

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy mastic
Description	Aluminum-pigmented, low-stress, high-solids mastic with a proven field history. Carbomastic 15 was the pioneer mastic coating in a number of industrial markets and today still provides unmatched levels of barrier protection and corrosion resistance over existing finishes and rusted or SSPC-SP2 or SP3-cleaned steel.
Features	<ul style="list-style-type: none"> • Excellent performance over minimal surface preparation of steel substrates • Suitable as a topcoat for most tightly adhered existing coatings • Excellent choice for field touch-up of zinc-rich primers and galvanized steel • Unique formulation with aluminum flakes provides exceptional barrier protection • Available in a low temperature cure version (Carbomastic 15 FC) • Suitable for use under insulation on hot surfaces operating up to 300 °F (150 °C) • VOC compliant to current AIM regulations
Color	Aluminum (C901); Red (M500) Color variations within a batch and from batch to batch may occur due to the metallic pigments and variations in application techniques and conditions. *Red (M500) is available for use as a contrasting primer in multiple coat applications, but should always be topcoated.
Primer	Self-priming. May be applied over most tightly adhering coatings as well as inorganic zinc primers.
Dry Film Thickness	3 - 5 mils (76 - 127 microns) over existing coatings 7 - 10 mils (178 - 254 microns) in one or two coats in severe exposures Do not exceed 10.0 mils (250 microns) in a single coat.
Solids Content	By Volume 90% +/- 2%
HAPs Values	As supplied: 0.70 lbs/solid gal
Theoretical Coverage Rate	1444 ft ² /gal at 1.0 mils (35.4 m ² /l at 25 microns) 481 ft ² /gal at 3.0 mils (11.8 m ² /l at 75 microns) 144 ft ² /gal at 10.0 mils (3.5 m ² /l at 250 microns) Allow for loss in mixing and application.
Severe Exposures	Temperature resistance under insulation: Up to 300°F(150°C) Discoloration is observed above 180°F(82°C) but does not affect performance.
VOC Values	As Supplied : 0.7 lbs/gal (88 g/l) Thinner 10 : 32 oz/gal: 2.0 lbs/gal (242 g/l) Thinner 236 E : 32 oz/gal: 0.7 lbs/gal (88 g/l) Thinner 72 : 32 oz/gal: 2.07 lbs/gal (248 g/l) Thinner 76 : 32 oz/gal: 1.9 lbs/gal (231 g/l) These are nominal values.
Topcoats	May be coated with Acrylics, Epoxies, Alkyds, 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 in accordance with SSPC-SP 1 and follow the guidelines below.
Steel	<p><u>Immersion</u>: NACE No. 2/SSPC-SP 10 with a 2.0-3.0 mil (50-75 microns) surface profile. <u>Non-Immersion</u>: NACE No. 3/SSPC-SP 6 with a 2.0-3.0 mil (50-75 microns) surface profile for maximum protection. SSPC-SP 2, SSPC-SP 3, NACE No. 4/SSPC-SP 7, NACE/SSPC WJ-1 to WJ-4, or SSPC-SP 14 are also acceptable methods. For alternate methods contact Carboline Technical Service.</p> <p>When using under fireproofing products, defer to the primer surface preparation requirements in the product data sheet of the fireproofing product.</p>
Galvanized Steel	<p>For optimum performance clean and abrade in accordance with SSPC-SP 16.</p> <p>When using under fireproofing products, defer to the primer surface preparation requirements in the product data sheet of the fireproofing product.</p>
Previously Painted Surfaces	Clean and lightly sand or abrade to roughen and degloss the surface. Existing coating must attain a minimum 3A rating in accordance with ASTM D3359 adhesion test.

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	System	Results
ASTM 4060 Taber Abrasion	1 ct. CM15	130 mg loss; 1000 cycles using CS 17 wheel and 1000 gm load,
ASTM B117 Salt Spray	Rusted Steel 1 ct. CM 15	No blistering, rusting, or softening No rust creep from scribe
ASTM D1735 Water Fog	Rusted Steel 1ct CM 15	No blistering or softening, No creep from scribe
ASTM D522 Flexibility	Blasted steel 1 ct. CM15	A) Conical - crack 0.38", actual elongation 48.57% B) Cylindrical- no cracking observed
ASTM G 14 Impact Resistance	A) Blasted Steel 1 ct. CM 15, B) Rusted Steel 1 ct. CM 15	Area Damaged A) 1/4 inch (0.25") B) 1/4 - 9/16 inch (0.44")

Test reports and additional data available upon written request.

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
Thinning	May be thinned up to 32 oz/gal (25%) with Thinner 10 for normal conditions. For application to hot substrates up to 200 °F (93 °C) it is recommended to thin approximately 25% (32 oz/ gal) with Thinner 230. Thinner 72 may be used for hot or windy conditions. Use Thinner 76 for nonphotochemically reactive thinner or Thinner 236E for exempt thinner. Use of thinners other than those recommended and supplied by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	1:1 Ratio (A to B)

MIXING & THINNING

Pot Life	2 hours @ 75 °F (24 °C) unthinned.
	1 hour @ 90 °F (32 °C) unthinned
	Pot life ends when coating 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.

Spray Application (General)	The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, 0.086" I.D. fluid tip and appropriate air cap.
Airless Spray	Pump Ratio: 30:1 (min.)* GPM Output: 3.0 (min.) Material Hose: 3/8" I.D. (min.) Tip Size: 0.019-0.025" Output PSI: 1900-2100 Filter Size: 60 mesh *PTFE packings are recommended and available from the pump manufacturer.
Plural Component	May be applied by plural component spray equipment. Contact Carboline Technical Service for specific recommendations.
Brush & Roller (General)	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or rerolling. Use clean natural bristle brush or medium nap phenolic core roller. Work coating into all irregularities.

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)	200°F (93°C)	100°F (38°C)	95%

This product simply 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 and/or thinning may be required for application when conditions are above and below normal application conditions.

CURING SCHEDULE

Surface Temp.	Final Cure Immersion	Dry to Recoat or Topcoat
50°F (10°C)	15 Days	5 Days
60°F (16°C)	10 Days	3 Days
75°F (24°C)	5 Days	24 Hours
90°F (32°C)	3 Days	18 Hours

For CM 15 Dry to Touch is 5 hours at 75 °F (24 °C). Maximum re-coat/topcoat times are 30 days for epoxies and 90 days for polyurethanes at 75 °F (24 °C).

*These times are based on a 5.0-7.0 mil (125-175 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. Recoat intervals may vary from those listed above when using under intumescent fireproofing products. Consult Carboline Technical Service for recommended cure times before applying Carboline intumescent products. If the maximum recoat time is exceeded, the surface must be abraded by sweep blasting prior to the application of additional coats. **Note:** This product contains conductive pigments and cannot be holiday tested.

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. Use adequate ventilation. Keep container closed when not in use.
Ventilation	When used as a tank lining or in enclosed areas, 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 vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A & B: Min. 36 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	45° - 110°F (7-43°C) 0-90% Relative Humidity
Storage	Store Indoors. This product is solvent based and not affected by excursions below these published storage temperatures, down to 10°F, for a duration of no more than 14 days. Always inspect the product prior to use to make sure it is smooth and homogeneous when properly mixed.
Shipping Weight (Approximate)	2 Gallon Kit - 25 lbs (11 kg) 10 Gallon Kit - 124 lbs (56 kg)
Flash Point (Setaflash)	Part A: >200°F (93°C) Part B: 76°F (24°C)

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.