

SELECTION & SPECIFICATION DATA

Generic Type	Polyamide zinc-rich epoxy
Description	A high performance, two component, organic zinc-filled primer specifically formulated to provide corrosion protection to steel surfaces in salt and weathering environments. It has good surface tolerant characteristics where steel surface preparation may be less than ideal. It may also be used for the repair of aged inorganic zinc-rich coatings or galvanised steel surfaces.
Features	<ul style="list-style-type: none"> • Exceptional corrosion resistance • Extremely high zinc loading - 90% by weight in dry film • Provides excellent cathodic protection • Excellent adhesion to commercial blast cleaned surfaces • Excellent for repairs to inorganic zinc silicate primers and aged/deteriorated galvanising • Meets the requirements of AS/NZS 3750.9, Type 2 Organic Zinc Rich • Conforms to the composition and performance requirements of SSPC-Paint 20 Type II Organic • As a brush applied maintenance primer tolerant to traces of surface moisture • As a holding / weld-through primer when applied less than 25 microns dry
Colour	Grey and Green
Finish	Flat
Film Build	50 - 100 microns dry. Typically applied at 75 microns dry
Solid(s) Content	By Volume 58%
Zinc Content in Dry Film	By Weight 90%
Theoretical Coverage Rates	11.6m ² /litre at 50 microns dry 7.7m ² /litre at 75 microns dry 5.8m ² /litre at 100 microns dry Allow for loss in mixing and application.
VOC Values	As Supplied : 382 g/L (mixed)
Dry Temp. Resistance	Continuous: 121°C (250°F) Non-Continuous: 200°C (392°F)
Limitations	<ul style="list-style-type: none"> • Do not topcoat with alkyd coatings • Not suitable for solvent, chemical, or water immersion service
Topcoats	May be topcoated with acrylics, epoxies, polyurethanes, and others as recommended by Carboline

SUBSTRATES & SURFACE PREPARATION

General	<p>All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application.</p> <p>Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.</p>
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Carbozinc 15-625

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Steel | Abrasive blast to SSPC-SP 6 (AS 1627.4 Sa 2) minimum and achieve a uniform jagged blast profile of 35µm (minimum) and up to 75µm.
Minimum power-tool clean to SSPC-SP 3 (AS 1627.2 St 3) for touch-up.

PERFORMANCE DATA

Test Method	Results
Adhesion – ASTM D4541	Excellent
Humidity Resistance – ASTM D2247	Excellent
Salt Spray Resistance – ASTM B117	Excellent

MIXING & THINNING

Mixing | The zinc metal is ready mixed in the base portion. Power mix the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion add the converter slowly with continued agitation. **DO NOT MIX PARTIAL KITS.**
Strain through a 30 to 60 mesh sieve prior to use.
Keep mixed material under slow agitation to keep zinc in suspension.

Thinning | Spray: Thinning in the range of 5% to 15% addition of Altex Thinning Solvent #12 may be expected, depending upon conditions.
Brush/Roller: Thin up to 5 to 10% by volume with Thinner #25 or #33.
When applying as a holding / weld-through primer at film thicknesses of 20-25 microns dry it is recommended to thin the mixed material up to 30% by volume with Altex Thinning Solvent #12 for optimum film thickness control; at high thinning levels an agitated pot is recommended.

Use of thinners other than those supplied or recommended by Altex Coatings may adversely affect product performance and void product warranty, whether expressed or implied.

Ratio | 4:1 by volume

Pot Life | 12 hours at 25°C
Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

Induction Time | 30 minutes

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. Keep material under mild agitation during application.

Conventional Spray | Agitated pressure pot equipped with dual regulators, 12 mm (1/2") I.D. minimum material hose, 2.8mm (.110") I.D. fluid tip and appropriate air cap.

Airless Spray | Pump Ratio: 30:1
Material Hose: 3/8" I.D min
Tip Size 0.021 – 0.025

(Note: The above is a guide. Other equipment to the above may be used.)

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.

Brush & Roller (General) | For small areas, this coating may be brush or roller applied if conditions are suitable, however, care must be taken to ensure the correct film build is applied.

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)	50°C (122°F)	35°C (95°F)	90%
Optimum	20°C (68°F)	20°C (68°F)	20°C (68°F)	30%

Industry standards are for substrate temperatures to be above the dew point. Carbozinc 15-625 is unique in that it can tolerate traces of surface moisture.

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat
10°C (50°F)	12 Hours	16 Hours
16°C (61°F)	10 Hours	14 Hours
25°C (77°F)	8 Hours	12 Hours
32°C (90°F)	6 Hours	8 Hours

These times are based on a 50 micron dry film thickness at 50% relative humidity. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

Maximum Time to Recoat: Unlimited. Must have a clean, dry surface for topcoating. "Loose" chalk or salts must be removed in accordance with good painting practice. Consult Carboline Technical Service for specific information.

CLEANUP & SAFETY

Cleanup | Use Altex Thinning Solvent #12

Safety | For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label, and the Safety Data Sheet (SDS) for health and safety information prior to use.

Ventilation | When used in enclosed areas and product is thinned, 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 vapour concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use suitable approved respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life | Part A: Min. 9 months at 24°C
Part B: Min. 24 months at 24°C

Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.

Storage Temperature & Humidity | Optimum: 5-35°C
0-85% Relative Humidity

Carbozinc 15-625

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

Flash Point (Setaflash) | 21°C

**Shipping Weight
(Approximate)** | 3.0 kg per litre
5 litre kit – 15 kg

Storage | Store under cool, dry conditions and should be protected from frost, weather, moisture, direct sunlight, and contamination ingress.

WARRANTY

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