

SELECTION & SPECIFICATION DATA

Generic Type	Two-component, zinc-rich epoxy primer
Description	A two-component, high solids, economical zinc rich epoxy primer formulated for the protection of properly prepared steel substrates. This product can be applied by conventional, and airless spray.
Features	<ul style="list-style-type: none"> • Excellent application properties • Excellent adhesion & undercutting resistance • Fast drying for quick recoating
Color	Grey (0700)
Finish	Flat
Dry Film Thickness	51 - 76 microns (2 - 3 mils) per coat For more severe environments CZ 655 may be applied at 4 mils (100 microns) dry film thickness.
Solids Content	By Volume 62% +/- 2%
Theoretical Coverage Rate	24.4 m ² /l at 25 microns (994 ft ² /gal at 1.0 mils) 12.2 m ² /l at 50 microns (497 ft ² /gal at 2.0 mils) 8.1 m ² /l at 75 microns (331 ft ² /gal at 3.0 mils) Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 149°C (300°F) Non-Continuous: 200°C (392°F)
Topcoats	May be coated with epoxies or polyurethanes depending on exposure and need.

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. Use Thinner #2 or Carboline Surface Cleaner #3 in accordance with SSPC-SP1.
Steel	Abrasive blast to a commercial finish in accordance with SSPC-SP6 and obtain a 1½ - 2 mil (37.5-50micron) blast profile.
Phosphatized Steel	Apply directly to dry, properly phosphatized substrate. Perform adhesion tests to insure proper, uniform and acceptable adhesion direct to phosphatized metal substrate.

MIXING & THINNING

Mixing	For plural component application equipment follow the equipment manufacturer's instructions. Power mix each component separately prior to using plural component spray equipment or batch mixing. THIS PRODUCT IS MOISTURE SENSITIVE. AVOID MOISTURE CONTAMINATION. DO NOT MIX PARTIAL KITS.
Thinning	Normally not required for plural heated application. For batch mix applications, it may be thinned up to 6.5 oz/gal (5%) with Thinner #2. For hotter than normal application conditions it may be thinned 3.8 oz/gal with Thinner #33. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Carbozinc 655

PRODUCT DATA SHEET



MIXING & THINNING

Ratio | 3:1 (A:B)

Pot Life | 3 Hours at 75°F (24°C) unthinned. Pot life decreases at higher temperatures. Pot life ends when coating becomes too viscous to use. This product is moisture sensitive. Avoid moisture contamination.

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 | The following spray equipment has been found suitable and is available from equipment manufacturers.

Conventional Spray | Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.

Non-Plural
Pump Ratio: 30:1 (min.)
GPM Output: 3.0 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .015-.019"
Output PSI: 2100-2300
Filter Size: 30-60 mesh
***Teflon packings are recommended and available from the pump manufacturer**

Airless Spray | Heated, Plural Component
Pump Ratio: Graco 35:1 (min)
GPM Output: 3.5 (min)
Lower Units: Two (2) #0, One (1) #5
Heaters: One (1) Graco Viscon (A side)
Material Hose: 50' x 3/8" I.D.
Mixer: 10" static
Tip Size: .015-.019"
Output psi: 2400-2800
Filter Size: 30-60 mesh (in-line)
Solvent Flush Pump Ratio: 10:1

Brush | Respray or brush. Brushing recommended only for touchup of small areas. Use medium, natural bristle brush applying with full strokes. Avoid excessive rebrushing.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	32°C (90°F)	49°C (120°F)	43°C (109°F)	90%

Do not apply when the surface temperature is less than 5°F (3°C) 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 thinning and application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Topcoat
2°C (36°F)	24 Hours	10 Hours
10°C (50°F)	18 Hours	5 Hours
24°C (75°F)	6 Hours	2 Hours
32°C (90°F)	3 Hours	60 Minutes
40°C (104°F)	30 Minutes	30 Minutes

50% Relative Humidity

*Dry to Topcoat - These times are based on 50-75 microns dry film thickness allowing solvent release and initial curing prior to topcoating. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Must have a clean, dry surface for topcoating.

CLEANUP & SAFETY

Cleanup	Use 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. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 12 months at 75°F (24°C) Part 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.
Shipping Weight (Approximate)	3.8 Liters - 8 Kg 19 Liters - 40 Kg
Storage Temperature & Humidity	Storage Temperature: 40-95 °F (4-35 °C) Relative Humidity: 0-90%
Flash Point (Setaflash)	Part A: 64°F (18°C) Part B: 69°F (20°C)
Storage	Store indoors

Carbozinc 655

PRODUCT DATA SHEET



TYPICAL CHEMICAL RESISTANCE

Exposure	Fumes	Splashes & Spills
Acids	Excellent	Very Good
Alkalies	Excellent	Very Good
Salt	Excellent	Excellent
Solvents	Excellent	Very Good
Water	Excellent	Excellent

*Splash & Spillage for Solvents - Resistance may vary dependent on the type of solvent involved.

*Acids & Alkalies ratings based on proper finish coat.

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 to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. 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. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.