

SELECTION DATA

GENERIC TYPE: Modified single package zinc-rich phenoxy.

GENERAL PROPERTIES: An easy-to-apply maintenance coating. Being single package, the material has no pot life.

RECOMMENDED USES: An excellent maintenance or general use shop primer. High zinc content provides galvanic cathodic protection. Readily topcoated with a wide variety of topcoats. Has been used in pulp and paper industries, chemical processing, petroleum refining and others. Is normally recommended to touch up inorganic zincs.

NOT RECOMMENDED FOR: Immersion service or exposure to pH above 10 or below 5 without suitable topcoat.

CHEMICAL RESISTANCE GUIDE (with recommended topcoat):

<u>Exposure</u>	<u>Heavy Fumes or Light Splash & Spillage</u>	<u>Outside Weathering/ Mild Fumes</u>
Acids	Fair	Very good
Alkalies	Fair	Very good
Solvents	Fair	Very good
Salt	Excellent	Excellent
Water	Excellent	Excellent

TEMPERATURE RESISTANCE (non-immersion):

Continuous	82°C
Non-continuous	110°C

FLEXIBILITY: Excellent

WEATHERING: Excellent

ABRASION RESISTANCE: Very good

SUBSTRATES: Apply to properly prepared steel, cast iron, galvanised steel or others as recommended.

TOPCOAT REQUIRED: May be topcoated with acrylic, epoxy-tar, vinyl or others as recommended.

COMPATIBILITY WITH OTHER COATINGS: Normally used only over clean metal surfaces, can be used to touch up inorganic zincs.

SPECIFICATION DATA

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL:

	<u>By Volume</u>
Carbozinc 676 ZA	37% ± 2%
Percentage zinc in dry film	86%

RECOMMENDED DRY FILM THICKNESS PER COAT:
75 Microns

THEORETICAL COVERAGE*:
4,9m²/lt at 75 microns

* **NOTE:** Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

SHELF LIFE: 12 Months minimum when stored at 25°C.

COLOURS: Grey only.

GLOSS: Flat.

ORDERING INFORMATION

Prices may be obtained from StonCor Africa Sales Representative or Main Office.

APPROXIMATE SHIPPING WEIGHT:

	<u>5L</u>
Carbozinc 676 ZA	11,2kg
Carboline Thinner # 76	4,8kg

FLASH POINT (Pensky-Martens Closed Cup):

Carbozinc 676 ZA	20°C
Carboline Thinner # 76	-2°C

March 2012 SA replaces June 2010 SA

APPLICATION INSTRUCTIONS

These instructions are not intended to show product recommendations for specific service. They are issued as an aid in determining correct surface preparation, mixing instructions and application procedure. It is assumed that the proper product recommendations have been made. These instructions should be followed closely to obtain the maximum service from the materials.

SURFACE PREPARATION: Remove any oil or grease from surface to be coated prior to abrasive blasting.

STEEL: For non-immersion, dry abrasive blast to a commercial grade finish in accordance with ISO 8501 SA2 to obtain a 25 to 75 micron blast profile.

MIXING: Power-mix Carbozinc 676 ZA to a smooth consistency before thinning. Thin up to 18% by volume with Carboline Thinner # 76.

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

APPLICATION TEMPERATURES:

	<u>Material</u>	<u>Surfaces</u>
Normal	16-32°C	16-38°C
Minimum	4°C	4°C
Maximum	43°C	43°C

	<u>Ambient</u>	<u>Humidity</u>
Normal	16-32°C	0-85%
Minimum	4°C	0%
Maximum	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.

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.

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 300 to 350mm from the surface and at a right angle to the surface.

<u>Mfr & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks # 18 or # 62	63B	63PB
DeVilbiss P-MBC or JGA	FX	704

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

<u>Mfr & Gun</u>	<u>Pump*</u>
De Vilbiss JGN-507	QFA-508
Graco 205-591	President 30:0 or Bulldog 30:1
Binks Model 500	Mercury 5C

* Teflon packings are recommended and available from pump manufacturer. Use a .017 to .019" tip with 2400 psi.

BRUSH: For touch up only. Use medium bristle brush and apply full strokes. Avoid rebrushing.

DRYING TIMES:

<u>Temp</u>	<u>To Handle *</u>	<u>Before Topcoating *</u>
4°C	16 Hours	48 Hours
10°C	12 Hours	24 Hours
16°C	8 Hours	12 Hours
25°C	2 Min	4 Hours
32°C	1 Min	2 Hours

* Minimum times.

CLEAN UP: Use Carboline Thinner # 2 or Xylol.

STORAGE CONDITIONS (Store indoors):

Temperature:	4-43°C
Humidity:	0-100%

CAUTION: MAY CONTAIN FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRONIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST, WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.



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