Carbomastic 20

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Two-components modified epoxymastic.
Description	Corrosion resistant epoxy mastic with very good protection against fresh- and salt water.
Features	• Surface tolerant • Fast curing at low temperatures • High solids give good coverage and reduced solvent emission
Color	Buff and light grey. Others upon request.
Finish	Semi-Gloss
Primer	Refer to “Substrates and Surface Preparation”.
Wet Film Thickness	120 – 350 µm per coat, normally 155 µm.
Dry Film Thickness	100 - 300 microns (3.94 - 11.81 mils) per coat Normally 130 µm.
Solid(s) Content	By volume: 85 ± 2%
Theoretical Coverage Rates	6,5 m²/l at 130 µm. Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 120°C (248°F) Non-Continuous: 150°C (302°F)
Limitations	Not recommended for immersion service in aromates, ketones or strong oxidizing acids. **Note:** Epoxies lose gloss, discolour and eventually chalk in sunlight exposure.
Topcoats	May be topcoated with most two-pack topcoats.

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	For immersion service, blast clean to Sa 2½ (ISO 8501-1), for other service St 2-3 (ISO 8501-1) may be sufficient. 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 combine and power mix.
Thinning	May be thinned up to 15% with Thinner # 2. 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	3 : 1 Ratio (A to B) by volume.
Pot Life	3 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.

Spray Application	The following spray equipment has been found suitable and is available from manufactures such as Binks, De Vilbis and Graco:
Airless Spray	Pump Ratio: 30:1 (minimum) GPM Output: 3.0 (minimum) 12 liters/min. Material Hose: 3/8” I.D. (minimum) Tip Size: .017”-.023” Output PSI: 2400 Filter Size: 60 mesh Teflon packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Recommended for small areas only.

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	Maximum Recoat
5°C (41°F)	24 Hours	30 Days
15°C (59°F)	10 Hours	20 Days
20°C (68°F)	8 Hours	10 Days
25°C (77°F)	5 Hours	10 Days

* These times are based on 130 µm 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 #2 Thinner 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 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.

CLEANUP & SAFETY

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 non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	36 months at 24°C.
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Storage	Store indoors
Packaging	Part A : 15 litres Part B : 5 litres

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.