Carbozinc 858

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Two-component zinc-filled cross-linked epoxy primer
Description	Carbozinc 858 is a high solid, organic zinc epoxy primer designed for corrosion protection of structural steel in salt and weathering environments. The paint is easy to apply and protects steel galvanically. Provides tough and abrasion resistant film.
Features	• Outstanding application properties • Protects steel galvanically • Cures at low temperatures down to 2°C • Cured film is tough and abrasion resistant • Widely used within petrochemical, offshore shipping and other heavy industries in severe environments with appropriate topcoat • No induction time • Prequalified in accordance with NORSOK M-501, Rev. 6, System 1
Color	Bluish grey
Finish	Flat (0-10)
Wet Film Thickness	80 to 230µm per coat
Dry Film Thickness	50 to 150µm per coat
Solid(s) Content	By volume: 65% ± 2% Zinc content in dry film: 84%
Theoretical Coverage Rates	13m²/litre at 50µm 4.3m²/litre at 150µm Allow for loss in mixing and application
Dry Temp. Resistance	Continuous: 150°C (302°F) Non-Continuous: 200°C (392°F)
Limitations	Not recommended for direct exposure to strong acids and alkalies.
Topcoats	May be topcoated with epoxy, polyurethane or others as recommended by StonCor Africa.

SUBSTRATES & SURFACE PREPARATION

General	Surface 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	ISO 8501-1:2007 - Sa2 minimum ISO 8501-1:2007 - St3 for touch-ups

MIXING & THINNING

Mixing	Power mix separately, then add Part B to Part A and power mix well. DO NOT MIX PARTIAL KITS.
Thinning	Normally not required. May be thinned up to 10% with Carboline Thinner # 2.
Ratio	3 : 1 (A to B) by volume

MIXING & THINNING

Pot Life | 4 Hours at 24°C and longer at lower temperatures.

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.

Conventional Spray | Agitated pressure pot equipped with dual regulators, 10mm ID minimum material hose, with a maximum length of 8m to 10m max; 1.8mm nozzle and air cap ID fluid tip and appropriate air cap.

Airless Spray |
Pump ratio: 30:1 (min.)
GPM Output: 3.0 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: 0.017-0.021"
Output PSI: 2000-2200 (140-160 kg/cm²)
Filter Size: 60 mesh

Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) | Recommended for touch-up, stripe coating and hard-to-reach areas.

Brush | Recommended using a soft bristle brush.

Roller | Generally not recommended for priming purposes.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	30°C (86°F)	50°C (122°F)	45°C (113°F)	95%

CURING SCHEDULE

Surface Temp.	Dry to Handle or Recoat	Final Cure
2°C (36°F)	8 Hours	10 Days
10°C (50°F)	5 Hours	5 Days
24°C (75°F)	2 Hours	3 Days
32°C (90°F)	1 Hour	2 Days

CLEANUP & SAFETY

Cleanup | Use Carboline 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 MSDS 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.

CLEANUP & SAFETY

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 applicable regulations. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conducting and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 12 months at 24°C Part B: 2 years at 24°C
Storage Temperature & Humidity	5°C to 45°C 0 to 95% relative humidity
Storage	Store indoors.
Packaging	Part A: 3.75 litres Part B: 1.25 litres

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