

Selection Data

GENERIC TYPE : Zinc-rich epoxy polyamide coating. Part A and Part B mixed prior to application.

GENERAL PROPERTIES : An easy to apply zinc primer. Cures to hard tough film. An organic zinc primer for protection of steel surfaces. Build to recommended film thickness in one coat.

RECOMMENDED USES : An excellent primer for use in fabrication installations such as : rail cars, marine containers, and others where a fast dry primer is needed. Carboline 656 may be topcoated with a variety of topcoats.

NOT RECOMMENDED FOR : Immersion service or solvent exposure.

NOT RECOMMENDED FOR : Exposure to strong acids, alkalis, or corrosive environments without topcoat.

CHEMICAL RESISTANCE GUIDE : (with recommended topcoat)

<u>Exposure*</u>	<u>Heavy Fumes or Light Splash and Spillage</u>	<u>Outside Weathering or Mild Fumes</u>
Acids	Good	Excellent
Alkalies	Very Good	Excellent
Solvents	Good	Excellent
Salt	Excellent	Excellent
Water	Excellent	Excellent

TEMPERATURE RESISTANCE :

Continuous : 200°F(93°C)

Non-continuous : 250°F(121°C)

FLEXIBILITY : Very Good

WEATHERING : Excellent

ABRASION RESISTANCE : Very Good

SUBSTRATES : Apply over properly prepared steel, cast iron, galvanized steel, or others. Consult carboline for specific recommended.

TOPCOAT REQUIRED : Can be topcoated with most generic type of coatings, including catalyzed epoxies, vinyls, chlorinated rubber, acrylics or other as recommended.

COMPATIBILITY WITH OTHER COATING : Should be applied directly to substrate, or over inorganic zinc. Other primers should be recommended from Carboline technical service.

Specification Data

SOLIDS CONTENT By Volume: 48% ± 2%

ZINC CONTENT By Weight: 85% ± 2%

RECOMMENDED DRY FILM THICKNESS PER COAT :
2-6 mils (50-150µ)

THEORETICAL COVERAGE PER MIXED GALLON*:

783 mil sq. ft. (19.2 sq. m/l at 25µ).

261 sq. ft. at 3 mils (6.4 sq. m/l at 75µ).

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

SHELF LIFE : 1 year minimum

COLORS : Green. Redish Gray

GLOSS : Flat

Ordering Information

APPROXIMATE SHIPPING WEIGHT :

	<u>2's</u>	<u>5's</u>
Carboline 656	41 lbs.(18.5 kg)	102 lbs.(46.2 kg)
Carboline Thinner #11	9 lbs. in 1's (4.1 kg)	45 lbs. in 5's (20.4 kg)

FLASH POINT : (Pensky-Martens Closed Cup)

Carboline 656 Part A

40°F(4°C)

Carboline 656 Part B

77°F(25°C)

Carboline Thinner #11

77°F(25°C)

Prices may be obtained from Carboline sales representative or main office. Terms-Net 30 days.

Carboline® 656

SURFACE PREPARATION : Remove any oil or grease from surface to be coated with clean rags soaked in Carboline Thinner #2 or Toluol, as per SSPC-SP 1.

Steel : For non-immersion service, dry abrasive blast to a commercial finish in accordance with SSPC-SP 6-63 to a degree of cleanliness in accordance with NACE #3 to obtain a 1 to 3 mil (25-75µ) blast profile. Acceptable-Power Tool cleaning per SSPC-SP3-63 for non-immersion.

MIXING : Mix separately, then combine and mix in the following proportions:

	<u>2Gal.Kit</u>	<u>10 Gal. Kit</u>
Carboline 656 Part A	1.6 Gallon	8 Gallons
Carboline 656 Part B	0.4 Gallon	2 Gallons

Thin up to 25% by volume with Carboline Thinner #11 or #33.

POT LIFE : 6 Hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag or gel.

APPLICATION TEMPERATURES :

	<u>Material</u>	<u>Surfaces</u>
Normal	60-90°F(16-32°C)	65-85°F(18-29°C)
Minimum	40°F(5°C)	40°F(5°C)
Maximum	120°F(49°C)	165°F(74°C)
	<u>Ambient</u>	<u>Humidity</u>
Normal	60-90°F(16-32°C)	20-80%
Minimum	40°F(5°C)	0%
Maximum	120°F(49°C)	85%

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

SPRAY : Use adequate air volume for correct operation . Hold gun 8-10 inches from the surface and at a right angle to the surface.

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 3/8" I.D. Mat'l. Hose.

<u>Mfr. & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	66C	63PB
DeVilbiss P-MBC or JGA	FF	704
	Approx..052" I.D.	Approx. 9-10 cfm @ 30 psi

Airless : Use a 3/8" I.D. Mat'l. Hose.

<u>Mfr. & Gun</u>	<u>Pump*</u>
DeVilbiss JGB-507	QFA-514
Graco 205-591	President 30 : 1 or Bulldog 30 : 1
Binks Model 500	Mercury 5C

* Teflon packings are recommended and are available from pump manufacturer. Use a .017-.021" tip with 2000~2200 psi.

BRUSH : For touch up only, areas less than 1 sq.ft. Use

DRYING TIMES : (at 50 mic DFT)

<u>Temperature</u>	<u>Before Topcoating*</u>
40°F(5°C)	24 Hours
50°F(10°C)	18 Hours
60°F(16°C)	12 Hours
75°F(24°C)	6 Hours
90°F(32°C)	4 Hours

medium bristle brush. Avoid rebrushing.

* If left exposed to atmosphere for a prolonged period prior to topcoating surface must be dry and clean from any dirt or chalked coating.

CLEAN UP : Use Carboline Thinner #2.

STORAGE CONDITIONS :

Temperature : 50-110°F(10-43°C)
Humidity : 0-90%

For more detailed information please consult specific Carboline application guides.

CAUTION: CONTAINS 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 ELECTRIC 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.

