Carbomastic 94 MC

PRODUCT DATA SHEET

SELECTION & SPECIFICATION DATA

Generic Type	Polyamide Epoxy
Description	A high performance, surface tolerant, high build, corrosion resistant epoxy mastic. It has outstanding adhesion to metal substrates along with most aged coatings and offers maximum protection against severe weather conditions, corrosion, moisture penetration and general industrial environments. It wets and penetrates firm rust and tight crevices and resists further rust deterioration. Use it on tank exteriors, structural steel, piping, process equipment, bridges & water towers. Carbomastic 94 MC may also be used on barges, vessels and other marine applications.
Features	• Surface tolerant epoxy mastic • Excellent corrosion protection • Low VOC, passes Berkeley Analytical VOC Emissions Tests • Custom colors available via RTS • Excellent wetting properties and adhesion • High solids, low stress over existing coatings • High film build, up to 7 mils DFT per coat • Class A Flame Spread and Smoke Development • Excellent durability • Good flexibility and impact resistance • Outstanding abrasion resistance • Good chemical resistance • Long pot life • Long maximum re-coat-up to 1 year • Approved topcoat over many Carboline Fireproofing Materials
Color	RTS capable, refer to Carboline color chart.
Finish	Semi-Gloss
Primer	Self priming. May be used over zinc-rich primers or other epoxies.
Dry Film Thickness	127 microns (5 mils) per coat 178 microns (7 mils) per coat
Solids Content	By Volume 86% +/- 2%
Theoretical Coverage Rate	33.9 m²/l at 25 microns (1379 ft²/gal at 1.0 mils) 6.8 m²/l at 125 microns (276 ft²/gal at 5.0 mils) 4.8 m²/l at 175 microns (197 ft²/gal at 7.0 mils) Allow for loss in mixing and application.
VOC Values	**As Supplied** : 1.0 lbs/gal (120 g/l)
Topcoats	May be coated with Acrylics, Epoxies, or Polyurethanes depending on exposure and need.

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 in accordance with SSPC-SP 1. Contact Carboline Technical Service for recommendations.

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Steel	New Steel: it is recommended that the steel be abraded, preferably to a minimum of Commercial Blast Clean with 1.5 to 3 mils (37 to 75 microns) anchor profile in accordance with NACE No. 3/ SSPC-SP 6. For alternative methods contact Carboline Technical Service. Weathered (corroded) Steel: for optimum performance abrasive blast clean to a minimum of Commercial Blast with 1.5 to 3 mils (37 to 75 microns) anchor profile in accordance with NACE No. 3/SSPC-SP 6. Alternative methods may include SSPC-SP 2, SSPC-SP 3, NACE No. 4/SSPC-SP 7, or NACE/SSPC WJ-1 to WJ-4. Contact Carboline Technical Service for recommendations.
Galvanized Steel	For optimum performance clean and abrade in accordance with SSPC-SP 16. Contact Carboline Technical Service for recommendations.
Previously Painted Surfaces	Clean and lightly sand or abrade to roughen and degloss the surface. Existing coating must attain a minimum 3A rating in accordance with ASTM D3359 adhesion test.

MIXING & THINNING

Mixing	Thoroughly mix each component using mechanical agitation. Pour the activator, part B, into part A (mixing ratio by volume: 1 part activator, part B, to 1 part base, part A) and mix well using mechanical agitation.
Thinning	Mixed Carbomastic 94 MC may be thinned to a maximum of 25 fluid ounces per gallon with Thinner 225 E, Thinner 236 E, or Thinner 243 E. Use of solvents other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Pot Life	Maximum 4 hours at 77°F. In order to maintain application properties, mix (activate) only what can be applied in 4 hours. Allow 15 minutes induction time at 77°F.

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 (General)	Apply using airless spray. Use a 50% overlap with each pass when spraying to eliminate holidays and pinholes.
Airless Spray	Apply using pump able to deliver a minimum of 3000 psi. Material Hose: 3/8" I.D. (min.) Tip Size: .019-.023" High Pressure Filter: 30 Mesh
Brush	Natural bristle or nylon/polyester
Roller	1/4-3/8" woven/phenolic core for smooth surfaces, 3/4- 1¼" nap for rough surfaces.

CURING SCHEDULE

Surface Temp.	Dry to Recoat	Dry to Touch
24°C (75°F)	18 Hours	6 Hours

Expect longer dry times in periods of higher humidity or lower temperatures or when applying thicker films. The following dry times are for exterior exposures at recommended film thickness with good ventilation. The temperature of the substrate during coating application must be at least 5°F above the dew point of the air. * Note Dry to Recoat is 18 hours or within 1 year.

CLEANUP & SAFETY

Cleanup	Clean up all tools and equipment promptly with Thinner #2.
Safety	Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A: 36 months Part B: 36 months *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	0° - 110°F (4° - 43°C) 0-100% Relative Humidity
Storage	Store Indoors.
Shipping Weight (Approximate)	¿2-Gal Kit - 29 lbs 10-Gal Kit - 139 lbs
Flash Point (Setaflash)	Part A - 89°F (32°C) Part B - 84°F (29°C)

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.