

SELECTION & SPECIFICATION DATA

Generic Type	Two-components modified epoxy coating.
Description	Carbomastic 18 NT is a heavy duty, high build coating for protection of steel in corrosive environments. Gives a hard and smooth surface with excellent flexibility.
Features	<ul style="list-style-type: none"> • Excellent immersion performance in both fresh and sea water. • Suitable as a rust preventing coating in ballast tanks. • Ideal for subsea installations, jackets and other areas prone to condensation. • Very good abrasion resistance.
Color	Several RAL colours
Finish	Semi-Gloss
Primer	Self-priming
Wet Film Thickness	155 - 620 µm per coat, normally 320 µm.
Dry Film Thickness	125 - 500 microns (4.92 - 19.68 mils) per coat Normally 250 µm.
Solid(s) Content	By volume: 80% ± 2%
Theoretical Coverage Rates	6,4 m ² /l at 125 µm Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 120°C (248°F) Non-Continuous: 150°C (302°F)
Approvals	<ul style="list-style-type: none"> • Det Norske Veritas classification B1 according to Testing Classification of Ballast Tank Coatings. • NORSOK M-501 System #7 Submerged
Limitations	Not recommended for immersion service in aromatic or ketone solvents and strong oxidizing acids. Epoxies discolour and eventually chalk in sunlight exposure.
Topcoats	Normally not topcoated

SUBSTRATES & SURFACE PREPARATION

General	Surface 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	<u>Immersion:</u> ISO 8501-1 Sa 2½ with a 50 – 75 microns surface profile. <u>Non-immersion:</u> ISO 8501-1 St 2-3 is acceptable. Alternatively, ultra high pressure water jetting to Nace No.7 min. C Vis WJ-2. Max flash rust; C Vis WJ-2M.

MIXING & THINNING

Mixing	Power mix separately, then add part B to Part A and power mix. DO NOT MIX PARTIAL KITS.
Thinning	May be thinned up to 15% with Carboline Thinner #15.

Carbomastic 18 NT

PRODUCT DATA SHEET



MIXING & THINNING

Ratio | 4 : 1 (A to B)

Pot Life | 6 Hours at 20°C and less at higher temperatures.

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.

General | The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

Airless Spray | Pump ratio: 30:1 (min.) *
GMP Output: 3.0 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .023-.027"
Output PSI: 2100-2300
Filter Size: 60 mesh

* Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) | For small areas and stripe coating. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding.

Brush | Use a medium bristle brush.

Roller | Use a medium nap phenolic core roller.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	5°C (41°F)	0%
Maximum	35°C (95°F)	50°C (122°F)	40°C (104°F)	85%

Industry standards are for substrate temperatures to be 3°C 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	Final Cure
5°C (41°F)	26 Hours	18 Days
10°C (50°F)	18 Hours	14 Days
15°C (59°F)	12 Hours	10 Days
20°C (68°F)	8 Hours	6 Days
25°C (77°F)	7 Hours	4 Days

These times are based on recommended DFT. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

CLEANUP & SAFETY

Cleanup	Use Carboline 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 MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
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.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with applicable regulations. In areas where explosion hazards exist, workmen should be required to use nonferrous tools and wear conductive and nonsparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	Maximum 24 months at 24°C
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Storage	Store indoors.
Packaging	Part A 16 liters Part B 4 liters

WARRANTY

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