

SELECTION & SPECIFICATION DATA

Generic Type	Polyamide Epoxy
Description	Carboguard 894 is a high performance, versatile, immersion-grade, VOC compliant, high build, self-priming epoxy. It is suitable for industrial and marine environments in fresh or salt water immersion. It can also be used for tank exteriors, structural steel, piping, or process equipment. Carboguard 894 may be used on barges, vessels and other marine applications where a high quality epoxy is needed.
Features	<ul style="list-style-type: none"> • Immersion- grade epoxy • High solids, low VOC • Excellent adhesion • Excellent flexibility • Long recoat window
Color	Refer to Carboline color chart.
Finish	Satin (25-35)
Primer	Self-priming
Dry Film Thickness	127 - 178 microns (5 - 7 mils) per coat (Two coats are normally required for immersion service)
Solids Content	By Volume 86% +/- 2%
Theoretical Coverage Rate	33.9 m ² /l at 25 microns (1379 ft ² /gal at 1.0 mils) 6.8 m ² /l at 125 microns (276 ft ² /gal at 5.0 mils) 4.8 m ² /l at 175 microns (197 ft ² /gal at 7.0 mils) Allow for loss in mixing and application.
VOC Values	As Supplied : 1.0 lbs/gal (120 g/l)
Topcoats	May be coated with Polyurethanes depending on exposure and need.

SUBSTRATES & SURFACE PREPARATION

General	All surfaces must be thoroughly cleaned to remove dirt, grease, mill scale, loose rust, chalk, and any other contaminants that can reduce adhesion via SSPC-SP1 solvent cleaning.
Steel	Sandblasting is recommended to remove rust and mill scale. Use commercial blast to SSPC-SP6 for mild exposures and nearwhite blast SSPC-SP10 for immersion service. SSPC-SP2 or SP3 are suitable cleaning methods for mild environments.
Concrete or CMU	Cure for at least 30 days before painting. Remove loose or excess mortar, efflorescence, laitance and concrete form release compounds that reduce adhesion.
Previously Painted Surfaces	Scrape loose, scaly, peeling paint and sand the edges smooth. If the paint is glossy, sand to dull the surface. Remove any rust and scale from ferrous metal. If mildew is present, remove completely by sterilizing the surface with mildew remover and detergent. Rinse well and allow to dry before painting.
Special Instruction	Do not apply over moisture or in dampness. Exterior exposure causes color change, gloss loss and chalking within one year, however, this does not affect protective performance properties.

Carboguard 894

PRODUCT DATA SHEET



MIXING & THINNING

Mixing	Thoroughly mix each component using mechanical agitation. Pour the activator, part B, into part A (mixing ratio by volume: 1 part activator, part B, to 1 part, part A) and mix well using mechanical agitation.
Thinning	Mixed Carboguard 894 may be thinned up to allowable local VOC regulations with Thinner 248.
Pot Life	8 hours at 75°F. Allow 15 minutes induction time at 75°F. Do not mix more than can be applied during the product's useful pot life.

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)	Apply using airless spray. Use a 50% overlap with each pass when spraying to eliminate holidays and pinholes.
Airless Spray	Apply using pump able to deliver a minimum of 3000 psi. Material Hose: 3/8" I.D. (min.) Tip Size: .019 - .023" High Pressure Filter: 30 Mesh
Brush	natural bristle or nylon/polyester
Roller	1/4-3/8" woven/phenolic core for smooth surfaces, 3/4-1 1/4" nap for rough surfaces

CURING SCHEDULE

Surface Temp.	Dry to Recoat	Dry to Touch	Final Cure
10°C (50°F)	36 Hours	18 Hours	21 Days
24°C (75°F)	18 Hours	6 Hours	7 Days
32°C (90°F)	9 Hours	3 Hours	3 Days

The above cure times are based on 5 mils (125 microns). This product simply requires the substrate temperature to be above the dew point. 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.

CLEANUP & SAFETY

Cleanup	Clean up all tools and equipment promptly with Thinner #2.
Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 36 months Part B: 36 months *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	<u>2 Gal Kit</u> 28 lbs <u>10 Gal Kit</u> 136 lbs
Storage Temperature & Humidity	40° - 110°F (4°-43°C) 0-90% Relative Humidity
Flash Point (Setaflash)	94°F
Storage	Store Indoors.

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