

SELECTION & SPECIFICATION DATA

Generic Type	Solventless, three-component, aggregate-filled, cross-linked epoxy.
Description	Carboguard 695 PM is a solventless, epoxy surfacer or patching mortar that is used to transition between floor-wall chine areas, lap-welded plates, rivets, etc. It is typically used with a reinforced mat system specifically designed to comply with API RP652 for thick-film tank bottom lining repairs. It is suitable for exposures in water, crude oil, aromatic distillates, and unblended gasolines. It is typically applied by broadknife, spatula, trowel, brush, or other suitable tool that allows heavy applications and smoothing procedures.
Features	<ul style="list-style-type: none"> • Solventless, high performance protection • Low-to-no odor • Easy to apply by hand tools • Excellent chemical resistance • Fast cure • Tough abrasion resistant film • Excellent corrosion protection • Impact resistant • Flexural strength (>5000 psi) • Hi-build application • Low temperature cure (35°F)
Color	Brown
Finish	High Gloss (Epoxies lose gloss, discolor and eventually chalk in sunlight exposure).
Primer	Self-priming, or Phenoline 311 as a holding primer
Dry Film Thickness	250 - 500 mils (6350 - 12700 microns) per coat
Solids Content	By Volume 99% +/- 2%
Theoretical Coverage Rate	1588 ft ² /gal at 1.0 mils (39.0 m ² /l at 25 microns) 6 ft ² /gal at 250.0 mils (0.2 m ² /l at 6250 microns) 3 ft ² /gal at 500.0 mils (0.1 m ² /l at 12500 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 0.06 lbs./gal (7 g/l)
Dry Temp. Resistance	Continuous: 250°F (121°C) Non-Continuous: 300°F (149°C) Discoloration and loss of gloss is observed above 200°F (93°C).

SUBSTRATES & SURFACE PREPARATION

General	Remove all oil or grease from the surface to be coated with clean rags soaked in Thinner 2 or Carboline Surface Cleaner 3 (refer to Surface Cleaner 3 instructions) in accordance with SSPC-SP1. For girth weld areas, all burrs, weld slag and other matter shall be removed to achieve a smoother surface prior to blasting.
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SUBSTRATES & SURFACE PREPARATION

Steel | This material is used to repair steel bottom storage tanks which are typically pitted and may have severe loss of steel. Heavy pits need to be filled in with a suitable putty or resin while other areas may need steel plate over-layment or replacement.
Abrasive blast to a Near White Metal Finish in accordance with SSPC-SP 10 and obtain a 3.0 mil (75 micron) blast profile. If the blasted steel cannot be coated before it begins to flash rust, a holding primer Phenoline 311 should be used.

Concrete or CMU | The concrete must be cured for 28 days (at 75°F/50% R.H.) or until the concrete reaches its designated compressive strength. Prepare and clean the surface in accordance with SSPC-SP13/ NACE No. 6 guidelines. Test for moisture by conducting a plastic sheet testing in accordance with ASTM D4263.

MIXING & THINNING

Mixing | Premix each liquid component separately, than add together Part B into Part A and mix until uniform. Then slowly add Filler # 50 until homogenous.
Kit (1.5 gals total)
Part A: 0.75 gal
Part B: 0.25 gal
Part C: 10.7 lbs (Filler # 50)

Thinning | Thinning is not normally required. 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: 3:1 Ratio (A to B)
Aggregate: 10.7 lbs

Pot Life | 60 minutes (large kit) at 80°F (27°C). The pot life ends when the material becomes too viscous to use.

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.

Application Procedure | *This product may be applied using brush, roller, spatula, broad-knife, or trowel.
1. Follow mixing instructions contained in this data page.
2. Use suitable tool (trowel, broadknife, brush, spatula, etc, to apply and smooth mixed material over substrate.
3. Apply in chine areas, over rivets, lap welds, etc, to minimize sharp edges or smooth out abrupt terminations/transitions.
4. Material will be firm enough for overcoating in 8 hrs @75°F.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	35°F (2°C)	35°F (2°C)	10%
Maximum	90°F (32°C)	110°F (43°C)	110°F (43°C)	95%

This product 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 Recoat
35°F (2°C)	48 Hours
50°F (10°C)	24 Hours
75°F (24°C)	8 Hours
100°F (38°C)	4 Hours

Insufficient heat or cooler temperatures will require longer cure times. This product has a very high tolerance for moisture during cure; however excessive humidity or condensation on the surface may cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing recoating.

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 SDS for this product. Employ normal workmanlike safety precautions.
Ventilation	While this is a solventless epoxy, it is common practice when used as a tank lining or in enclosed areas to circulate the air during and after application until the coating is cured. Minimal protection is needed when proper ventilation is achieved. The ventilation system should be capable of preventing any solvent vapor concentration from reaching the lower explosion limit for any solvents that may be present. 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 supplied air respirator.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 24 months at 75°F (24°C) Part B: 18 months at 75°F (24°C) Part C: 24 months at 75°F (24°C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40° - 110°F (4° - 43°C) 0-80% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	1.5 Gallon Kit - 26 lbs. (12 kg)
Flash Point (Setaflash)	Part A: >205°F (96°C) Part B: >230°F (110°C)

Carboguard[®] 695 PM

PRODUCT DATA SHEET



WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.