

SELECTION & SPECIFICATION DATA

Generic Type	Modified epoxy
Description	High solids, modified amine cured epoxy formulated for corrosion resistance as a direct-to-metal(DTM) exterior coating for railcars.
Color	White, Gray, and Black
Finish	Semi-Gloss
Primer	None required.
Wet Film Thickness	5.0 - 9.0 mils
Dry Film Thickness	4 - 8 mils (102 - 203 microns) per coat
Solids Content	By Volume 83% +/- 2%
Theoretical Coverage Rate	1331 ft ² /gal at 1.0 mils (32.7 m ² /l at 25 microns) 333 ft ² /gal at 4.0 mils (8.2 m ² /l at 100 microns) 166 ft ² /gal at 8.0 mils (4.1 m ² /l at 200 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 1.2 lbs./gal (140g/l)
Limitations	Epoxies may lose gloss, discolor and chalk when exposed to sunlight.
Topcoats	Not Applicable

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Remove dirt, dust, oil and all other contaminant.
Steel	Prepare steel surface according to NACE No.3/SSPC-SP 6 Commercial Metal Blast. When viewed under magnification, the surface must have a sharp, angular, dense profile with a 2-3 mil profile.

MIXING & THINNING

Mixing	Power mix each component separately, then combine and power mix.
Thinning	Thinner #2, Thinner #10, Thinner #231, Thinner #245 or Thinner #235 up to 15%.
Ratio	1:1 by volume
Pot Life	3 hours @ 77°F

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)	45:1 ratio pump with 0.017 (617) to 0.019 (619) inch diameter orifice for airless spray gun tip at a 2,800 psi recommended minimum fluid pressure at tip to obtain proper atomization. An artist brush can be used for touchup of WFT marks and other small repair areas.
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Carboguard[®] 876 HS

PRODUCT DATA SHEET



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)	130°F (54°C)	110°F (43°C)	90%

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry to Recoat
77°F (25°C)	2 Hours	10 Hours	12 Hours

Note: recoat within 10 days @ 77°F

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.
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 now sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months
Storage Temperature & Humidity	40°-110°F (4°-43°C) 0-100% Relative humidity
Storage	Store indoors
Shipping Weight (Approximate)	Part A 12.3 lbs./gal. Part B 11.1 lbs./gal
Flash Point (Setaflash)	Part A = 83°F Part B = 78°F

WARRANTY

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