

SELECTION & SPECIFICATION DATA

Generic Type	Epoxy mastic
Description	Aluminum-pigmented, low-stress, high-solids, and low temperature cure epoxy mastic with a proven field history. Carbomastic 15 LT provides unmatched levels of barrier protection and corrosion resistance over existing finishes and rusted or Hand Tool/Power Tool Cleaned steel.
Features	<ul style="list-style-type: none"> • Excellent performance over minimal surface preparation of steel substrates • Suitable as a topcoat for most tightly adhered existing coatings • Excellent choice for field touch-up of zinc-rich primers and galvanized steel • Unique formulation with aluminum flakes provides exceptional barrier protection • Low temperature cure down to 1.7°C (35°F)
Color	C901 (Aluminum) Color variations within a batch and from batch to batch may occur due to the metallic pigments and variations in application techniques and conditions.
Finish	Semi-Gloss
Primer	Self-priming. May be applied over most tightly adhering coatings as well as inorganic zinc primers.
Dry Film Thickness	3 - 5 mils (76 - 127 microns) over existing coatings 7 - 12 mils (178 - 305 microns) in one or two coats in severe exposures Do not exceed 305 microns (12.0 mils) in a single coat.
Solids Content	By Volume 86% +/- 2%
Theoretical Coverage Rate	1379 ft ² /gal at 1.0 mils (33.9 m ² /l at 25 microns) 460 ft ² /gal at 3.0 mils (11.3 m ² /l at 75 microns) 115 ft ² /gal at 12.0 mils (2.8 m ² /l at 300 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : 254 g/l (2.12 lbs/gal)
Dry Temp. Resistance	Continuous: 248°F (120°C) Non-Continuous: 302°F (150°C)
Limitations	Not recommended for immersion service.
Topcoats	May be topcoated with most generic types. Some alkys or oil modified paints exhibit poor adhesion. Topcoat should be applied within 14 days.

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 and follow the guidelines below. May be used over most generic types of coatings which are tightly adhering to the substrate including organic and inorganic zinc primers.
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SUBSTRATES & SURFACE PREPARATION

Steel	NACE No. 3/SSPC-SP 6 with a 50-75 microns (2.0-3.0 mil) surface profile for maximum protection. SSPC-SP 2, SSPC-SP 3, NACE No. 4/SSPC-SP 7, NACE/SSPC WJ-1 to WJ-4, or SSPC-SP 14 are also acceptable methods. For alternate methods contact Carboline Technical Service.
Galvanized Steel	For optimum performance clean and abrade in accordance with SSPC-SP 16.
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	Power mix separately, then combine and power mix. DO NOT MIX PARTIAL KITS.
Thinning	May be thinned up to 15% with Thinner 2. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether expressed or implied.
Ratio	1:1 Ratio (A to B) by volume
Pot Life	1.5 hours at 20°C (68°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.

General	The following spray equipment has been found suitable and is available from manufactures such as Binks, De Vilbis and Graco:
Airless Spray	Pump Ratio: 30:1 (min.) GPM Output: 3.0 (min.) 12 liters/min Material Hose: 3/8" I.D. (min.) Tip Size: 0.023-0.027" Output PSI: 2000-2400 Filter Size: 60 mesh PTFE packings are recommended and available from the pump manufacturer.
Brush & Roller (General)	Recommended for small areas and touch-up only
Brush	Use a medium bristle brush.
Roller	Use a medium nap solvent resistant cover.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	41°F (5°C)	36°F (2°C)	36°F (2°C)	0%
Maximum	95°F (35°C)	167°F (75°C)	104°F (40°C)	85%

Industry standards are for substrate temperatures to be 3°C (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
40°F (4°C)	18 Hours	7 Days
50°F (10°C)	10 Hours	5 Days
68°F (20°C)	6 Hours	3 Days
77°F (25°C)	4 Hours	2 Days

These times are based on 5 - 8 mils (127 - 203 microns) DFT. Higher film thickness, insufficient ventilation and/or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure

CLEANUP & SAFETY

Cleanup	Use Carboline Thinner 2 or 25. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
Safety	Read and follow all caution statements on this product data sheet and on the SDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
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. If not able to monitor levels, use MSHA/NIOSH approved respirator.
Caution	This product contains flammable solvents. Keep away from sparks and open flames. All electrical equipment and installations should be made and grounded in accordance with applicable regulations. In areas where explosion hazards exist, workmen should be required to use nonferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Packaging	Part A: 10 litres (2.6 gallons) Part B: 10 litres (2.6 gallons)
Shelf Life	Part A: 24 months at 24°C (75°F) Part B: 24 months at 24°C (75°F)
Storage Temperature & Humidity	5°C - 45°C (41°F - 113°F) 0-95% Relative Humidity

Carbomastic[®] 15 LT

PRODUCT DATA SHEET



PACKAGING, HANDLING & STORAGE

	Store Indoors.
Storage	This product is solvent based and not affected by excursions below these published storage temperatures, down to -17°C (10°F), for a duration of no more than 14 days. Always inspect the product prior to use to make sure it is smooth and homogeneous when properly mixed.

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 Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. 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.