

SELECTION DATA

GENERIC TYPE : Two component, high build, low temperature modified aluminum epoxy mastic.

GENERAL PROPERTIES : Carbomastic 15 LT is a high build coating with excellent adhesion to rusted steel and most aged coatings. Proven long-term protection in immersion service and against for corrosion.

RECOMMENDED USES : Ideal for offshore structures, marine, metal buildings, piping, process equipment, highway bridges and exposed structural steel. May also be used where hand tool cleaned steel is being coated for the first time. Excellent maintenance system for piping, bridges, ships and offshore structure, etc.

NOT RECOMMENDED FOR : Immersion service in acids, alkalis or solvents.

CHEMICAL RESISTANCE GUIDE :

<u>Exposure</u>	<u>Immersion</u>	<u>Splash & Spillage</u>	<u>Fumes</u>
Acids	NR	Good	Excellent
Alkalies	NR	Good	Excellent
Solvents	NR	Excellent	Excellent
Salt Water	Excellent	Excellent	Excellent
Fresh Water	Excellent	Excellent	Excellent

N/R = Not recommended.

TEMPERATURE RESISTANCE : (Non-immersion)

Continuous : 250°F(121°C)
Non-continuous : 300°F(149°C)

WEATHERING : Very Good

SUBSTRATES : Apply over properly prepared metal or other surfaces as recommended. May be used over most generic type of coatings which are tightly adhering to substrate including organic and inorganic zinc primers.

COMPATIBILITY WITH OTHER COATINGS : May be used over most generic types of coatings which are tightly adhering and properly prepared. A topcoat is not normally required but most generic types of coatings may be applied as topcoats. Consult Carboline Technical Service for specific recommendation.

SPECIFICATION DATA

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL :

	<u>By Volume</u>
Carbomastic 15 LT	86% ± 2%

RECOMMENDED DRY FILM THICKNESS PER COAT :

1. 100-400μ : Recommended (Min.-Max.)
2. 150μ : Standard.

For severe exposure including immersion, a minimum total thickness of 8-12 mils (200-300μ) applied in 1 or 2 coats is recommended.

Dry film thickness in excess of 16 mils (400μ) per coat is not recommended. Excessive film thickness over inorganic zinc will increase damage during shipping and erection.

THEORETICAL COVERAGE PER MIXED GALLON* :

1379 mil sq. ft. (34.4 sq. m / ℓ @ 25μ)
230 sq. ft. at 6 mils (5.7 sq. m / ℓ @ 150μ)

*NOTE : Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

STORAGE CONDITIONS : Store Indoor

Temperature : 45-110°F(7-43°C)
Humidity : 0-90%

SHELF LIFE : 24 months when stored at 75°F(24°C).

GLOSS : Semi-gloss

COLORS : Aluminum(C901) is standard. Other colors are available by special request for use as a contrasting primer in multiple coat application.

ORDERING INFORMATION

Prices may be obtained from Carboline Sales Representative or Main Office.

APPROXIMATE SHIPPING WEIGHT :

	<u>5's</u>
Carbomastic 15 LT	66 lbs.(30 kg)
Carboline Thinner #2	39 lbs.(18 kg)
Carboline Thinner #25	42 lbs.(19 kg)

FLASH POINT : (Pensky-Martens Closed Cup)

Carboline Thinner #2	24°F(-5°C)
Carboline Thinner #25	90°F(32°C)

APPLICATION INSTRUCTIONS

SURFACE PREPARATION : Remove any oil or grease from the surface to be coated with clean rags soaked in Carboline Thinner #2 in accordance with SSPC-SP 1.

Steel : For immersion service, dry abrasive blast to a near white metal finish in accordance with NACE #2 to obtain a 2 to 3 mils (50-75µ) blast profile. However, hand or power tool cleaning is acceptable to standard in many cases to remove non adhering paint and rust. Carbomastic 15 penetrates through rust to steel substrate and stops further corrosion and undercutting.

MIXING : Power mix separately, then combine and mix in the following proportions.

	<u>2 Gal. kit</u>	<u>5 Gal. kit</u>
Carbomastic 15 LT Part A	1 Gal	2.5 Gal
Carbomastic 15 LT Part B	1 Gal	2.5 Gal

Thin up to 25% by volume with Carboline Thinner #2.

POT LIFE : 11/2 hours at 68°F(20°C) and less at higher temperatures. Pot life ends when the coating loses body and begins to sag.

APPLICATION TEMPERATURES :

	<u>Material</u>	<u>Surfaces</u>
Normal	60-85°F(15-30°C)	65-85°F(15-30°C)
Minimum	40°F(5°C)	23°F(-5°C)
Maximum	90°F(32°C)	120°F(49°C)

	<u>Ambient</u>	<u>Humidity</u>
Normal	60-85°F(15-30°C)	35-80%
Minimum	23°F(-5°C)	0%
Maximum	105°F(40°C)	85%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point.

SPRAY : Use sufficient air volume for correct operation of equipment. Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

NOTE : The following equipment has been found suitable, However equivalent equipment may be substituted.

CONVENTIONAL : Pressure pot equipment with dual regulators, 3/8" I.D. minimum material hose, 0.086" I.D. fluid tip and appropriate air cap.

AIRLESS :

Pump Ratio	: 30:1 (min.)
GPM Output	: 3.0 (min.)
Material Hose	: 3/8" I.D.(min.)
Tip Size	: 0.019-0.025"
Output PSI	: 1900-2100
Filter Size	: 60 mesh

*Teflon packings are recommended and available from the pump manufacturer.

BRUSH OR ROLLER : Use medium bristle brush or medium nap phenolic core roller.

DRYING TIMES : These times are based on a 6mils(150µm) dry film thickness. Higher film thicknesses, cooler temperatures or insufficient ventilation will lengthen cure time and could result in solvent entrapment and premature failure.

<u>Temperature</u>	<u>To Recoat</u>	<u>Final Cure</u>
23°F(-5°C)	60 hours	15 days
32°F(0°C)	42 hours	10 days
40°F(5°C)	36 hours	7 days
50°F(10°C)	18 hours	5 days
68°F(20°C)	10 hours	3 days
85°F(30°C)	6 hours	2 days

Note : Carbomastic 15 LT meets the criterias set for NS 5403. The complete system will also meet the most stringent requirements in NS 5415

CLEAN UP : Use Carboline Thinner #2

VOC+ (Volatile Organic Compounds) coatings with high solid, in other words, coatings that are less hazardous, more environmentally safe, and more economical for users.

VENTILATION & SAFETY : When used as a tank lining or 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. In addition to ensuring 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 clean protective clothing, gloves and/or protective cream on face, hands and all exposed areas.

CAUTION: CONTAINS FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST. WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.

