

SELECTION & SPECIFICATION DATA

Generic Type	Solvent-free epoxy phenalkamine
Description	Self-priming epoxy lining with excellent adhesion, flexibility and abrasion resistance. May be applied directly to a properly prepared steel surface to provide outstanding corrosion protection.
Features	<ul style="list-style-type: none"> • Single or dual coat system for internal lining of pipes and tanks carrying potable water, brine and wastewater • Improves throughput of pipelines • Good flexibility • Good weathering (chalks) • Excellent abrasion resistance • Not recommended for immersion service in strong mineral or organic acids or solvent exposure
Color	Pipe Blue and Light Grey only
Finish	Gloss (70-85)
Dry Film Thickness	150 to 600 microns A two coat system at 500 microns is recommended to ensure a pinhole-free film and adequate coverage over welds, etc.
Solid(s) Content	By Volume 100%
Theoretical Coverage Rates	2.0m ² /litre at 500 microns 4.0m ² /litre at 250 microns NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.
Temperature Resistance (Immersion)	Continuous: 65°C Non-continuous: 82°C Immersion temperature resistance depends on exposure. Consult StonCor Africa Sales or Technical Service Department for specific cargo and temperature recommendations. It is recommended that tanks and pipes operating at 60°C or above be insulated to extend coating life.
Topcoats	Can be used as a multi-coat system and serves as both first and finish coats.

SUBSTRATES & SURFACE PREPARATION

General	Remove any oil or grease from surface to be coated prior to abrasive blast cleaning. Abrasive blast in accordance with ISO 8501 Sa2½ to obtain a 50 to 100 micron blast profile. Note: Sa2½ is a minimum. Generally good practice to attain Sa3 to ensure surface cleanliness is maximized and thus lifespan improved, specifically in full immersion conditions. Soluble salt concentration must be below 100mg/m ² when tested with a Weber Reilly detection kit.
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PERFORMANCE DATA (TYPICAL VALUES)

Test Method	System	Results
Adhesion ASTM D4541	Carboguard 550	> 9 MPa
Potable Water SANS 241	Carboguard 550	Complies

Carboguard 550

PRODUCT DATA SHEET



MIXING & THINNING

Mixing | Power mix separately, then combine and mix in the following proportions:
5 Litre kit:
Part A: 3.7 litre
Part B: 1.4 litre
20 Litre kit:
Part A: 14.8 litre
Part B: 5.6 litre

Pot Life | 40 Minutes at 25°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.

Airless Spray | 60:1 pump
Spray hose should be 12 to 15mm I.D. Use a high delivery airless spray gun (direct material feed to spray head) equipped with a reversible, self-cleaning tip, orifice size .017 to .023" and no whip end hose.
Recommended operating pressure is 3 to 6 bar.

Brush & Roller (General) | Brush recommended for small areas and touch-up only. Roller application is not recommended.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	16°C (61°F)	10°C (50°F)	6°C (43°F)	0%
Maximum	32°C (90°F)	45°C (113°F)	43°C (109°F)	90%
Optimum	24°C (75°F)	24°C (75°F)	24°C (75°F)	50%

Do not apply or cure material when the surface temperature is below 10°C or less than 3°C above the dew point.

CURING SCHEDULE

Surface Temp.	Final Cure	Maximum Recoat	Minimum Recoat Time	Dry to Handle	Dry Hard
16°C (61°F)	14 Days	72 Hours	24 Hours	NR	NR
25°C (77°F)	7 Days	48 Hours	8 Hours	6 Hours	24 Hours
30°C (86°F)	5 Days	36 Hours	6 Hours	NR	NR

Relative Humidity: 50%

The main must be completely isolated from the supply and water prevented from contacting the uncured lining.

Ready for flushing after 14 hours at 25°C.

If maximum recoat time is exceeded and recoat is necessary, special surface preparation will be required.

NOTE: Excessive humidity or condensation on the surface during curing may result in a surface haze or blush which should be removed by water washing before recoating.

CLEANUP & SAFETY

Cleanup | Use Thinner # 2

CLEANUP & SAFETY

Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions.
Ventilation	When used as a pipe lining or in enclosed areas, thorough air circulation must be provided during and after application until the coating is cured. In addition to proper ventilation, fresh air respirators or fresh air hoods must be used by all application personnel. Where flammable solvents exist, explosion proof lighting equipment must be used. Hypersensitive persons should wear protective clothing, gloves and/or protective cream on face, hands and all exposed areas.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 Months minimum when stored at 25°C *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	5 Litre: Part A: 5.6kg Part B: 1.78kg 20 Litre Part A: 21.7kg Part B: 5.6kg
Storage Temperature & Humidity	4 to 32°C 0 to 100% Store indoors
Flash Point (Pensky Martens Closed Cup)	Part A: >93°C Part B: >93°C

WARRANTY

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