

SELECTION & SPECIFICATION DATA

Generic Type	Two-component, zinc-rich epoxy primer
Description	A two-component, high solids, zinc rich epoxy primer formulated for the protection of properly prepared steel substrates. This product can be applied by conventional or airless spray.
Features	<ul style="list-style-type: none"> • Excellent application properties • Zinc rich epoxy primer • High solids # Superior corrosion resistance • Can be applied by conventional or airless spray • Tough abrasion resistant film • Fast drying for recoat • Excellent adhesion & undercutting resistance
Color	Grey
Finish	Flat
Dry Film Thickness	51 - 76 microns (2 - 3 mils) per coat
Total Zinc Content in Dry Film	By Weight: 75%
Solids Content	By Volume 62% +/- 3%
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.
VOC Values	As Supplied : 327 g/l These are nominal values.
Dry Temp. Resistance	Continuous: 204°C (400°F) Non-Continuous: 218°C (425°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 (38-50 micron) blast profile.

Carbozinc 8790

PRODUCT DATA SHEET



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. Pail agitators are recommended. Keep Part A material under mild agitation during plural spray application. Keep batch-mixed material under mild agitation during conventional air or airless spray application.
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.
Ratio	3.1/1 (by volume A to B)
Pot Life	10 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 (General)	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.
Airless Spray	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. Heated, plural component Consult Carboline Technical Service

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	2°C (36°F)	2°C (36°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.

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry Hard
24°C (75°F)	1 Hour	4 Hours	8 Hours

*Dry to Topcoat: these times are based on a 2.0-3.0 mils (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.

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 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.
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: Min. 6 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)	8.2 Liters Kit (Gross weight 22.4 kg) Part A: 6.2 Liters (Gross weight 20.2 kg) Part B: 2 Liters (Gross weight 2.2 kg)
Storage Temperature & Humidity	40° - 95°F (4-35°C) 0-90% Relative Humidity
Flash Point (Setaflash)	Part A: 77°F (25°C) Part B: 53°F (12°C) Thinner #2: 24°F (-4.4) Thinner #33: 89°F (32°C)
Storage	Store Indoors.

WARRANTY

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