

Selection & Specification Data

Generic Type Zinc-filled , epoxy-polyamide primer.

Description An organic zinc primer for protection of structural steel in salt or weathering environments . Easy to apply . Cures to hard tough film. May top coated in two to four hours at 60 – 75° F (see Cured schedule)

- Features**
- An excellent maintenance or general use zinc primer over steel
 - As an intermediate coat over an organic zinc primer
 - Good flexibility
 - Very good abrasion resistance
 - Excellent weathering resistance

CHEMICAL RESISTANCE GUIDE

(With proper topcoats)

Exposure	Heavy Light and Spillage	Outside or Mild Fumes
Acids	Very Good	Excellent
Alkalies	Very Good	Excellent
Solvents	Very Good	Excellent
Salt	Excellent	Excellent
Water	Excellent	Excellent

Color/ Gloss Gray only / flat

Primers Apply directly to substrate or inorganic zinc primer or weathered galvanized steel.

Topcoats Can be top coated with catalyzed epoxies, phenolics, epoxie-coal tars, vinyls, chlorinated rubbers, acrylics, silicones or others as recommended.

Dry Film Thickness 3 mils (75 microns)

Solids Content

Theoretical solid content (mixed)	By volume 51% ± 2%
Percent total zinc in the dry film	By weight 80%

Theoretical Coverage Rate PER MIXED GALLON
818 mil sq.ft. (20,4 sq. m/l at 25 microns)
273 sq. ft. at 3 mils (6.8 sq. m/l at 75 microns)
"NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

Dry Temp. Resistance (non immersion)
Continuous: 180°F (82°C)
Non-continuous: 230°F (110°C)

Limitations NOT RECOMMENDED FOR immersion service , exposure to strong acids or alkalies or untopcoated in severe corrosive exposures

Substrates & Surface Preparation

Substrate & General Apply to properly prepared Steel, cast iron, galvanized steel, stainless steel, aluminum or others as recommended.
Remove any oil or grease from surface to be coated with clean rags soaked in CARBOLINE Thinner #2 or toluo! in accordance with SSPC-SP 1,

Steel For non-immersion service, dry abrasive blast to a Commercial finish in accordance with SSPC-SP 6-82 to a degree of cleanliness in accordance with NACE #3 to obtain a 1 to 3 mil (25-75 micron) blast profile Acceptable — thorough Power Tool cleaning per SSPC-SP 3-82, for non-immersion.

Application Equipment

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. **General Guidelines:**

Spray Application (General) Use sufficient air volume for correct operation of equipment.
Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later. Should be under mild agitation while spraying.

Conventional Spray Pressure pot equipped with dual regulators , 3/8" I.D. minimum material hose, .055-.070" I.D. fluid tip and appropriate air cap.

Mfg	Fluid tip	Air cap
Binks #18or #62	66	63PB
DeVilbiss P-MBCorJGA	E	704

Carbozinc® 658

Airless Spray

Use a 3/8" I.D. minimum material hose, Hold gun 18-20" from the surface and at right angle to the surface

Tip Size: .019"-.023"

Output psi: 2100-2300

Filter Size: 60 mesh

Mfr. & Gun	Pump
DeViiibiss JGB or JGN	QFA – 519
Graco 205-591 or208-663	Bulldog 30:1
Binks Model 700	B8-36 37:1

*Teflon packings are recommended and are available from pump manufacturer

Brush & Roller (General)

Recommended for small area or touch up
Avoid rebrushing. Avoid rerolling.

Use a natural bristle brush applying with full strokes

Use a short nap mohair roller with phenolic core.

Mixing & Thinning

Mixing

Mix Part A and Part B separately and combine:

Ratio

	5L set
CARBOZINC 658 Part A	4 L
+ zinc filler	
CARBOZINC 658 Part B	1 L

Thinning

Thin up to 25% by volume with CARBOLINE Thinner #15.

For temperatures below 60°F(16°C) use CARBOLINE Thinner #2.

Pot Life

3 hours at 30° C

Cleanup & Safety

Cleanup

Use CARBOLINE Thinner # 2

Safety

Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

Ventilation

When used in enclosed area, 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 solvent 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 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 shoes

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	60° - 90°F (16 - 32°C)	60-100°F (16-38°C)	60-90°F (16-32°C)	0 - 85%
Minimum	40°F(6°C)	50°F(10°C)	50°F (10°C)	0%
Maximum	120°F (49°C)	165°F (74°C)	100°F (38°C)	85%

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Handle	Before topcoating
50°F (10°C)	75 min.	6 hours
60°F (16°C)	65 min	4 hours
75°F (24°C)	55 min	2 hours
90°F (32°C)	45 min.	1 hours

Do not apply when the surface temperature is less than 5°F (2°C) above the dew point.

Packaging, Handling & Storage

Shipping Weight (Approximate)

	5'L set
Carbozinc 658 Part A	4 L
Carbozinc 658 Part B	1 L

Flash Point (Setaflash)

CARBOZINC 658 Part A	39°F (4°C)
CARB ZINC 658 Part B	41°F (5°C)
CARBOLINE Thinner #15	77°F (25°C)
CARBOLINE Thinner #2	30°F (-1°C)

Storage Temperature & Humidity

Store indoor
Temperature: 40-110°F (4-43°C)
Humidity: 0-100%

Shelf Life

Six months minimum when stored at 32°C

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



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