

Selection & Specification Data

Generic Type	Organic Zinc-Rich Epoxy
Description	Low VOC organic zinc epoxy steel primer with extremely fast cure-to-topcoat characteristics for in-shop applications and quick turnaround requirements in the field. Carbozinc 859 has less than 3.0 lbs/gallon VOC (thinned) and is used extensively in virtually all industrial markets.
Features	<ul style="list-style-type: none"> ▪ Meets Class B slip co-efficient and creep testing criteria for use on faying surfaces ▪ Rapid cure. Dry to recoat in 30 minutes at 75°F (24°C) and 50% relative humidity. ▪ Low temperature cure down to 35°F (2°C) ▪ Excellent adhesion ▪ Protects against undercutting corrosion ▪ Available in ASTM D520, Type II zinc version ▪ Field proven primer that applies well by spray methods ▪ Excellent touch-up primer by brush or roll for small areas. ▪ VOC compliant to current AIM regulations
Color	Green (0300)
Finish	Flat
Primers	Self Priming
Topcoats	Can be topcoated with Epoxies, Polyurethanes, Acrylics and others as recommended by your Carboline sales representative. Under certain conditions, a mist coat is required to minimize topcoat bubbling.
Dry Film Thickness	3.0-5.0 mils (75-125 microns) Nominal. Dry film thickness. May be applied up 10.0 mils (250 microns) per coat.
Solids Content*	By Volume: 66% ± 2% *Tested in accordance with ASTM D2697
Zinc Content	By Weight: 81% ± 2% in dry film
Theoretical Coverage Rate	1,059 mil ft ² (24.0 m ² /l at 25 microns) 353 ft ² at 3.0 mils (8.0 m ² /l at 75 microns) Allow for loss in mixing and application
VOC Values	As Supplied: 2.72 lbs./gal (326 g/l) Thinned:* 13 oz/gal w/ #2: 3.12 lbs./gal (374 g/l) 13 oz/gal w/ #33: 3.15 lbs./gal (378 g/l) 13 oz/gal w/ #236e 2.72 lbs./gal (326 g/l) 13 oz/gal w/ #243e 2.72 lbs./gal (326 g/l) These are nominal values. *Use Thinner #76 for projects requiring non-photochemically reactive solvents.
Dry Temp. Resistance	Continuous: 400°F (204°C) Non-Continuous: 425°F (218°C)

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 minimum with a 1.0-3.0 mil (25-75 micron) nominal surface profile. Carbozinc 859 may be applied over any profile exceeding 1 mil. To achieve specified performance Carbozinc 859 must be applied at thickness to cover the profile by at least 3 mils. Calibrate dry film measurement tools accordingly. SSPC-SP2 or SP3 for touch-up.

Performance Data

Test Method	System	Results	Report #
ASTM D4541 Adhesion	A. Carbozinc 859	A. 841 psi Pneumatic	03343
	B. 859 / Polyurethane	B. 1,100 min. psi Pneumatic	03343
	C. 859/Epoxy/ Polyurethane	C. 585 psi Elcometer	03390
ASTM D522 Flexibility	A. 859	A. > 6%	03343
	B. 859 / Polyurethane	B. > 5%	
ASTM D2794 Impact	A. 859	A. 160 Gardner Impact Tester, Direct (intrusion), inch-pounds, over 1/8" steel	03343
	B. 859 / polyurethane		
Slip Co-Efficient	Carbozinc 859 A-490 bolt spec; 6 mils dry film maximum, 10% max. thinning	Meets requirements for class B rating	03617
ASTM D870 Immersion	A. Carbozinc 859/Epoxy/ Polyurethane Salt Water (5% sodium chloride) at 75°F, 30 days B. 859 / Epoxy / Polyurethane Fresh water at 75°F, 30 days	A & B had no rusting in the scribe; and no blistering, softening or discoloration with either environment	03390

Test reports and additional data available upon written request.

Application Equipment

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.

General Guidelines:

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: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .017-.023" Output PSI: 2000-2200 Filter Size: 60 mesh *Teflon packings are recommended and available from the pump manufacturer.
Brush/Roller	For small areas and touch-up only. Preferred method for large areas is spray application.

Mixing & Thinning

Mixing Power mix Part A completely. Then slowly sift in the zinc filler under agitation. Power mix Part B separately and add slowly to the mixture. Pour mixture through a 30 mesh screen. DO NOT MIX PARTIAL KITS.

Tip: Sifting zinc through a window screen will aid in mixing process by breaking up or catching dry zinc lumps.

	<u>.80 Gal Kit</u>	<u>4.00 Gal. Kit</u>
Ratio	Part A: .35 gallons	1.77 gallons
	Part B: .20 gallons	1 gallon
	Zinc Filler: 14.6 lbs	73 lbs

Thinning Normally not required but may be thinned up to 13 oz/gal (10%) with Thinner #2 or Thinner #76. In hot or windy conditions, may be thinned up to 13 oz/gal with Thinner #33. Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Carboline Thinner #236E may also be used to thin this product to minimize HAP and VOC emissions. Consult Carboline Technical Service for guidance.

Pot Life 4 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

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. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.

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.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	60°-85°F (16°-29°C)	60°-90°F (16°-32°C)	60°-90°F (16°-32°C)	0-90%
Minimum	40°F (4°C)	35°F (2°C)	35°F (2°C)	0%
Maximum	90°F (32°C)	120°F (49°C)	110°F (43°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.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Handle	Dry to Topcoat
35°F (2°C)	8 Hours	6 Hours
50°F (10°C)	5 Hours	2 Hours
75°F (24°C)	2 Hours	30 Minutes
100°F (32°C)	1 Hour	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. **Specific topcoat products can be used in a much shorter re-coat interval. Consult Carboline for recommendations and test results.**

Maximum Recoat: Unlimited. 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.

Packaging, Handling & Storage

Shipping Weight (Approximate)	<u>.80 Gallon Kit</u> 22 lbs (10 kg)	<u>4.00 Gallon Kit</u> 105 lbs (48 kg)
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Flash Point (Setaflash) Part A: 49°F (9°C)
Part B: 38°F (3°C)
Zinc Filler: NA

Storage (General) Store Indoors.

Storage Temperature & Humidity 40° – 110°F (4° - 43°C).
0-95% Relative Humidity

Shelf Life Part A: Min. 36 months at 75°F (24°C)
Part B: Min. 24 months at 75°F (24°C)
Part C: 24 months at 75°F (24°C)

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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