

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 a hard, tough film.	
Features	<ul style="list-style-type: none"> - Excellent maintenance or general use zinc primer over steel - May be used as an intermediate coat over an inorganic zinc primer such as Carbozinc 11 or Carboweld 11 - Readily topcoated with a variety of topcoats - Used for structural steel in pulp & paper, petrochemical, chemical processing and other facilities - Recommended for touching up inorganic zinc coatings such as Carbozinc 11 - Good flexibility - Excellent weathering - Very good abrasion resistance - Not recommended for immersion service, exposure to strong acids or alkalis or untopcoated in severe corrosive exposures - Can be applied directly to substrate, inorganic zinc or weathered galvanised steel. Other primers should be confirmed with StonCor Africa Technical Service 	
Colour	Red only	
Finish	Flat	
Topcoat	Can be topcoated with catalyzed epoxies, phenolics, epoxy coal tars, vinyls, chlorinated rubbers, acrylics, silicones or others as recommended.	
Dry Film Thickness	75 Microns	
Solids Content	By Volume 53% ± 2%	
Theoretical Coverage Rate	7.1m ² /litre at 75 microns	
VOC Content	405 g/litre	
Temp Resistance	Non-immersion	
	Continuous	82°C
	Non-continuous	110°C

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated prior to abrasive blast or power tool cleaning.
Steel	<p>Non-immersion service: Dry abrasive blast to a commercial finish in accordance with ISO 8501 Sa2 to obtain a 25 to 27 micron blast profile.</p> <p>Acceptable for non-immersion: Thorough power tool cleaning as per ISO 8501 St3.</p>

May 2017 replaces January 2016

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Application Equipment

Spray Use sufficient air volume for correct operation of equipment.

Use agitated pot. Maximum 15m hose. Keep pot at same elevation as gun. If spraying stops for more than 15 minutes, blow the material from hose back into the pot.

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.

NOTE: The following equipment has been found suitable, however equivalent equipment may be substituted.

Conventional Use a 10mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface.

Mfr & Gun	Fluid Tip	Air Cap
Binks # 18 or # 62	66	63PB
DeVilbiss MBC or JGA	E (approx. .070 I.D.)	704

Airless Use a 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface.

Mfr & Gun	Pump *
DeVilbiss JGB or JGN	QFA-519
Graco 205-591 or 208-663	Bulldog 30:1
Binks Model 700	B8-36 37:1

* Teflon packings are recommended and are available from pump manufacturer.

Use a .019 to .023" tip with 2400 psi (165 bar)

Brush or Roller Recommended for small areas and touch-up only. Use natural bristle brush, applying with full strokes. Avoid rebrushing. Use short nap mohair roller with phenolic core.

Mixing & Thinning

Mixing Mix Part A and Part B separately and combine in the following proportions:

	5 Litre kit
Carbozinc 658 Part A	4 litres
Carbozinc 658 Part B	1 litre

Thinning Up to 25% by volume with Thinner # 2

NOTE: Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether express or implied.

Pot Life 6 Hours at 25°C and less at higher temperatures. Pot life ends when coating becomes too viscous to use.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	16-32°C	16-38°C	16-32°C	0-85%
Minimum	4°C	10°C	10°C	0%
Maximum	43°C	43°C	43°C	85%

Do not apply when the surface temperature is less than 3°C above the dew point.

Special thinning and application techniques may be required above or below normal conditions.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Handle *	Before Topcoating *
10°C	8 Hours	16 Hours
16°C	6 Hours	12 Hours
25°C	4 Hours	6 Hours
32°C	2 Hours	3 Hours

* Minimum times. Weathering beyond 30 days may require special surface preparation before topcoating. Consult StonCor Africa Technical Service for detailed information.

Cleanup & Safety

Cleanup Use 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. 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. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

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.

Packaging, Handling & Storage

Shipping Weight (Approximate)		5 Litre kit
Carbozinc 658		11.0kg
Thinner # 2		4.8kg

Flash Point (Pensky Martens Closed Cup)	Carbozinc 658 Part A	14°C
	Carbozinc 658 Part B	25°C
	Thinner # 2	-4°C

Storage Temperature & Humidity	4 to 43°C
	0 to 100%
	Store indoors

Shelf Life	12 Months minimum when stored at 25°C
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*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.



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March 2017 replaces January 2016

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