

SELECTION & SPECIFICATION DATA

General Paint Name | Deep-penetrating epoxy sealer

Generic Type | Epoxy/ polyamine

Description | Epoxy resin primer/ sealer with excellent corrosion resistance due to its deep-penetrating characteristics. Can be applied over marginally-prepared surfaces. Extremely-low internal contraction stress during curing will cause no peeling from existing coatings. Recommended for the use as a maintenance primer/ sealer for marginally-prepared steel surfaces or existing coatings, as a primer for nonferrous substrates, and as a tie-coat for coatings which had exceeded their "recoat windows."

- Features**
- Excellent corrosion resistance and penetrating characteristics into rusted surfaces
 - Excellent adhesion property to various topcoats and to various substrates such as steel, rusted surface, galvanized steel, nonferrous metals, and existing coatings
 - Very-high solids (96% by volume), VOC-compliant
 - Free of harmful heavy metals
 - Low odor
 - "Low VOC paint" (Weight solids ≥ 70%)

Color | Translucent Yellow

Solid(s) Content | By Volume 96% +/- 2%

Solids Content | By Weight 97% +/- 1%

Mixed Density | 1.07 +/- 0.03 g/ cm³

VOC Values | **As Supplied** : 37 g/ L

Application Method	Dry Film Thickness (microns/coat)	Theoretical Coverage Rate (g/m ²)	Practical Coverage Rate (g/m ²)*
Brush	25	28	90-120

*: 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) | 1.05

Sag Resistance (Dry) | 48 microns

Dry Temp. Resistance | Continuous: 80°C (176°F)
Non-Continuous: 93°C (199°F)

- Limitations**
- Not recommended for immersion services.
 - Not recommended for services without suitable topcoats.
 - Epoxies lose gloss, discolor and eventually chalk in sunlight exposure.

Topcoats | Carbomastic 15 T, Carbomastic 15II, Carbomastic Color II, Carbomastic Mighty, Carbothane 233 HB, Carbothane 234 HS, etc.

SUBSTRATES & SURFACE PREPARATION

General	Surfaces 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	ISO St 2 or St 3
Galvanized Steel	ISO St 2 or St 3
Previously Painted Surfaces	A test patch is recommended to verify compatibility with existing coatings.

MIXING & THINNING

Mixing	Combine Part A and B, and 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 until uniform consistency, use a scale to weigh each part precisely, then combine and power mix until uniform consistency.
Thinning	Not recommended. Carboline Thinner 2 may be used, but only for the cleaning purpose of application equipment. Use of thinners other than those supplied or recommended by JAPAN CARBOLINE may adversely affect product performance.
Ratio	Part A : Part B = 55 : 45 (by weight)
Pot Life	10°C: 8 hours 20°C: 4 hours 30°C: 2 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 | Brush

Brush | Apply enough material to uniformly wet the surface to be coated. Excessive wet thickness must be avoided, and any puddles formed must be brushed out.

APPLICATION CONDITIONS

Condition	Surface	Ambient	Humidity
Minimum	10°C (50°F)	10°C (50°F)	0%
Maximum	50°C (122°F)	40°C (104°F)	85%

CURING SCHEDULE

Surface Temp.	Dry Hard	Maximum Topcoat Time	Minimum Topcoat Time
10°C (50°F)	60 Hours	30 Days	60 Hours
20°C (68°F)	24 Hours	14 Days	24 Hours
30°C (86°F)	10 Hours	7 Days	10 Hours

Curing schedule is based on 25 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	4 kg kit
Part A	2.2 kg
Part B	1.8 kg

Flash Point (Setaflash) | Part A: 69°C
Part B: 79°C
Carboline Thinner 2: -9°C

Carboline Thinner 2 may be used, but only for the cleaning purpose of application equipment.

UPDATE INFORMATION

Last Modified | June, 2022

Control Number | PDS061-015

WARRANTY

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