

Selection & Specification Data

Generic Type	Polyamide Epoxy with corrosion inhibitor, (zinc phosphate)
Description	Carbomastic 94 is a high performance, surface tolerant, high build, corrosion resistant epoxy mastic. It has outstanding adhesion to metal substrates and most aged coatings and offers maximum protection against severe weather conditions, corrosion, moisture penetration and general industrial environments. It wets and penetrates firm rust and tight crevices and resists further rust deterioration. Use it on tank exteriors, structural steel, piping, process equipment, bridges & water towers. Carbomastic 94 may also be used on barges, vessels and other marine applications. An optional micaceous iron oxide, (MIO), additive can be purchased separately and may be used per its Product Data Sheet to further enhance the coating's performance.
Features	<ul style="list-style-type: none"> • Surface tolerant mastic • Custom colors available • Excellent wetting properties • Excellent adhesion • Tolerant of existing coatings • Class A flame spread rated
Color	Refer to Carboline color chart
Finish	Semi-Gloss (35-70)
Primer	Self priming. May be used over zinc-rich primers or other epoxies.
Dry Film Thickness	5 mils (127 microns) per coat 7 mils (178 microns) per coat
Solids Content	By Volume 86% +/- 2%
Theoretical Coverage Rate	1379 ft ² /gal at 1.0 mils (33.9 m ² /l at 25 microns) 276 ft ² /gal at 5.0 mils (6.8 m ² /l at 125 microns) 197 ft ² /gal at 7.0 mils (4.8 m ² /l at 175 microns)
VOC Values	Allow for loss in mixing and application. As Supplied 1.0 lbs/gal (120 g/l)
Topcoats	May be coated with Acrylics, Epoxies, 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	SSPC-SP2, SP3, SP7, or SP12 are acceptable methods. Use SSPC-SP6 with a 2.0-3.0 mil (50-75 micron) surface profile for maximum protection.
Galvanized Steel	For optimum performance sweep blast cleaning is recommended. Consult your Carboline Sales Representative for specific recommendations.

Substrates & Surface Preparation

Previously Painted Surfaces Lightly sand or abrade to roughen and degloss the surface. Existing paint must attain a minimum 3A rating in accordance with ASTM D3359 "X-Scribe" adhesion test.

Mixing & Thinning

Mixing	Thoroughly mix each component using mechanical agitation. Pour the activator, part B, into part A (mixing ratio by volume: 1 part activator, part B, to 1 part base, part A) and mix well using mechanical agitation.
Thinning	Mixed Carbomastic 94 may be thinned to a maximum of 25 fluid ounces per gallon with Thinner 248. Do not thin beyond allowable local VOC regulations.
Pot Life	Maximum 4 hours at 77 °F (25 °C). In order to maintain application properties, mix (activate) only what can be applied in 4 hours. Allow 15 minutes induction time at 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)	Apply using airless spray. Use a 50% overlap with each pass when spraying to eliminate holidays and pinholes.
Airless Spray	Apply using pump able to deliver a minimum of 3000 psi. Material Hose: 3/8" I.D. (min.) Tip Size: 0.019-0.023" High Pressure Filter: 30 Mesh
Brush	Natural bristle or nylon/polyester
Roller	1/4-3/8" woven/phenolic core for smooth surfaces, 3/4-1 1/4" nap for rough surfaces.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Minimum	50 °F (10 °C)	50 °F (10 °C)	50 °F (10 °C)	0%
Maximum	90 °F (32 °C)	110 °F (43 °C)	110 °F (43 °C)	100%

Curing Schedule

Surface Temp.*	Dry to Recoat	Dry to Touch
75 °F (24 °C)	18 Hours	6 Hours

Expect longer dry times in periods of higher humidity or lower temperatures or when applying thicker films. The following dry times are for exterior exposures at recommended film thickness with good ventilation. The general requirement is a 24 hour cure for Carboline epoxy intumescent applications. The temperature of the substrate during coating application must be at least 5°F above the dew point of the air. * Note Dry to Recoat is 18 hours or within 1 year.

Cleanup & Safety

Cleanup	Clean up all tools and equipment promptly with Thinner 2.
----------------	---

Carbomastic[®] 94

Cleanup & Safety

Safety Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

Packaging, Handling & Storage

Shelf Life Part A: 36 months
Part B: 36 months
*Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.

Shipping Weight (Approximate) 2 Gal Kit - 29 lbs (13.2 kg)
10 Gal Kit - 139 lbs (63.2 kg)

Storage Temperature & Humidity 40-120 °F (4-49 °C) Store indoors
(Can be stored down to 20 °F (-7 °C) for no longer than 30 days)
0-100% Relative Humidity

Flash Point (Setaflash) Part A: 89 °F (32 °C)
Part B: 84 °F (29 °C)

Storage Store Indoors



October 2017

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 or injuries resulting from use. Liability, if any, is limited to replacement of products. 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. Carboline® and Carboguard® are registered trademarks of Carboline Company.

107F