 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 solvent resistant core.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	50 °F (10 °C)	50 °F (10 °C)	50 °F (10 °C)	0%
Maximum	90 °F (32 °C)	125 °F (52 °C)	110 °F (43 °C)	80%

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.

Carboguard[®] 8922

Curing Schedule

Surface Temp.*	Dry to Recoat	Dry to Handle	Maximum Recoat Time
50 °F (10 °C)	30 Minutes	12 Hours	1 Year
60 °F (16 °C)	10 Minutes	6 Hours	1 Year
75 °F (24 °C)	5 Minutes	3 Hours	1 Year
90 °F (32 °C)	2 Minutes	1 Hour	1 Year

These times are based on a 1.5-2.0 mil (37.5-50 micron) dry film thickness for non-immersion. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats. For force curing, contact Carboline Technical Service for specific requirements.

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 SDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation. Keep container closed when not in use.
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. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved respirator.

Packaging, Handling & Storage

Shelf Life	Part A & B: Min. 36 months at 75 °F (24 °C) <small>*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.</small>
Storage Temperature & Humidity	40-110 °F (4-43 °C) 0-100% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	2 Gallon Kit - 26 lbs. (12 kg) 10 Gallon Kit - 127 lbs. (58 kg)
Flash Point (Setaflash)	Part A: 62 °F (17 °C) Part B: 67 °F (19 °C)



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