

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	High chemical resistant epoxy lining
<b>Description</b>	Carboguard 896 is a two component, high solids, modified epoxy formulated for use as a protective hopper lining with excellent resistance to fugitive acetic and hydrochloric acids often found in many plastic pellet cargoes.
<b>Features</b>	Dry bulk service for hopper cars carrying EVA, PTA, PTA, polyethylene (PE), polypropylene (PP), polystyrene (PS), polyvinyl chloride (PVC) plastic pellets, and other commodities, which may contain residual process acid. Also complies with 21CFR175.300(b)(3)(viii)(a).
<b>Color</b>	Beige, Lt. Blue, and other colors available subject to minimum order.
<b>Finish</b>	High Gloss
<b>Primer</b>	Welds should be striped with Carboguard 896S
<b>Wet Film Thickness</b>	7 to 8 mils per coat
<b>Dry Film Thickness</b>	5 - 7 mils (127 - 178 microns) per coat Two contrasting color coats are recommended to achieve a 10-14 total DFT.
<b>Typical Uses</b>	Dry bulk service for hopper cars carrying EVA, PTA, polyethylene (PE), polypropylene (PP), polystyrene (PS), polyvinyl chloride (PVC) plastic pellets, and other commodities, which may contain residual process acid.
<b>Solids Content</b>	By Volume 66% +/- 3%
<b>Theoretical Coverage Rate</b>	1059 ft <sup>2</sup> /gal at 1.0 mils (26.0 m <sup>2</sup> /l at 25 microns) 212 ft <sup>2</sup> /gal at 5.0 mils (5.2 m <sup>2</sup> /l at 125 microns) 151 ft <sup>2</sup> /gal at 7.0 mils (3.7 m <sup>2</sup> /l at 175 microns) Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 2.35 lbs/gal (282 g/l) Thinner 231 : 10%: 2.747 lbs/gal (329 g/l) Thinner 245 : 10%: 2.77 lbs/gal (332 g/l)
<b>Dry Temp. Resistance</b>	Continuous: 225°F (107°C)

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Surfaces must be clean and dry. Remove all dirt, dust, oil and all other contaminants.
<b>Steel</b>	Abrasive blast to SSPC-SP6, Commercial Blast. Anchor (surface) profile should be a sharp, angular and dense 2.5 to 3.5 mil profile.

## MIXING & THINNING

<b>Thinning</b>	Thin up to 10% by volume with Thinner 231 or Thinner 245. Use Thinner 245 for finish coat.
<b>Ratio</b>	1:1 by volume (Part A to Part B)
<b>Pot Life</b>	3 hours at 77 °F (25 °C)

### 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.

**Airless Spray** | • Pump Ratio: 45:1  
• Gun Tip: 0.017" to 0.019"  
• Output PSI: 2,800 minimum fluid pressure at tip to obtain proper atomization

**Brush** | A small brush can be used for touch-up or small repair areas.

### APPLICATION CONDITIONS

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

Metal temperature at least 5 deg. above the dew point

### CURING SCHEDULE

Surface Temp.	Set to Touch	Tack Free	Dry Hard	Dry to Recoat
75°F (24°C)	3 Hours	6 Hours	10 Hours	12 Hours

**Note:** Normal recoat is within 72 hours at 75 °F (24 °C).

**Air Dry Schedule:** Circulate warm air at 85-90°F (29-32 °C) for 12 hours minimum. Perform holiday test for discontinuities. All touch-ups must be made before force cure.

**Force Cure Schedule:** Contact Carboline Transportation for specific force curing information.

### CLEANUP & SAFETY

**Cleanup** | Use Thinner 2 or Acetone.

**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.

### PACKAGING, HANDLING & STORAGE

**Shelf Life** | Part A: 12 months  
Part B: 12 months

**Shipping Weight (Approximate)** | Part A - 10.92 lbs/gal  
Part B - 11.14 lbs/gal

**Flash Point (Setaflash)** | Part A: 61 °F (16 °C)  
Part B: 81 °F (27 °C)

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## **WARRANTY**

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