

## SELECTION & SPECIFICATION DATA

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

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	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.
<b>Steel</b>	<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

<b>Mixing</b>	Power mix separately, then add part B to Part A and power mix. DO NOT MIX PARTIAL KITS.
<b>Thinning</b>	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.

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## CLEANUP & SAFETY

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<b>Cleanup</b>	Use Carboline Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	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.
<b>Ventilation</b>	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.
<b>Caution</b>	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.

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## PACKAGING, HANDLING & STORAGE

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

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## 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.