

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Two-component zinc filled, cross linked epoxy primer
<b>Description</b>	Low VOC organic zinc epoxy steel primer with quick cure-to-topcoat characteristics for in-shop applications and quick turnaround requirements in the field. Carbozinc 858 has very good adhesion and undercutting resistance and is excellent for use as a corrosion resistant primer for a variety of applications.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Ready to apply as supplied</li> <li>• Meets SSPC Paint System 20</li> <li>• Low temperature cure down to 35°F (2°C)</li> <li>• Protects against undercutting corrosion</li> <li>• May be applied with standard airless or conventional spray equipment</li> <li>• VOC compliant to current AIM regulations</li> </ul>
<b>Color</b>	Grey
<b>Finish</b>	Matte
<b>Primer</b>	Self Priming
<b>Dry Film Thickness</b>	51 - 152 microns (2 - 6 mils) per coat Dry film thickness in excess of 8.0 mils (200 microns) per coat is not recommended.
<b>Solids Content</b>	By Volume 61% +/- 2%
<b>Zinc Content in Dry Film</b>	By Weight 80%
<b>Theoretical Coverage Rate</b>	24.0 m <sup>2</sup> /l at 25 microns (978 ft <sup>2</sup> /gal at 1.0 mils) 12.0 m <sup>2</sup> /l at 50 microns (489 ft <sup>2</sup> /gal at 2.0 mils) 4.0 m <sup>2</sup> /l at 150 microns (163 ft <sup>2</sup> /gal at 6.0 mils) Allow for loss in mixing and application.
<b>VOC Value(s)</b>	As Supplied: 3.0 lbs./gal (360 g/l)
<b>Dry Temp. Resistance</b>	Continuous: 149°C (300°F) Non-Continuous: 200°C (392°F)
<b>Topcoats</b>	Can be topcoated with Epoxies, Polyurethanes, Acrylics and others as recommended by your StonCor ME sales representative.

## 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>	SSPC-SP6 with a 1.0-3.0 mils (25-75 microns) surface profile. SSPC-SP2 or SP3 for touch-up.

## MIXING & THINNING

<b>Mixing</b>	Power mix Part A and Part B separately, then combine and power mix for a minimum of two minutes. DO NOT MIX PARTIAL KITS.
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# Carbozinc 680

## PRODUCT DATA SHEET



### MIXING & THINNING

<b>Thinning</b>	Normally not required but may be thinned up to 7 oz/gal (6%) with Thinner #2. Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
<b>Ratio</b>	3:1 by volume <u>10-Liter Kit</u> Part A: 7.5 liters Part B: 2.5 liters
<b>Pot Life</b>	4 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag.

### 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. Keep material under mild agitation during application.
<b>Conventional Spray</b>	Agitated pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap.
<b>Airless Spray</b>	Pump Ratio: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .017-.023" Output PSI: 2100-2500 Filter Size: 60 mesh  *Teflon packings are recommended and available from the pump manufacturer.
<b>Brush</b>	For small areas and touch-up only. Use medium bristle brush and avoid rebrushing.
<b>Roller</b>	Not recommended

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	32°C (90°F)	49°C (120°F)	43°C (109°F)	95%

Industry standards are for the substrate temperatures to be 5°F (3°C) above the dew point. 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 Handle	Dry to Topcoat
2°C (36°F)	8 Hours	10 Hours
10°C (50°F)	5 Hours	6 Hours
24°C (75°F)	2 Hours	3 Hours
32°C (90°F)	60 Minutes	60 Minutes

### \*50% Relative Humidity

Dry to touch at 75°F (24°C) is 30 minutes.

These times are based on a 3.0 mils (75 microns) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Maximum Recoat: Unlimited. Must have a clean, dry surface for top coating. "Loose" chalk or salts must be removed in accordance with good painting practice. Consult StonCor ME Technical Service for specific information.

## CLEANUP & SAFETY

<b>Cleanup</b>	Use Thinner #2 or Acetone. 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 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.
<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. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.
<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, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

## PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	Part A: Min. 6 months at 75°F (24°C) Part B: Min. 12 months at 75°F (24°C)  <b>*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.</b>
<b>Shipping Weight (Approximate)</b>	10 Liters: 57 lbs (26 Kg)
<b>Storage Temperature &amp; Humidity</b>	Storage Temperature: 40° – 110°F (4° - 43°C) Relative Humidity: 0-95%
<b>Flash Point (Setaflash)</b>	Part A: 48°F (9°C) Part B: 38°F (3°C)
<b>Storage</b>	Store indoors

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## PRODUCT DATA SHEET

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### WARRANTY

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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.