

SELECTION & SPECIFICATION DATA

Generic Type	Two-components, high solids aluminium pigmented, low temperature curing modified epoxymastic.
Description	Carbomastic 15 LT is a high build coating with excellent adhesion to rusted steel and most aged coatings.
Features	<ul style="list-style-type: none"> • Surface tolerant • Recommended for painting over rusted steel where hand cleaning only is possible • Carbomastic 15 LT penetrates through rust to steel substrate and stops further corrosion and undercutting • Fast curing at low temperatures • High solids give good coverage and reduced solvent emission • Excellent maintenance primer for piping, bridges, tank exteriors, ships and offshore structures etc..
Color	Aluminium & Aluminium Red
Finish	Semi-Gloss
Wet Film Thickness	115 – 350 µm per coat, normally 175 µm.
Dry Film Thickness	100 - 300 microns (3.94 - 11.81 mils) per coat Normally 150 µm.
Solid(s) Content	By volume: 86 ± 2%
Theoretical Coverage Rates	5,7 m²/l at 150 µm. Allow for loss in mixing and application.
Dry Temp. Resistance	Continuous: 120°C (248°F) Non-Continuous: 150°C (302°F)
Limitations	Not recommended for immersion service in acids, alkalies or solvents.
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	May be used over most generic types of coatings which are tightly adhering to the substrate including organic- and inorganic zinc primers.
Steel	Preferably blasting however hand- or power tool cleaning is acceptable standard in many cases to remove non adhering paint and rust. Alternatively, ultra high pressure water jetting to Nace No. 7 min. C Vis WJ-2. Max flash rust; C Vis WJ-2M.

MIXING & THINNING

Mixing	Power mix separately, then combine and power mix.
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.

Carbomastic 15 LT

PRODUCT DATA SHEET



MIXING & THINNING

Ratio | 1:1 Ratio (A to B) by volume.

Pot Life | 1½ hours at 20°C 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 Vilbiss and Graco:

Airless Spray | Pump Ratio: 30:1 (minimum)
GPM Output: 3.0 (minimum) 12 liters/min.
Material Hose: 3/8" I.D. (minimum)
Tip Size: .023" - .027"
Output PSI: 2000 - 2400
Filter Size: 60 mesh

Teflon packings are recommended and available from the pump manufacturer.

Brush & Roller (General) | Recommended for small areas and touch-up only

APPLICATION CONDITIONS

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

Industry standards are for substrate temperatures to be 3°C above the dew point. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Recoat	Final Cure
5°C (41°F)	18 Hours	7 Days
10°C (50°F)	10 Hours	5 Days
20°C (68°F)	6 Hours	3 Days
25°C (77°F)	4 Hours	2 Days

These times are based on recommended DFT. Higher film thickness, insufficient ventilation 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 MSDS 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.

CLEANUP & SAFETY

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.
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 non-ferrous tools and wear conductive and non-sparking shoes.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 months at 24°C
Storage Temperature & Humidity	5° - 45°C 0 - 95% relative humidity
Storage	Store indoors.
Packaging	Part A: 10 litres Part B: 10 litres

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.