

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Polyamide zinc-rich epoxy
<b>Description</b>	A high performance, two component, organic zinc-filled primer specifically formulated to provide corrosion protection to steel surfaces in salt and weathering environments. It has good surface tolerant characteristics where steel surface preparation may be less than ideal. It may also be used for the repair of aged inorganic zinc-rich coatings or galvanised steel surfaces.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Exceptional corrosion resistance</li> <li>• Extremely high zinc loading - 90% by weight in dry film</li> <li>• Provides excellent cathodic protection</li> <li>• Excellent adhesion to commercial blast cleaned surfaces</li> <li>• Excellent for repairs to inorganic zinc silicate primers and aged/deteriorated galvanising</li> <li>• Meets the requirements of AS/NZS 3750.9, Type 2 Organic Zinc Rich</li> <li>• Conforms to the composition and performance requirements of SSPC-Paint 20 Type II Organic</li> <li>• As a brush applied maintenance primer tolerant to traces of surface moisture</li> <li>• As a holding / weld-through primer when applied less than 25 microns dry</li> </ul>
<b>Colour</b>	Grey and Green
<b>Finish</b>	Flat
<b>Film Build</b>	50 - 100 microns dry. Typically applied at 75 microns dry
<b>Solid(s) Content</b>	By Volume 58%
<b>Zinc Content in Dry Film</b>	By Weight 90%
<b>Theoretical Coverage Rates</b>	11.6m <sup>2</sup> /litre at 50 microns dry 7.7m <sup>2</sup> /litre at 75 microns dry 5.8m <sup>2</sup> /litre at 100 microns dry  Allow for loss in mixing and application.
<b>VOC Values</b>	<b>As Supplied</b> : 382 g/L (mixed)
<b>Dry Temp. Resistance</b>	Continuous: 121°C (250°F) Non-Continuous: 200°C (392°F)
<b>Limitations</b>	<ul style="list-style-type: none"> <li>• Do not topcoat with alkyd coatings</li> <li>• Not suitable for solvent, chemical, or water immersion service</li> </ul>
<b>Topcoats</b>	May be topcoated with acrylics, epoxies, polyurethanes, and others as recommended by Carboline

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	<p>All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application.</p> <p>Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner.</p>
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# Carbozinc 15-625

## PRODUCT DATA SHEET



### SUBSTRATES & SURFACE PREPARATION

**Steel** | Abrasive blast to SSPC-SP 6 (AS 1627.4 Sa 2) minimum and achieve a uniform jagged blast profile of 35µm (minimum) and up to 75µm.  
Minimum power-tool clean to SSPC-SP 3 (AS 1627.2 St 3) for touch-up.

### PERFORMANCE DATA

Test Method	Results
Adhesion – ASTM D4541	Excellent
Humidity Resistance – ASTM D2247	Excellent
Salt Spray Resistance – ASTM B117	Excellent

### MIXING & THINNING

**Mixing** | The zinc metal is ready mixed in the base portion. Power mix the base portion first to obtain a smooth, homogeneous condition. After mixing the base portion add the converter slowly with continued agitation. **DO NOT MIX PARTIAL KITS.**  
Strain through a 30 to 60 mesh sieve prior to use.  
Keep mixed material under slow agitation to keep zinc in suspension.

**Thinning** | Spray: Thinning in the range of 5% to 15% addition of Altex Thinning Solvent #12 may be expected, depending upon conditions.  
Brush/Roller: Thin up to 5 to 10% by volume with Thinner #25 or #33.  
When applying as a holding / weld-through primer at film thicknesses of 20-25 microns dry it is recommended to thin the mixed material up to 30% by volume with Altex Thinning Solvent #12 for optimum film thickness control; at high thinning levels an agitated pot is recommended.  
  
Use of thinners other than those supplied or recommended by Altex Coatings may adversely affect product performance and void product warranty, whether expressed or implied.

**Ratio** | 4:1 by volume

**Pot Life** | 12 hours at 25°C  
Higher temperatures will reduce the working life of the coating; lower temperatures will increase it.

**Induction Time** | 30 minutes

### 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.

**Spray Application (General)** | The following spray equipment has been found suitable and is available from equipment manufacturers. Keep material under mild agitation during application.

**Conventional Spray** | Agitated pressure pot equipped with dual regulators, 12 mm (1/2") I.D. minimum material hose, 2.8mm (.110") I.D. fluid tip and appropriate air cap.

**Airless Spray** | Pump Ratio: 30:1  
Material Hose: 3/8" I.D min  
Tip Size 0.021 – 0.025

(Note: The above is a guide. Other equipment to the above may be used.)

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**Brush & Roller (General)** | For small areas, this coating may be brush or roller applied if conditions are suitable, however, care must be taken to ensure the correct film build is applied.

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	2°C (36°F)	2°C (36°F)	0%
Maximum	32°C (90°F)	50°C (122°F)	35°C (95°F)	90%
Optimum	20°C (68°F)	20°C (68°F)	20°C (68°F)	30%

Industry standards are for substrate temperatures to be above the dew point. Carbozinc 15-625 is unique in that it can tolerate traces of surface moisture.

## CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat
10°C (50°F)	12 Hours	16 Hours
16°C (61°F)	10 Hours	14 Hours
25°C (77°F)	8 Hours	12 Hours
32°C (90°F)	6 Hours	8 Hours

These times are based on a 50 micron dry film thickness at 50% relative humidity. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

**Maximum Time to Recoat:** Unlimited. Must have a clean, dry surface for topcoating. "Loose" chalk or salts must be removed in accordance with good painting practice. Consult Carboline Technical Service for specific information.

## CLEANUP & SAFETY

**Cleanup** | Use Altex Thinning Solvent #12

**Safety** | For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label, and the Safety Data Sheet (SDS) for health and safety information prior to use.

**Ventilation** | When used in enclosed areas and product is thinned, 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 vapour concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to ensure all personnel are below guidelines. If not sure or if not able to monitor levels, use suitable approved respirator.

## PACKAGING, HANDLING & STORAGE

**Shelf Life** | Part A: Min. 9 months at 24°C  
Part B: Min. 24 months at 24°C

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

**Storage Temperature & Humidity** | Optimum: 5-35°C  
0-85% Relative Humidity

# Carbozinc 15-625

## PRODUCT DATA SHEET



## PACKAGING, HANDLING & STORAGE

**Flash Point (Setaflash)** | 21°C

**Shipping Weight  
(Approximate)** | 3.0 kg per litre  
5 litre kit – 15 kg

**Storage** | Store under cool, dry conditions and should be protected from frost, weather, moisture, direct sunlight, and contamination ingress.

## WARRANTY

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