

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy-amine
Description	A modified epoxy formulated to provide outstanding corrosion resistance as a single-coat, direct-to-metal (DTM) exterior coating for railcars and other structures. While all epoxies will chalk and yellow under UV exposure; Carboguard 876 resists this effect better than most.
Color	White, Gray, Black and other colors available subject to minimum order.
Finish	High Gloss Initial gloss. Epoxies lose gloss and chalk upon exposure to UV.
Primer	None required; self-priming.
Dry Film Thickness	4 - 8 mils (102 - 203 microns) per coat
Solids Content	By Volume 75% +/- 2%
Theoretical Coverage Rate	1203 ft ² /gal at 1.0 mils (29.5 m ² /l at 25 microns) 301 ft ² /gal at 4.0 mils (7.4 m ² /l at 100 microns) 150 ft ² /gal at 8.0 mils (3.7 m ² /l at 200 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 1.75 lbs./gal mixed; 210 g/l mixed
Limitations	Epoxies may lose gloss, discolor and chalk when exposed to sunlight.

SUBSTRATES & SURFACE PREPARATION

General	All surfaces must be thoroughly cleaned to remove dirt, grease, mill scale, loose rust and any other contaminants that can reduce adhesion via SSPC-SP1 solvent cleaning before proceeding with recommended surface preparation.
Steel	Abrasive blast per SSPC-SP6 (NACE No. 3) to a Commercial Blast finish; with a 1.5-3 mils angular profile.

MIXING & THINNING

Mixing	Power mix each component separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
Thinning	Thin from 5-15% as needed with Thinner 76, 231, 214 or 245.
Ratio	1:1 by volume
Pot Life	3 hours @ 77 °F (25 °C)

Carboguard[®] 876

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.

Spray Application (General) | Listed below are general guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve desired results.

Airless Spray | 45:1 ratio pump with 0.017 - 0.019" diameter orifice for airless spray gun tip at a 2,800 psi recommended minimum fluid pressure at tip to obtain proper atomization.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	60°F (16°C)	70°F (21°C)	50°F (10°C)	0%
Maximum	90°F (32°C)	125°F (52°C)	110°F (43°C)	90%

Metal temperature at least 5 °F (3 °C) above the dew point.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Recoat	Dry Hard
77°F (25°C)	3 Hours	8 Hours	10 Hours

Note: recoat within 10 days @ 77 °F (25 °C)

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

Ventilation | When used as a tank lining or 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 supplied air respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life | Part A: 36 months
Part B: 36 months

Storage Temperature & Humidity | Store indoors: 40-110 °F (4-43 °C)
0-100% relative humidity

Storage | Store indoors.

Shipping Weight (Approximate) | 10-gal kits
12.3 lbs (5.4 kg) per gallon

PACKAGING, HANDLING & STORAGE

Flash Point (Setaflash) | Part A: 80 °F (26 °C)
Part B: 80 °F (26 °C)

WARRANTY

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