

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Two-components zinc filled, cross-linked epoxy primer.
<b>Description</b>	Carbozinc 858 is a high solid, organic zinc epoxy primer designed for corrosion protection of structural steel in salt and weathering environments. The paint is easy to apply and protects steel galvanically. Provides tough and abrasion resistant film.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Outstanding application properties</li> <li>• Protects steel galvanically</li> <li>• Cures at low temperatures down to 2°C</li> <li>• Cured film is tough and abrasion resistant</li> <li>• Widely used within petrochemical-, offshore shipping- and other heavy industries in severe environments with appropriate topcoat</li> <li>• No induction time</li> <li>• Prequalified in accordance with NORSOK M-501, Rev.6 System 1.</li> <li>• <b>N.B. an applied film of 90 microns DFT of Carbozinc 858 achieved accredited test certification for NORSOK M-501, Rev 4 System 1.</b></li> </ul>
<b>Color</b>	Bluish grey Green
<b>Finish</b>	Flat
<b>Wet Film Thickness</b>	80 - 230 µm per coat.
<b>Dry Film Thickness</b>	50 - 150 microns (1.95 - 5.9 mils) per coat
<b>Solid(s) Content</b>	By volume: 65 ± 2% Zinc content in dry film: 84 %
<b>Theoretical Coverage Rates</b>	13 m²/l at 50 µm 4,3 m²/l at 150 µm Allow for loss in mixing and application.
<b>Dry Temp. Resistance</b>	Continuous: 150°C (302°F) Non-Continuous: 200°C (392°F)
<b>Limitations</b>	Not recommended for direct exposure to strong acids and alkalies.
<b>Topcoats</b>	May be topcoated with epoxy, polyurethane or others as recommended by Carboline.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Surface 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.
<b>Steel</b>	Surface preparation to be minimum St 3 (ISO 8501-1). Alternatively, ultra high pressure water jetting to Nace No. 7 min. C Vis WJ-2. Max flash rust; C Vis WJ-2M.

## MIXING & THINNING

<b>Mixing</b>	Power mix separately, then add part B to Part A and power mix well. DO NOT MIX PARTIAL KITS.
<b>Thinning</b>	Normally not required. May be thinned up to 10 % with Carboline Thinner #2.

# Carbozinc 858

## PRODUCT DATA SHEET



### MIXING & THINNING

**Ratio** | 3 : 1 (A to B) by volume

**Pot Life** | 4 hours at 24°C and longer at lower temperatures.

### 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.

**Airless Spray** | Pump ratio: 30:1 (min.)  
GPM Output: 3.0 (min.)  
Material Hose: 3/8" I.D. (min.)  
Tip Size: 0.017-0.021"  
Output PSI: 2000-2200 (140-160 kg/cm<sup>2</sup>)  
Filter Size: 60 mesh

Teflon packings are recommended and available from the pump manufacturer

**Brush & Roller (General)** | Recommended for touch up, stripe coating and hard-to-reach areas

**Brush** | Recommended using a soft bristle brush.

**Roller** | Generally not recommended for priming purposes

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (39°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	30°C (86°F)	50°C (122°F)	45°C (113°F)	95%

### CURING SCHEDULE

Surface Temp.	Dry to Handle or Recoat	Final Cure
2°C (36°F)	8 Hours	10 Days
10°C (50°F)	5 Hours	5 Days
24°C (75°F)	2 Hours	3 Days
32°C (90°F)	1 Hour	2 Days

### CLEANUP & SAFETY

**Cleanup** | Use Carboline 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 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 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.

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## CLEANUP & SAFETY

<b>Caution</b>	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 applicable regulations. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non-sparking shoes.
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## PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	Part A: 9 months (24°C) Part B: 2 years (24°C)
<b>Storage Temperature &amp; Humidity</b>	5° - 45°C 0 - 95% relative humidity
<b>Storage</b>	Store indoors.
<b>Packaging</b>	Part A 7,5 litres Part B 2,5 litres

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## WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.