

SELECTION & SPECIFICATION DATA

Generic Type	Modified epoxy
Description	This epoxy is a fast-curing, heavy-duty, high-build anti-corrosive coating with a broad and versatile list of uses in marine and other corrosive environments. It is an excellent choice for the protection of ship hull exteriors, underwater and ballast tanks. Offshore applications include splash zone, sub-sea, jackets, production decks, drilling rig legs and pontoons in immersed exposures.
Features	<ul style="list-style-type: none"> • Excellent immersion performance in both fresh and sea water • Suitable as a rust preventive coating in ballast tanks and hull applications • Ideal for sub-sea installations, jackets and other areas exposed to sea water • Can be applied as low as 5°C (40°F) • Good flexibility • Very good abrasion resistance • High solids; low VOC
Color	Standard: Off White (1702)
Finish	Semi-Gloss
Primer	Self-priming
Dry Film Thickness	127 - 203 microns (5 - 8 mils) per coat Normally applied in 7 mil (175 microns) thicknesses. May be applied up to 20 mils (500 microns) in one or more coats depending on application.
Solids Content	By Volume 85% +/- 2%
Theoretical Coverage Rate	33.5 m ² /l at 25 microns (1363 ft ² /gal at 1.0 mils) 6.7 m ² /l at 125 microns (273 ft ² /gal at 5.0 mils) 4.2 m ² /l at 200 microns (170 ft ² /gal at 8.0 mils) Allow for loss in mixing and application.
VOC Values	As Supplied : X.XX lbs/gal (yyy g/l) Thinner 2 : X.XX lbs./gal (yyy g/l) These are nominal values.
Dry Temp. Resistance	Continuous: 121°C (250°F) Non-Continuous: 149°C (300°F) Epoxies discolor (darken) when exposed to elevated temperatures.
Limitations	Epoxies lose gloss, discolor and eventually chalk in sunlight exposure. Not recommended for immersion in aromatic or ketone solvents or strong oxidizing acids.

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. Carboline Surface Cleaner 3 is recommended.
Steel	Immersion: (SSPC-SP10) with a 2-3 mil surface profile. Non-Immersion: (SSPC-SP2) minimum is acceptable.

Carbomastic 18 FC - mfd.

PRODUCT DATA SHEET



MIXING & THINNING

Mixing | Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.

Thinning | Up to 15% with Thinner #2

Ratio | 1:1 Ratio (Part A to B) by Volume

Pot Life | 2 Hours at 75°F 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.

Spray Application (General) | The following spray equipment has been found suitable and is available from manufacturers.

Airless Spray

Pump Ratio: 30:1 (min.)*
Volume Output: 3.0 gpm min.
Material Hose: 3/8" I.D. min.
Tip Size: 0.019-0.025"
Output Pressure: 2200-2400 psi
Filter Size: 60 mesh
*PTFE packings are recommended and available from the pump manufacturer.

Brush & Roller (General)

For small areas only. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Use a good quality brush or medium nap synthetic core roller.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	4°C (40°F)	2°C (35°F)	2°C (35°F)	0%
Maximum	35°C (95°F)	52°C (125°F)	38°C (100°F)	85%

Industry standards are for substrate temperatures to be 5°F above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Recoat	Final Cure
4°C (40°F)	24 Hours	18 Days
10°C (50°F)	15 Hours	14 Days
21°C (70°F)	7 Hours	7 Days
27°C (80°F)	5 Hours	5 Days

These times are based on a 5-8 mil dry film thickness. Higher than recommended film thicknesses, insufficient ventilation, or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure.

CLEANUP & SAFETY

Cleanup

Use Thinner #2. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

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 in enclosed areas, thorough air circulation must be used during and after application until the coating is cured. The ventilation system should be capable of preventing the solvent vapor concentration from reaching the lower explosion limit for the solvents used. User should test and monitor exposure levels to insure all personnel are below guidelines.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 40°F-110°F *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	2 Gal. Kit - 30 lbs (13.6 kg) 10-Gal Kit - 138 lbs (62.7 kg)
Storage Temperature & Humidity	40°F-110°F (5°-45°C) 0-100% Relative Humidity
Flash Point (Setaflash)	Part A: 80°F (27°C) Part B: 90°F (32°C)
Storage	Store Indoors.

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