

SELECTION & SPECIFICATION DATA

Generic Type	Modified single package zinc rich phenoxy
Features	<ul style="list-style-type: none"> • An excellent maintenance or general use shop primer • High zinc content provides galvanic cathodic protection • Readily topcoated with a wide variety of topcoats • Has been used in pulp & paper industries, chemical processing, petroleum refining and others • Normally recommended to touch up inorganic zincs • Excellent flexibility • Excellent weathering • Very good abrasion resistance • Normally used only over clean metal surfaces • Can be used to touch up inorganic zincs • Not recommended for immersion service or exposure to pH above 10 or below 5 without suitable topcoat
Color	Grey only
Finish	Flat (0-10)
Dry Film Thickness	75 Microns
Solid(s) Content	By Volume 37% ± 2%
Zinc Content in Dry Film	By Volume 86%
Theoretical Coverage Rates	4.9m ² /litre at 75 microns NOTE: Material losses during mixing and application may vary and must be taken into consideration when estimating job requirements.
Dry Temp. Resistance	Continuous: 82°C (180°F) Non-Continuous: 110°C (230°F)
Topcoats	May be topcoated with acrylic, epoxy tar, vinyl or others as recommended
Density	An easy to apply maintenance coating. Being single package, the material has no pot life.

SUBSTRATES & SURFACE PREPARATION

General	Remove any oil or grease from surface to be coated prior to abrasive blasting.
Steel	For non-immersion, dry abrasive blast to a commercial grade finish in accordance with ISO 8501 Sa2 to obtain a 25 to 75 micron blast profile.

MIXING & THINNING

Mixing	Power mix Carbozinc 676 to a smooth consistency before thinning.
Thinning	Thin up to 18% by volume with Thinner # 76. NOTE: Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether express or implied.

Carbozinc 676

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 | Use sufficient air volume for correct operation of equipment.
Use agitated pot. Maximum 15m hose. Keep pot at same elevation as gun. If spraying stops for more than 15 minutes, blow the material from hose back into the pot.
Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

Conventional Spray | Use a 10mm minimum I.D. material hose. Hold gun 300 to 350mm from the surface and at a right angle to the surface.
Gun:905 Spray Gun
Fluid Tip:1.8mm
Air Cap:905-PV

Airless Spray | Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface.
Gun:TRITECH T360 Spray Gun
Pump:47:1

* Teflon packings are recommended and available from the pump manufacturer. Use a .017 to .019" tip with 2400 psi.

Brush | For touch-up only. Use medium bristle brush and apply full strokes. Avoid rebrushing.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	4°C (39°F)	4°C (39°F)	0%
Maximum	43°C (109°F)	43°C (109°F)	43°C (109°F)	85%
Optimum	24°C (75°F)	27°C (81°F)	24°C (75°F)	45%

Do not apply when the surface temperature is less than 3°C above the dew point.
Special thinning and application techniques may be required above or below normal conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat
4°C (39°F)	16 Hours	48 Hours
10°C (50°F)	12 Hours	24 Hours
16°C (61°F)	8 Hours	12 Hours
25°C (77°F)	2 Minutes	4 Hours
32°C (90°F)	1 Minute	2 Hours

Curing Details | Relative Humidity: 50%

CLEANUP & SAFETY

Cleanup | Use Thinner # 2

PACKAGING, HANDLING & STORAGE

Shelf Life	12 Months minimum when stored at 25°C *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	5 Litre Carbozinc 676: 11.2kg Thinner # 76: 4.8kg
Storage Temperature & Humidity	4 to 43°C 0 to 100%
Flash Point (Pensky Martens Closed Cup)	Carbozinc 676: 20°C Thinner # 76: -2°C
Storage	Store indoors

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.