

SELECTION & SPECIFICATION DATA

General Paint Name	Intermediate coating for mild solvent-based coatings
Generic Type	Epoxy/ polyamide amine
Description	Mild solvent-based epoxy intermediate coating with environmental- and human-friendliness. Can be applied with airless spray, brush, or roller. Recommended for the use for the following; <ul style="list-style-type: none"> - Steel structures such as roofs, tank exterior, bridges, towers, piping and building structures - Nonferrous substrates such as galvanized steel and stainless steel - Steel members in architectural structures such as doors, stairs, and handrails
Features	<ul style="list-style-type: none"> • Free of harmful heavy metals • Excellent adhesion characteristics to various primers and topcoats • Excellent water resistance and application characteristics
Color	White, Light Colors, and others
Primer	Carbomastic Mild, etc.
Solid(s) Content	By Volume 44% +/- 3%
Solids Content	By Weight 65% +/- 3%
Mixed Density	1.30 +/- 0.05 g/ cm ³
VOC Values	As Supplied : 455 g/ L

Application Method	Dry Film Thickness (microns/coat)	Theoretical Coverage Rate (g/m ²)	Practical Coverage Rate (g/m ²)*
Spray	30	88	160 ~ 170
Brush/ Roller	30	88	120 ~ 140

*: 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)	2.27
Sag Resistance (Dry)	80 microns
Dry Temp. Resistance	Continuous: 120°C (248°F) Non-Continuous: 135°C (275°F)
Limitations	Not recommended for immersion services in water, acids, alkalis, or solvents.
Topcoats	Carbothane Mild, Fulon Ace FII HB Mild, etc.

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry. Remove any oil or grease from surface to be coated with clean rags soaked in an adequate solvent.
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Multi-Gard 25 JC Color Mild

PRODUCT DATA SHEET



MIXING & THINNING

	Power mix Part A, combine with Part B, then power mix until uniform consistency.
Mixing	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 until uniform consistency, use a scale to weigh each part precisely, then combine and power mix until uniform consistency.
	Use of Carboline Thinner 45 is recommended.
Thinning	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: 10 hours 10°C: 7 hours 20°C: 5 hours 30°C: 4 hours

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, Brush, Roller
Airless Spray	Pump Ratio: 30 : 1 Output Pressure: 12-15 MPa Tip Size: 0.015-0.019" Filter Size: 50 Mesh (if needed) Thinning: up to 10 weight % Appropriate Viscosity: 0.5-1.0 Pa·s (5-10 Poise)

APPLICATION CONDITIONS

Condition	Surface	Ambient	Humidity
Minimum	5°C (41°F)	5°C (41°F)	0%
Maximum	50°C (122°F)	38°C (100°F)	85%

CURING SCHEDULE

Surface Temp.	Dry Hard	Dry to Topcoat Minimum	Maximum Recoat Time	Maximum Topcoat Time with Other Finishes
5°C (41°F)	48 Hours	48 Hours	30 Days	7 Days
10°C (50°F)	36 Hours	24 Hours	25 Days	7 Days
20°C (68°F)	24 Hours	24 Hours	20 Days	7 Days
30°C (86°F)	24 Hours	24 Hours	15 Days	7 Days

Curing schedule is based on 30 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. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A, B: 12 months
	When kept in original unopened containers.
Storage	Store indoors.
Packaging	Part A, B: 12 months
	When kept in original unopened containers.

Net Weight	16 kg kit
Part A	14.4 kg
Part B	1.6 kg

Flash Point (Setaflash)	Part A: 41°C
	Part B: 41°C
	Carboline Thinner 45: 41°C

UPDATE INFORMATION

Last Modified	May, 2023
Control Number	PDS184-004

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 to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. Carboline warrants our products to be free of manufacturing defects in accord with applicable Carboline quality control procedures. THIS WARRANTY IS NOT VALID WHEN THE PRODUCT IS NOT: (1) APPLIED IN ACCORDANCE WITH CARBOLINE'S SPECIFICATIONS, AND/OR (2) PROPERLY STORED, CURED, AND USED UNDER NORMAL OPERATING CONDITIONS. Carboline assumes no responsibility for coverage, performance, injuries, or damages resulting from use of the product. If this product is found not to perform as specified upon inspection by a Carboline representative during the warranty period, Carboline's sole obligation, if any, is to replace the Carboline product(s) proven to be defective or refund the purchase price thereof, at Carboline's sole option. Carboline shall not be liable for any other losses or damages. This warranty excludes (1) labor and costs of labor for the application or removal of any product, and (2) any incidental or consequential damages, whether based on breach of express or implied warranty, negligence, strict liability or any other legal theory. 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. The whole text of this Product Data Sheet, as well as the documents derived from it, have been written in English, and for legal purposes the English version shall prevail.