

SELECTION & SPECIFICATION DATA

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| Generic Type | Epoxy Polyamide |
| Description | Versatile corrosion resistant coating. Used either as a primer, intermediate coat, or self-priming finish over steel or zinc primers. May be topcoated with itself, or a broad variety of high performance finish coats. Has surface tolerant properties. It has versatile uses in the marine and offshore industries for both above and below the waterline. Carboguard 885 LT has 35°F cure capability (see separate data sheet). |
| Features | <ul style="list-style-type: none"> • Ready to apply after mixing; no sweat-in time or thinning required • Economical fit for use epoxy • Available in a variety of rapid tint colors • Attractive low sheen for tank exteriors • Used as a primer, intermediate, or finish coat • Power tool cleaned surfaces acceptable • Optional low temperature (LT) cure Part B • VOC compliant to current AIM regulations |
| Color | Primer color (0700) gray. Variety of other finish coat colors in rapid tint service. Use Bright White (F800) for tank exterior finish. |
| Finish | Satin |
| Primer | Self-priming. May be applied over zinc rich primers. A mist coat may be required to minimize bubbling over inorganic zinc rich primers. |
| Dry Film Thickness | <p>3 - 5 mils (76 - 127 microns) per coat as a primer or intermediate 4 - 6 mils (102 - 152 microns) per coat as a finish coat over a primer</p> <p>Do not exceed 10 mils (250 microns) in a single coat. Excessive film thickness over inorganic zincs may increase damage during shipping or erection.</p> |
| Solids Content | By Volume 62% +/- 2% |
| Theoretical Coverage Rate | <p>994 ft²/gal at 1.0 mils (24.4 m²/l at 25 microns) 331 ft²/gal at 3.0 mils (8.1 m²/l at 75 microns) 166 ft²/gal at 6.0 mils (4.1 m²/l at 150 microns) Allow for loss in mixing and application.</p> |
| VOC Values | <p>As Supplied : 2.80 lbs./gal 336 g/l Thinner 10 : 15 oz/gal 3.26 lbs./gal 391 g/l Thinner 236 E : 16 oz/gal 2.80 lbs./gal 336 g/l Thinner 243 E : 16 oz/gal 2.80 lbs./gal 336 g/l Thinner 33 : 16 oz/gal 3.31 lbs./gal 397 g/l</p> |
| Limitations | Epoxies lose gloss, discolor and eventually chalk in sunlight exposure. LT Cure will cause additional discoloration as it weathers and/or ages. When used for immersion projects the following colors need to be used: Red (A590), White (5839), Grey (C705), Buff (0217), and Black (C900) |
| Topcoats | May be coated with Acrylics, Epoxies, Alkyds, or Polyurethanes depending on exposure and need. |

SUBSTRATES & SURFACE PREPARATION

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| 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. |
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SUBSTRATES & SURFACE PREPARATION

Steel | For most applications: SSPC-SP6 to obtain a blast profile of 1.0-2.0 mils (25-50 microns). May also be applied over SSPC-SP 3 when needed.

Concrete or CMU | Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

| Test Method | System | Results |
|-----------------------|---------------------|---|
| ASTM D4541 Adhesion | Blasted Steel 2 ct. | 1600 psi (Pneumatic) |
| ASTM D522 Flexibility | Blasted Steel 1 ct. | 90 degree bend produced no cracking, 3/4 Cylindrical Mandrel Bend |

MIXING & THINNING

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

Thinning | Normally not required but may thin as follows: Spray: Up to 15 oz/gal (12%) wth Thinner # 10 Brush and Roll: Up to 4 oz/gal (3%) with Thinner #33. Thinner 236E or 243E may be used as an exempt thinner in lieu of those listed above. 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 | 4 Hours at 75°F (24°C) Pot life ends when coating thickens and loses application properties. 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 equipment manufacturers.

Conventional Spray | 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: 2.5 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .017"-.021"
Output PSI: 2100-2300
Filter Size: 60 mesh
*Teflon packings are recommended and available from the pump manufacturer.

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| Brush & Roller (General) | Not recommended for tank lining applications except when striping welds. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive rebrushing or re-rolling. For best results, tie-in within 10 minutes at 75°F (24°C). |
| Brush | Use a medium bristle brush. |
| Roller | Use 3/8" nap phenolic core roller. |

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) | 85% |

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. *Surface and ambient temperatures may be reduced to 35C when using the (LT) cure.

CURING SCHEDULE

| Surface Temp. | Dry to Recoat | Maximum Dry to Recoat for Immersion |
|---------------|---------------|-------------------------------------|
| 35°F (2°C) | NR | NR |
| 50°F (10°C) | 24 Hours | 30 Days |
| 60°F (16°C) | 10 Hours | 30 Days |
| 75°F (24°C) | 7 Hours | 30 Days |
| 90°F (32°C) | 4 Hours | 30 Days |

These times are based on a 4.0-6.0 mil (100-150 micron) dry film thickness for immersion. For atmospheric exposures (non-immersion) the recoat time is 12 months for all temperatures. 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

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| 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 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. |

Carboguard[®] 885

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

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| Shelf Life | Part A & B: Min. 36 months at 75°F (24°C) *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) 0-100% 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: 75°F (24°C) Part B: 75°F (24°C) Mixed: 75°F (24°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.