

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Phenalkamine Epoxy with Zinc Phosphate
<b>Description</b>	High performance surface tolerant epoxy mastic with short recoating interval and excellent corrosion protection.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Fast recoat times</li> <li>• Used as a primer or intermediate coat</li> <li>• VOC compliant to current AIM regulations</li> <li>• Meets requirement of ISO 12944 C5 High when used as a part of predefined paint system</li> <li>• Surface tolerant and Moisture tolerance during application</li> <li>• MIO version is available</li> </ul>
<b>Color</b>	Red (0500) and Grey (0700)
<b>Finish</b>	Satin to Low Sheen Semi-Gloss
<b>Primer</b>	May be applied over zinc rich primers. A mist coat may be required to minimize bubbling over inorganic zinc rich primers.
<b>Dry Film Thickness</b>	76 - 178 microns (3 - 7 mils) per coat
<b>Solids Content</b>	By Volume 75% +/- 2%
<b>Theoretical Coverage Rate</b>	29.5 m <sup>2</sup> /l at 25 microns (1203 ft <sup>2</sup> /gal at 1.0 mils) 9.8 m <sup>2</sup> /l at 75 microns (401 ft <sup>2</sup> /gal at 3.0 mils) 4.2 m <sup>2</sup> /l at 175 microns (172 ft <sup>2</sup> /gal at 7.0 mils) Allow for loss in mixing and application.
<b>VOC Value(s)</b>	As Supplied : 220 g/l
<b>Dry Temp. Resistance</b>	Continuous: 93°C (199°F) Non-Continuous: 121°C (250°F) Discoloration and loss of gloss is observed above 93°C (200°F).
<b>Limitations</b>	Epoxies lose gloss, discolor and eventually chalk in sunlight exposure. Discoloration is more pronounced with this product. Not recommended for immersion service.
<b>Topcoats</b>	Acrylics, Alkyds, Epoxies, Polyurethanes

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	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.
<b>Steel</b>	For most applications: SSPC-SP6 (ISO 8501 Sa 2 ½) to obtain a blast profile of 1.0-2.0 mils (25-50 microns).
<b>Galvanized Steel</b>	Galvanizing requires a roughened surface for optimum adhesion/performance of high build epoxies. Remove any contaminants per SSPC SP1; ensure there are no chemical treatments that may interfere with adhesion; and abrade the surface to establish a suitable roughness (typically 1 mil). SSPC-SP7 or SP11 are acceptable methods.

# Carboguard 614

## PRODUCT DATA SHEET



### SUBSTRATES & SURFACE PREPARATION

<b>Stainless Steel</b>	Use non-metallic blast media (Corundum, Garnet, etc.). Sweep blasting to a uniform dense sharp profile, without blank spots.
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### MIXING & THINNING

<b>Mixing</b>	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
<b>Thinning</b>	<ul style="list-style-type: none"><li>• Airless Spray: Up to 15% with Thinner #80</li><li>• Brush &amp; Roller: Up to 5% with Thinner #80</li></ul>
<b>Ratio</b>	6:1 Ratio (A to B) By Volume
<b>Pot Life</b>	2 Hours at 25°C Pot life ends when coating thickens and loses application properties. Pot life times will be less at higher 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.

<b>Spray Application</b>	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.070" I.D. fluid tip and appropriate air cap.
<b>Airless Spray</b>	<ul style="list-style-type: none"><li>• Pump Ratio: 30:1 (min.)*</li><li>• GPM Output: 2.5 (min.)</li><li>• Material Hose: 3/8" I.D. (min.)</li><li>• Tip Size: 0.015"-0.021"</li><li>• Output PSI: 2100-2300</li><li>• Filter Size: 60 mesh</li></ul> <p>*PTFE packings are recommended and available from the pump manufacturer.</p>
<b>Brush &amp; Roller (General)</b>	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 75°F (24°C).
<b>Brush</b>	Use a medium bristle brush.
<b>Roller</b>	Use 3/8" nap phenolic core roller.

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	32°C (90°F)	52°C (126°F)	43°C (109°F)	85%

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.

## CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Recoat	Maximum Recoat Time
5°C (41°F)	12 Hours	2 Days	60 Days
15°C (59°F)	4 Hours	8 Hours	45 Days
25°C (77°F)	60 Minutes	2.5 Hours	30 Days
35°C (95°F)	30 Minutes	1.5 Hours	15 Days

These times are based on 50% relative humidity and 3.0-4.0 mil (75-100 micron) dry film thickness for atmospheric exposures. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats. For force curing, contact StonCor ME Technical Service for specific requirements.

## CLEANUP & SAFETY

<b>Cleanup</b>	Use Thinner #80. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	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.
<b>Ventilation</b>	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.
<b>Caution</b>	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

<b>Shelf Life</b>	Part A & B: Min. 12 months at 75°F (24°C)  *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
<b>Shipping Weight (Approximate)</b>	19 liter kit (Approximately 30 kg)

# Carboguard 614

## PRODUCT DATA SHEET



## PACKAGING, HANDLING & STORAGE

<b>Storage Temperature &amp; Humidity</b>	<ul style="list-style-type: none"><li>• 40° - 110°F (4° - 43°C)</li><li>• 0-100% Relative Humidity</li></ul>
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<b>Flash Point (Setaflash)</b>	<ul style="list-style-type: none"><li>Part A: &lt;25°C</li><li>Part B: &lt;25°C</li></ul>
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<b>Storage</b>	Store Indoors.
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## WARRANTY

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