

SELECTION & SPECIFICATION DATA

General Paint Name		Surface-tolerant, high-build epoxy polyurethane resin paint
Generic Type		Epoxy/ polyurethane
Description		High-build epoxy polyurethane resin primer with excellent fast-curing characteristics. Two-coat application with compatible topcoat can be achieved in a single day. Recommended for the use for internal and external steel structures, especially where shortening of work periods is strongly desired, such as mechanical multistory parking facilities. Also suitable for nonferrous substrates such as galvanized steel, stainless steel, or aluminum.
Features		<ul style="list-style-type: none"> • Excellent adhesion characteristics to steel and nonferrous substrates • Free of harmful heavy metals • "Low VOC paint" (Weight solids \geq 70%)
Color		White and Light Colors
Primer		Direct to substrates.
Solid(s) Content		By Volume 61% +/- 2%
Solids Content		By Weight 78% +/- 2%
Mixed Density		1.53 +/- 0.05 g/ cm ³
VOC Values		As Supplied : 337 g/ L

Application Method	Dry Film Thickness (microns/coat)	Theoretical Coverage Rate (g/m ²)	Practical Coverage Rate (g/m ²)*
Spray	125	309	560
Brush/ Roller	70	173	220-260

*: Practical Coverage Rates are estimates based on average results. Individual results may vary based on several issues including the shape and location of the item being painted as well as environmental conditions like temperature, humidity and wind. The skill level of those applying the paint will also impact the final results. For details, consult Japan Carboline staff.

Wet/ Dry (As Supplied)		1.64
Sag Resistance (Dry)		240 microns
Dry Temp. Resistance		Continuous: 120°C (248°F)
Limitations		<ul style="list-style-type: none"> • Not recommended for immersion services. • This product is moisture-sensitive. Avoid contact with moisture. Do not leave containers open.
Topcoats		Carbomastic Color II Winter Grade, Carbothane 233 HB, Carbothane 234 HS, Siloxane Ace HB, etc.

SUBSTRATES & SURFACE PREPARATION

General		Surfaces must be clean and dry. Remove loose rust, existing coatings, dust and all other contaminants with hand tools or power tools in accordance with ISO St 2.
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Carbomastic Mighty Sokkan

PRODUCT DATA SHEET



MIXING & THINNING

Mixing	Power mix Part A, combine with Part B, then power mix until uniform consistency. In principle, the whole contents in the containers of Part A and B should be mixed together. When using partial kits out of necessity, agitate Part A and B separately, until uniform consistency, use a scale to weigh each part precisely, then combine and power mix until uniform consistency.
Thinning	Use of Carboline Thinner 25 or 72 is recommended. Use of thinners other than those supplied or recommended by JAPAN CARBOLINE may adversely affect product performance.
Ratio	Part A : Part B = 90 : 10 (by weight)
Pot Life	5°C: 4 hours 10°C: 3 hours 20°C: 2 hours 30°C: 1 hours In summer, pay enough attention to pot life when applying.

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.

Application Tool	Airless spray, Air spray, Brush, Roller
Airless Spray	<ul style="list-style-type: none">• Pump Ratio: 30 : 1• Output Pressure: 10-15 MPa• Tip Size: 0.015-0.021"• Filter Size: 50 Mesh (if needed)• Thinning: 5-15 weight %• Appropriate Viscosity: 0.5-2.0 Pa·s (5-20 Poise)

APPLICATION CONDITIONS

Condition	Surface	Ambient	Humidity
Minimum	0°C (32°F)	0°C (32°F)	0%
Maximum	50°C (122°F)	38°C (100°F)	85%

CURING SCHEDULE

Surface Temp.	Dry Hard	Dry to Topcoat Maximum	Dry to Topcoat Minimum
5°C (41°F)	8 Hours	30 Days	8 Hours
10°C (50°F)	6 Hours	21 Days	6 Hours
20°C (68°F)	4 Hours	14 Days	4 Hours
30°C (86°F)	2.5 Hours	7 Days	2.5 Hours

Curing schedule is based on 125 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.

PACKAGING, HANDLING & STORAGE

Shelf Life | 12 months (when kept in original unopened containers)

Storage | Store indoors.

Net Weight	20 kg kit	10 kg kit
Part A	18 kg	9 kg
Part B	2 kg	1 kg

Flash Point (Setaflash) | Part A: 18°C
Part B: 18°C
Carboline Thinner 25: 27°C
Carboline Thinner 72: -9°C

UPDATE INFORMATION

Last Modified | June, 2022

Control Number | PDS033-015

WARRANTY

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