

SELECTION & SPECIFICATION DATA

Generic Type	Zinc-Rich Epoxy Primer
Description	Steel primer with extremely fast cure-to-topcoat characteristics for in-shop applications and rapid-turnaround requirements in the field. Carbozinc 860 ME has less than 3.0 lbs/gallon VOC (thinned) and is used extensively in virtually all industrial markets.
Features	<ul style="list-style-type: none"> • Rapid cure. Dry to recoat in 30 minutes at 75°F (24°C) and 50% relative humidity • Low temperature cure down to 35°F (2°C) • Excellent adhesion and undercutting resistance • May be applied with standard airless or conventional spray equipment • 90% total zinc in the dry film
Color	Grey (0700)
Finish	Flat
Primer	Self-priming
Dry Film Thickness	51 - 102 microns (2 - 4 mils) per coat Dry film thickness in excess of 8.0 mils (200 microns) per coat is not recommended.
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) 6.1 m ² /l at 100 microns (249 ft ² /gal at 4.0 mils) Allow for loss in mixing and application.
Zinc Content by Weight	90% +/- 2% in dry film
VOC Value(s)	As Supplied: 325 g/l These are nominal values.
Dry Temp. Resistance	Continuous: 149°C (300°F) Non-Continuous: 177°C (351°F)
Topcoats	Can be topcoated with epoxies, polyurethanes, acrylics and others as recommended by your StonCor ME Sales Representative. Under certain conditions, a mist coat is required to minimize topcoat bubbling.

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.
Steel	SSPC-SP6 with a 1.0-2.0 mils (25-50 microns) surface profile

MIXING & THINNING

Mixing	6.14:1 by volume. Power mix Part A completely. Power mix Part B separately and add slowly to the mixture. Pour mixture through a 30 mesh screen.
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Carbozinc 860 ME

PRODUCT DATA SHEET



MIXING & THINNING

Thinning	Normally not required but may be thinned up to 8 oz/gal (6%) with #2. In hot or windy conditions, may be thinned up to 8 oz/gal with #33. Use of thinners other than those supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	<u>10-Liter Kit</u> Part A: 8.6 Liters Part B: 1.4 Liters
Pot Life	4 Hours at 75°F (24°). 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.

Spray Application	The following spray equipment has been found suitable and is available from manufactures such as Binks, DeVilbiss and Graco. Keep material under mild agitation during application.
Conventional Spray	Agitated pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose. .070" I.D. fluid tip and appropriate air cap.
Airless Spray	<p>Pump Ratio: 30:1 (min.) GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min) Tip Size: .017-.023" Output PSI: 2000-2200 Filter Size: 60 mesh</p> <p>Teflon packings are recommended and available from the pump manufacturer. Contact StonCor ME Technical Service for plural component equipment recommendations.</p>
Brush	For small areas and touch-up only. Use available from the pump manufacturer.
Roller	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)	51°C (124°F)	43°C (109°F)	85%

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	6 Hours
10°C (50°F)	5 Hours	3 Hours
24°C (75°F)	2 Hours	1.5 Hours
32°C (90°F)	60 Minutes	60 Minutes

These times are based on a 2.0 mils (50 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.

CLEANUP & SAFETY

Cleanup	Use #2 Thinner 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	Vapors and/or spray mist may cause explosion. When used as a tank lining or 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.
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 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

Shelf Life	Part A: 6 months at 75°F (24°C) Part B: 24 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)	10-Liter Kit: 35 Kg
Storage Temperature & Humidity	Storage Temperature: 40°-110°F (4°-43°C) Relative Humidity: 0-95%
Flash Point (Setaflash)	Part A: 58°F (14°C) Part B: 48°F (9°C)
Storage	Store indoors

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PRODUCT DATA SHEET



WARRANTY

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