

Selection & Specification Data

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| Generic Type | Epoxy Polyamide |
| Description | <u>Low-temperature and rapid curing primer/finish with an extended recoat window.</u> Provides excellent corrosion resistance as a primer, intermediate or finish coat on steel substrate. Self-priming on steel, galvanized steel and concrete, 888 offers user-friendly characteristics which facilitate application in a wide range of environmental conditions. |
| Features | <ul style="list-style-type: none"> - Low-temperature cure characteristics - Rapid handling for in-shop applications - One year recoat window - Low yellowing compared to other epoxies - VOC compliant to current AIM regulation - Meets the requirements of: Class "A" slip coefficient and creep testing criteria for use on faying surfaces |
| Color | Buff & Light Gray only |
| Finish | Satin |
| Primers | Self-priming. May be applied over inorganic zinc primers, epoxies and other as recommended. A mist coat may be required to minimize bubbling over inorganic zinc primers. |
| Topcoats | Acrylics, Epoxies, Polyurethanes |
| Dry Film Thickness | 75-125 µm (3.0-5.0 mils) per coat Don't exceed 250 µm (10 mils) in a single coat. Excessive film thickness over inorganic zincs may increase damage during shipping or erection. |
| Solids Content | By Volume: Carboguard 888 60 ± 2 % |
| Theoretical Coverage Rate | 24.0 m ² /l at 25 microns Allow for loss in mixing and application |
| VOC Values | As supplied: 330 g/l (2.70 lbs./gal) Thinned: 15% BV Th# 15: 403 g/l (3.30 lbs./gal) These are nominal values and may vary slightly with color. |
| Dry Temp. Resistance | Continuous: 93°C (200°F) Non-Continuous: 121°C (250°F) Discoloration and loss of gloss is observed above 93°C (200°F). |
| Limitations | Epoxies lose gloss, discolor and eventually chalk in sunlight exposure. |

Substrates & Surface Preparation

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| 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-SP 6 / ISO 8501-1 SA 2 <u>Surface profile:</u> 38-75 µm (1.5-3 mils) |
| Galvanized Steel | SSPC-SP1 – SSPC-SP7 |
| Concrete | Concrete must be cured 28 days at 24°C (75°F) and RH 50% or equivalent. Laitance, form oils, curing agents and hardeners should be removed by suitable method before coating application. |

Application Equipment

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| Spray Application (General) | The following spray equipment has been found suitable and is available from manufacturers such as Binks, De Vilbiss and Graco |
| 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 | Pump Ratio: 30:1 (min.) GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: .017"-.021" Output PSI: 2100-2300 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer. |
| Brush & Roller (General) | Not recommended for tank lining applications except when striping welds. Multiple coat may be required to obtain desired appearance, recommended dry film thickness and adequate hiding: Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 24°C (75°F) |
| Brush | Use a medium bristle brush |
| Roller | Use a short nap synthetic roller cover with phenolic core |

Test reports and additional data available upon written request.

Mixing & Thinning

- Mixing** Power mix separately, then combine and power mix.
DO NOT MIX PARTIAL KITS
- Ratio** 1:1 Ratio by volume
- Thinning** May be thinned up to 15% with Thinner#15. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
- Pot Life** 4 Hours at 24°C (75°F)
Pot-life end when coating loses body and begins to sag. Pot-life times will be less at higher temperatures

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** 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. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or if not able to monitor levels, use MSHA/NIOSH approved supplied air respirator.
- 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

Application Conditions

| Condition | Material | Surface | Ambient | Humidity |
|-----------|----------|---------|---------|----------|
| Normal | 16-29°C | 18-29°C | 16-32°C | 0-65% |
| Minimum | 10°C | 2°C | 2°C | 0% |
| Maximum | 32°C | 57°C | 49°C | 90% |

Do not apply when the surface temperature is less than 3°C above 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. & 50% Relative Humidity | Dry to Recoat | Dry to Topcoat with Other Finishes | Final Cure |
|---------------------------------------|---------------|------------------------------------|------------|
| 2°C | 16 Hours | 18 Hours | 3 Days |
| 10°C | 9 Hours | 8 Hours | 2 Days |
| 24°C | 3 Hours | 4 Hours | 24 Hours |
| 32°C | 1,5 Hours | 2 Hours | 12 Hours |

These times are based on a 75-125 µm DFT

Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. **Maximum recoat time is one year without special surface preparation.** If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats. Carboguard 888 applied below 4°C (40°F) may temporarily soften for several hours, after temperature rise to 16°C (60°F). This is a normal condition and will not affect performance.

Packaging, Handling & Storage

- Kit Standard** Part A: 10 liters Part B: 10 liters
- Flash Point (Setaflash)** 12°C (54°F) for Part A.
13°C (13°F) for Part B.
- Storage Temperature & Humidity** 4° - 43°C (40°-110°F) Store indoors.
0-100% Relative Humidity
- Shelf Life** Part A: 36 months at 24°C (75° F)
Part B: 24 months at 24°C (75° F)

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Carboline Italia SpA

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