

SELECTION & SPECIFICATION DATA

Generic Type	Two-components modified epoxy coating.
Description	Carbomastic 25 gives a smooth and hard surface. The coating is very solid and provides excellent protections against corrosion. Carbomastic 25 is suitable at application at low temperatures.
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	Grey and off-white
Finish	Semi-Gloss
Primer	Steel, concrete or suitable primers as Carbozinc 858. May be applied directly over galvanized steel, aluminum and stainless steel.
Wet Film Thickness	125 - 500 µm per coat, normally 220 µm. (For airless spray)
Dry Film Thickness	125 - 400 microns (4.92 - 15.75 mils) per coat Normally 175 µm. (For airless spray)
Solid(s) Content	By volume: 80 ± 2%
Theoretical Coverage Rates	4,9 m ² /l at 175 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 aromatic or ketone solvents and strong oxidizing acids. Epoxies discolour and eventually chalk in sunlight exposure.
Topcoats	Normally not topcoated for submerged exposures, otherwise topcoat according to Carboline recommendations.

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, abrasive blast cleaning to min. Sa 2 (ISO 8501-1). For non-immersion service, hand- or power tool cleaning to min. St 2 (ISO 8501-1) 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 #2.
Ratio	1 : 1 (A to B) by volume

Carbomastic 25

PRODUCT DATA SHEET



MIXING & THINNING

Pot Life | 2 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 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: .019-.025"
- Output PSI: 2400
- Filter Size: 60 mesh

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

Brush & Roller (General) | Carbomastic 25 can be applied with brush or roller, 50 – 100 µm per coat can be reached depending on application technique and tools. Multiple coats may be necessary to obtain recommended film thickness.

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)	2°C (36°F)	2°C (36°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)	17 Hours	15 Days
10°C (50°F)	10 Hours	12 Days
15°C (59°F)	6.5 Hours	9 Days
20°C (68°F)	4 Hours	7 Days
25°C (77°F)	3 Hours	5 Days

* Maximum recoating time is 1-2 months depending on temperature and curing conditions. If exceeded, contact Carboline for further information about recoating procedures.

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

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 24°C
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Storage	Stores indoors.
Packaging	Part A 10 litres Part B 10 litres

WARRANTY

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