

SELECTION & SPECIFICATION DATA

Generic Type	Two component zinc filled, cross linked polyamide epoxy primer.
Description	Carbozinc 658 P is high solids, organic zinc epoxy primer, for protection of structural steel in salt or weathering environments. Excellent as a maintenance or general use zinc epoxy primer over blasted steel. Used within industry, petrochemical process, offshore or other heavy industries in severe environments with appropriate topcoats. Recommended for shop application where fast handling and re-coating are requested.
Features	<ul style="list-style-type: none"> • Easily applicable. • Cures at low temperatures, 2°C (35°F). • Hard tough film. • Good flexibility. • Excellent abrasion resistance.
Color	Gray-Green.
Finish	Flat
Primer	Normally self-priming. May be applied over Carboweld 11 P.
Dry Film Thickness	76 microns (3 mils) per coat
Solid(s) Content	By Volume: 56% ± 2%
Theoretical Coverage Rates	5.25 m ² /Kg at 40 microns 2,80 m ² /Kg at 75 microns Allow for loss in mixing and application.
Zinc Content by Weight	81 % ± 2 % in dry film.
VOC Values	As Supplied : 350 g/l
Dry Temp. Resistance	Continuous: 110°C (230°F) Non-Continuous: 82°C (180°F)
Topcoats	May be coated with epoxies, polyurethanes and others as recommended by the Carboline Technical Service.

SUBSTRATES & SURFACE PREPARATION

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.
Steel	SSPC-SP 10 - ISO 8501-1 Sa 2 ½ blast profile: 30-50 micron (1,5 – 2,0 mils).

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix for a minimum of two minutes. DO NOT MIX PARTIAL KITS. Maturation of 5 minutes before use.
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Carbozinc 658P

PRODUCT DATA SHEET



MIXING & THINNING

Thinning	Up to 25% by volume, with Thinner #15. Use of thinners other than those supplied by Carboline, may adversely affect product warranty, whether expressed or implied.
Ratio	By Weight: Parte A: 93 Parte B: 7
Pot Life	20°C at 8 hours lower at more elevated temperature. Pot life ends when coating loses body and begins to sag.

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.

General	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Conventional Spray	Agitated pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, with a maximum length of 15 m, .070" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 GPM Output: 3.0 (min.) 11.5 liters/min. Material Hose: 3/8" I.D. (min.) Tip Size: .017-.021" Output PSI: 2000-2200 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Recommended for touch up, striping of weld seams and hard-to-coat areas.
Brush	Use a medium bristle brush.
Roller	Not Recommended.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	4°C (39°F)	0%
Maximum	32°C (90°F)	50°C (122°F)	45°C (113°F)	95%

Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions. Do not apply when the surface temperature is less than 3°C above the DEW- POINT.

CURING SCHEDULE

Surface Temp.	Minimum Recoat Time	Final Cure
2°C (36°F)	8 Hours	12 Hours
10°C (50°F)	6 Hours	8 Hours
24°C (75°F)	3 Hours	6 Hours
27°C (81°F)	2 Hours	4 Hours

These times are based on a 75 microns (3 mils) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

CLEANUP & SAFETY

Cleanup	Use Thinner #2. 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.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with the National Electric Code. In areas where explosion hazards exist, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 12 months at 24 °C Part B: 24 months at 24 °C
Shipping Weight (Approximate)	Part A: 23,25 Kg Part B: 1,75 Kg
Storage Temperature & Humidity	4°- 43 °C 0 - 95 % RH
Flash Point (Setaflash)	Parte A: 5 °C Parte B: 14 °C
Storage	Store Indoors.

Carbozinc 658P

PRODUCT DATA SHEET



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.