Carbomastic 96

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	High build, two component epoxy mastic containing zinc and aluminium
Description	This high build, zinc-filled primer penetrates and encapsulates rust and provides galvanic protection over clean, bare steel. Aluminium platelets form a barrier to penetration. Very tolerant to salt contamination over cleanest practical surface, making Carbomastic 96 more suitable for coastal environments. Compatible over most coatings and old paint, is readily topcoated with many generic types.
Features	• Maintenance primer for corrosive environments over blast-cleaned or hand/power-tool cleaned steel • Excellent primer for two coat maintenance systems where minimum downtime is desirable • Suitable for offshore, pulp and paper, bridge and tank-farm applications • Good flexibility • Excellent weathering • Fair abrasion resistance • May be used over most generic types of coatings which are tightly adhering and properly prepared (a test patch is recommended for use over existing coatings) • Not recommended for immersion service in acids, alkalies or solvents
Color	Metallic Grey and Pink
Finish	Flat (0-10)
Dry Film Thickness	75 to 125 Microns 75 Microns recommended over blast-cleaned steel prepared to ISO 8501-1:2007, Sa2 125 Microns recommended over tool-cleaned steel prepared to ISO 8501-1:2007, St2
Solid(s) Content	By Volume 54% ± 2%
Theoretical Coverage Rates	7.2m²/litre at 75 microns 4.3m²/litre at 125 microns **NOTE:** Allow for mixing and application losses.
Dry Temp. Resistance	Continuous: 82°C (180°F) Non-Continuous: 121°C (250°F)
Topcoats	Carbothane 134 or other coatings as recommended by StonCor Africa Technical Service.

SUBSTRATES & SURFACE PREPARATION

General	Remove oil and grease before abrasive blast cleaning or hand/power tool cleaning.
Steel	For severe environments, dry abrasive blast clean to ISO 8501-1:2007, Sa2. For less severe environments, blast clean to ISO 8501-1:2007 Sa1. Mild steel may alternatively be hand or power tool cleaned to ISO 8501-1:2007, St3.

MIXING & THINNING

Mixing	Power mix each component separately, then combine and mix thoroughly. **5 Litre Kit** Part A: 3 Litre Part B: 2 Litre

MIXING & THINNING

Thinning	Thinning not normally required. Where necessary, thin up to 12% by volume with Thinner # 10. **NOTE:** Use of thinners other than those supplied or approved by StonCor Africa may adversely affect product performance and void product warranty, whether express or implied.
Ratio	By volume: 3:2 (Part A : Part B)
Pot Life	4 Hours at 25°C. Pot life is shorter at higher temperatures and ends when material becomes too viscous to apply.

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	Use sufficient air volume for correct operation of equipment. Apply each pass with approximately a 50% overlap. On irregular surfaces, coat the edges first, making an extra pass later.
Conventional Spray	Use 12mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at a right angle to the surface. **Gun:**905 Spray Gun **Fluid Tip:**1.8mm **Air Cap:**905-PV
Airless Spray	Use 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at a right angle to the surface. **Gun:**TRITECH T360 Spray Gun **Pump:**47:1 * PTFE packings are recommended and are available from the pump manufacturer. Use a .021 to .025” tip with 2400 psi (165 Bar).
Brush	Use natural bristle brush applying with full strokes. Avoid rebrushing.
Roller	Not recommended

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	32°C (90°F)	45°C (113°F)	38°C (100°F)	85%
Optimum	24°C (75°F)	26°C (79°F)	26°C (79°F)	55%

Special thinning and application techniques may be required above or below normal conditions.
Do not apply when the surface temperature is less than 3°C above the dew point.

CURING SCHEDULE

Surface Temp.	Final Cure	Between Coats
16°C (61°F)	10 Days	3 Days
25°C (77°F)	5 Days	24 Hours
32°C (90°F)	3 Days	18 Hours

CURING SCHEDULE

Curing Details	**Relative Humidity: 50%**

CLEANUP & SAFETY

Cleanup	Use Thinner # 2.
Safety	Read and follow all caution statements on this product data sheet and on the material safety data sheet for this product. Use suitable PPE and normal industrial safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
Ventilation	Provide effective ventilation during application and cure, particularly in enclosed areas. Refer to the latest Safety Data Sheet for this product. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. In addition to ensuring proper ventilation, appropriate respirators must be used by all application personnel.

PACKAGING, HANDLING & STORAGE

Shelf Life	12 Months minimum when stored at 25°C in original unopened container. ***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**
Shipping Weight (Approximate)	**5 Litre** Carbomastic 96: 10.9kg Thinner # 10: 4.9kg
Storage Temperature & Humidity	7 to 43°C 0 to 100%
Flash Point (Pensky Martens Closed Cup)	Part A: 12°C Part B: 26°C Thinner # 10: 24°C
Storage	Store indoors

WARRANTY

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