

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.
Non-Ferrous Metals	Surface profile should be a dense angular 1.5 - 3 mils and is best achieved through abrasive blasting in accordance with SSPC-SP16 for atmospheric exposure, or SSPC-SP17 for immersion environments.

MIXING & THINNING

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

Carboguard[®] 876 HS

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) | 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.

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

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.