

Selection & Specification Data

Generic Type	Epoxy Polyamide
Description	Carboguard 60 is a high solids, versatile corrosion resistant coating. It can be used as a primer, intermediate coat, or self-priming finish over steel or inorganic zinc primers. May be topcoated with itself, or a broad variety of high performance finish coats. This product has excellent wetting properties giving it the capability of going over marginally prepared substrates. It is ideal for maintenance and fabrication shop applications. An optional Glass Flake (GF) additive or micaceous iron oxide (MiO) additive can be purchased separately and may be used to enhance film strength for more abusive applications for severe marine or heavy industrial uses. Carboguard 60 is suitable for use as a blast-hold primer for tank linings used in crude oil storage, fuel oils, gasoline and water/wastewater up to 140°F (60°C). Consult Technical Service for suitable linings or for other exposures.
Features	<ul style="list-style-type: none"> • Low odor and low VOC • Available in a variety of rapid tint colors • Attractive medium sheen for tank exteriors • Used as a primer, intermediate, or finish coat • Fast cure & dry times • Can be applied over power tool cleaned surfaces • VOC compliant to current AIM regulations
Color	Primer color (0700) gray. Variety of other finish coat colors in rapid tint service. MiO additive will darken (grey) all colors.
Finish	Semi-Gloss (35-70)
Primer	Self-priming. May be applied over organic and inorganic zinc rich primers. A mist coat may be required to minimize bubbling over zinc rich primers.
Dry Film Thickness	<p>4.0 - 6.0 mils (102 - 152 microns) per coat as a primer or an intermediate without additives</p> <p>4.0 - 10.0 mils (102 - 254 microns) per coat (2 coats) may be used direct-to-metal</p> <p>8.0 - 12.0 mils (203 - 305 microns) per coat with GF or MiO additives</p> <p>Do not exceed 10 mils in a single coat (without additives)</p>
Solids Content	By Volume 72% +/- 2%
Theoretical Coverage Rate	<p>1155 ft² at 1.0 mils (28.3 m²/l at 25 microns)</p> <p>289 ft² at 4.0 mils (7.1 m²/l at 100 microns)</p> <p>96 ft² at 12.0 mils (2.4 m²/l at 300 microns)</p> <p>Allow for loss in mixing and application.</p>
VOC Values	<p>Thinner 2 13 oz/gal 2.47 lbs./gal 296 g/l</p> <p>Thinner 2 6 oz/gal 2.23 lbs./gal 267 g/l</p> <p>Thinner 33 15 oz/gal 2.57 lbs./gal 308 g/l</p> <p>As Supplied 2.00 lbs./gal 240 g/l</p> <p>These are nominal values for the liquid components only and may vary slightly with color and with the addition of GF or MiO fillers.</p>

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Dry Temp. Resistance	<p>Continuous: 300 °F (149 °C)</p> <p>Non-Continuous: 350 °F (177 °C)</p> <p>Exposure above 200°F/93°C may cause discoloration (darkening) or loss of gloss, but will not affect performance.</p>
Limitations	RTS colors and the use of Additive 8505 with this product are not recommended for immersion. Additive 8505 will cause discoloration of this product, but will not affect product performance.
Topcoats	May be topcoated with Acrylics, Epoxies, Alkyds, or Polyurethanes depending on exposure and need.

Substrates & Surface Preparation

General	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.
Steel	<p>For most applications:</p> <p>Immersion: SSPC-SP10</p> <p>Non-immersion: SSPC-SP6</p> <p>1.5-3.0 mils (38-75 microns)</p>
Galvanized Steel	SSPC-SP16
Concrete or CMU	Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.

Previously Painted Surfaces SSPC-SP2 or SP3

Performance Data

Test Method	System	Results
ASTM D2794 Impact resistance	Blasted Steel 1ct.	100 in. lbs (direct)
ASTM D3366 Pencil Hardness	Blasted Steel 1 ct.	4H-5H
ASTM D4541 Adhesion	Blasted Steel 1ct. 2ct.	(Pneumatic) 1 ct. 1500+psi 2 ct.1500+ psi
ASTM D522 Flexibility	Blasted Steel 1 ct.	No cracking, 5/8" Conical Mandrel Bend

Data based on Carboguard 60 without filler additives.

Mixing & Thinning

Mixing	<p>Power mix separately, then combine and power mix. Allow mixed product 15 minute sweat in time before thinning if material is under 70°F. No sweat in needed above 70°F DO NOT MIX PARTIAL KITS. For GF or MiO additives, slowly add while mixing.</p>
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Carboguard® 60

Mixing & Thinning

Thinning Spray: Up to 13 oz/gal (10%) with Thinner #2. Brush & Roller: Up to 15 oz/gal (12%) with Thinner #33. Thinner 236E or 250E may be used as an exempt thinner in lieu of those listed above. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.

Ratio

- Liquid Components: 1:1 Ratio (A to B)
- Glass Flake (GF) Additive: (1.8 lbs/mixed gal)
- Micaceous Iron Oxide (MiO) Additive: (2.0 lbs/gal)

Pot Life 4 Hours at 75°F (24°C)
Pot life ends when coating loses body and begins to sag. Pot life times will be less at higher temperatures.

Carboline Additive 8505 can be used to aid the film forming process in the product for temperatures down to 35°F. Carboline Additive 8505 is added at a rate of 4 oz per mixed two gallon kit or 20 oz per mixed ten gallon kit. Allow mixed product 15 minute sweat in time before thinning, if material is under 70°F, and 24 hrs cure prior to topcoating for surface temperatures down to 40°F. At this addition rate, Additive 8505 will accelerate the cure rate of the epoxy product and reduce the pot life of the product.

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.

Conventional Spray Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .070" I.D. fluid tip and appropriate air cap. For filler additives use a 0.110" I.D. fluid tip.

Airless Spray Pump Ratio: 30:1 (min.)*
GPM Output: 2.5 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .017"-.021" (.035"-.041" for filler additives)
Output PSI: 2100-2500
Filter Size: 60 mesh (remove mesh for filler additives)
PTFE packings are recommended and available from the pump manufacturer.

Brush & Roller (General) Not recommended for tank lining applications except when striping welds. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 75°F (24°C). The addition of GF or MiO fillers is best applied by spray application.

Brush Use a medium bristle brush.
Roller Use 3/8" nap roller with a solvent resistant core.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	50 °F (10 °C)	40 °F (4 °C)	40 °F (4 °C)	0%
Maximum	90 °F (32 °C)	140 °F (60 °C)	120 °F (49 °C)	85%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required above or below normal application conditions.

Curing Schedule

Surface Temp.*	Dry to Handle	Dry to Recoat	Dry to Touch	Maximum Recoat Time
40 °F (4 °C)	30 Hours	48 Hours	3 Hours	1.0 Years
50 °F (10 °C)	20 Hours	24 Hours	2 Hours	1.0 Years
60 °F (16 °C)	8 Hours	10 Hours	1 Hours	1.0 Years
75 °F (24 °C)	5 Hours	7 Hours	45.0 Minutes	1.0 Years
90 °F (32 °C)	3 Hours	4 Hours	30.0 Minutes	1.0 Years

*These times are based on a 5.0 mil (125 micron) dry film thickness and 50% RH. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating.
NOTE: The maximum recoat times in the chart above are for atmospheric exposures. When used as a blast-hold primer, maximum recoat time is limited to 30 days. If the maximum recoat times have been exceeded, the surface must be abraded by sweep blasting or sanding prior to the application of additional coats. For force curing, contact Carboline Technical Service for specific requirements.

Cleanup & Safety

Cleanup Use 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.

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. 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.

Packaging, Handling & Storage

Shelf Life Part A & B: Min. 36 months at 75°F (24°C)

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

Shipping Weight (Approximate)
2 Gallon Kit
26 lbs. (12 kg)
10 Gallon Kit
127 lbs. (58 kg)

Storage Temperature & Humidity
40° - 100°F (4° - 37.8°C)
0-100% Relative Humidity

Flash Point (Setaflash)
Part A: 82°F (27.8°C)
Part B: 71°F (21.7°C)
Mixed: 78°F (25.6°C)

Storage Store Indoors.

This product is solvent based and not affected by excursions below these published storage temperatures, down to 10°F, for a duration of no more than 14 days. Always inspect the product prior to use to make sure it is smooth and homogeneous when properly mixed.



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1045