

## Selection & Specification Data

<b>Generic Type</b>	Polyamide Modified Epoxy
<b>Description</b>	<p><b>Carbozinc 85</b> is a two component, polyamide, organic zinc filled coating designed to provide cathodic protection to steel in environments exposed to marine and industrial environments with severe weather and chemical fumes. Provides superior corrosion protection from undercutting. Excellent for use on structural steel, petrochemical applications, pulp and paper mills, bridges, piping, tanks, sewage treatment plants, electrical generating plants, and marine applications.</p>
<b>Features</b>	<ul style="list-style-type: none"> <li>▪ High zinc loading</li> <li>▪ Excellent corrosion protection</li> <li>▪ Low VOC</li> <li>▪ Easy two-component mixing</li> </ul>
<b>Color</b>	Green (0300)
<b>Finish</b>	Flat
<b>Topcoats</b>	Can be topcoated with a variety of finishes including epoxies and urethanes.
<b>Dry Film Thickness</b>	2.0-4.0 mils (50-100 microns)
<b>Solids Content</b>	By Volume: 63% ± 2%
<b>Zinc Dust Content</b>	By Weight: 85% ± 2%
<b>Theoretical Coverage Rate</b>	1010 mil ft <sup>2</sup> @ 1 dry mil Allow for loss in mixing and application.
<b>VOC Values</b>	As supplied: 2.70 lbs./gal (324 g/l) Thinned: 6 oz/gal w/ #248; 2.9 lbs/gal (348 g/l) These are nominal values.
<b>Dry Temp. Resistance</b>	400°F

## Substrates & Surface Preparation

<b>General</b>	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.
<b>Steel</b>	SSPC-SP6 with a 1.0-3.0 mil (25-75 micron) profile. SSPC-SP2 or SP3 for touch-up.
<b>Weathered Zinc Rich Primer</b>	Remove zinc salts with power washing and a stiff bristle brush scrubbing or sweep blast and allow to dry before coating.

### Special Information:

Do not apply if material, substrate or ambient temperature is below 45°F or above 110°F. Stripe coat crevices, welds and sharp angles before spraying to optimize performance. Topcoating is recommended for optimum protection.

## 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:

<b>Spray Application (General)</b>	Use a 50% overlap, when spraying, to avoid pinholing and holidays. Clean equipment before extended periods of downtime to prevent equipment blockage. Keep pressure pot at the level of the applicator to avoid fluid line blockage due to product weight. Blow back coating in fluid lines at intermittent shutdowns. Continue agitation of the product at the pressure pot.
<b>Conventional Spray</b>	Mix continuously. Gun: Binks 95; Fluid Nozzle: 68; Air Nozzle: 68P; Atomization Pressure: 50 psi; Fluid Pressure: 20-40 psi
<b>Airless Spray</b>	Use Teflon packings and mix continuously. Material Hose: 3/8" I.D. (min.) Tip Size: .019" Output PSI: Minimum 3000 psi Filter Size: No filter
<b>Brush</b>	Natural bristle or nylon/polyester, for striping, repair and small areas only.
<b>Roller</b>	3/8" woven/phenolic core, for striping, repair and small areas only.

## Mixing & Thinning

<b>Mix Ratio</b>	2 gals (Part A) with 0.5 gals (Part B)
<b>Mixing</b>	Thoroughly mix each component using mechanical agitation making sure pigment does not remain on the bottom of can. Pour the activator, part B, into part A (mixing ratio by volume: 1 part activator, part B, to 4 parts part A) and mix well. After mixing, pour through a 30-60 mesh screen. If thinner is required, thin only after mixing part A with part B. Allow 15 minutes induction time at 77°F. Do not mix more than can be applied during the product's useful pot life. Continue to agitate the mixture during application of the product to keep the zinc pigment from settling out and the product uniform.
<b>Thinning</b>	Thin up to 6 fluid ounces per gallon with Thinner 248.
<b>Pot Life</b>	Maximum 8 hours @ 77°F. In order to maintain application properties, mix (activate) only what can be applied in 8 hours. Allow 15 minutes induction time at 77°F.

## Cleanup & Safety

<b>Cleanup</b>	Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	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.

## Curing Schedule

Surface Temp. & 50% RH	Dry to Touch	Dry to Handle	Dry to Recoat
50°F (10°C)	60 min	6 hours	48 hours
60°F (16°C)	45 min	4 hours	32 hours
75°F (24°C)	30 min.	2 hours	16 hours
90°F (32°C)	20 min	1 hour	12 hours

These times are based on a 3.0 mil (75 micron) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times. Maximum recoat time is 6 months.

## Packaging, Handling & Storage

<b>Shipping Weight (Approximate)</b>	<b>2.5 Gallon Kit</b> 65 lbs (30 kg)
<b>Flash Point (Setaflash)</b>	Part A: 73°F Part B: 80°F
<b>Storage Temperature &amp; Humidity</b>	40-110°F; 0-95% RH Store Indoors.
<b>Shelf Life</b>	Part A: 12 months @75°F Part B: 24 months @75°F

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



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