

SELECTION & SPECIFICATION DATA

Generic Type	High Solids DTM Epoxy
Description	Carboguard 904 is a two component, amine cured epoxy formulated for use as a direct-to-metal (DTM) exterior coating with excellent corrosion and chemical resistance.
Features	Exterior coating for railcars applied in one coat by plural component equipment.
Color	Gray (2758), Black (C900), White (S800) Other colors may be available upon request. Contact your Carboline Representative for more details.
Finish	Gloss
Primer	Self-priming
Dry Film Thickness	4 - 8 mils (102 - 203 microns) per coat
Solids Content	By Volume 98% +/- 2%
Theoretical Coverage Rate	1572 ft²/gal at 1.0 mils (38.6 m²/l at 25 microns) 393 ft²/gal at 4.0 mils (9.6 m²/l at 100 microns) 196 ft²/gal at 8.0 mils (4.8 m²/l at 200 microns) Allow for loss in mixing and application.
VOC Value(s)	As supplied: 0.17 lbs/gal (21 g/l)
Limitations	Epoxies may lose gloss, discolor, and chalk when exposed to sunlight.

SUBSTRATES & SURFACE PREPARATION

General	Clean to remove all contaminants in accordance with SSPC-SP 1. Substrate must be clean and dry.
Ferrous Metal	Abrasive blast clean to a minimum NACE No.3/SSPC-SP 6 Commercial Blast Cleaning with a minimum of 2.0 mils (51 microns) profile that is sharp, angular and dense.
Non-Ferrous Metals	Abrasive blast clean to a SSPC-SP 16 with a minimum of 2.0 mils (51 microns) profile that is sharp, angular and dense.

MIXING & THINNING

Ratio	1:1 by volume
Pot Life	15 minutes @ 77 °F (25 °C)

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)	Airless plural component, heated spray equipment capable of 3000 psi with a mixer manifold and whip hose is required for the application of this material. Contact Carboline Technical Service for additional information.
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APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	100°F (38°C)	60°F (16°C)	50°F (10°C)	0%
Maximum	125°F (52°C)	130°F (54°C)	100°F (38°C)	90%

CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Recoat	Maximum Recoat
77°F (25°C)	2 Hours	10 Hours	7 Days

CLEANUP & SAFETY

Cleanup | Thinner 76 or Acetone

Safety | Consult SDS for proper handling, cleanup, disposal, and use of personal protective equipment. Circulate sufficient air to maintain working environment below the PEL and LEL. Apply according to local, state, and federal (OSHA) regulations.

PACKAGING, HANDLING & STORAGE

Shelf Life | 24 months

Storage | 40 -110 °F (4-43 °C)
0-100% Relative Humidity

Flash Point (Setaflash) | Part A: 201 °F (94 °C)
Part B: 201 °F (94 °C)

WARRANTY

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