

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	A two-component epoxymastic coating
<b>Description</b>	Carbomastic 652 is a heavy duty, high build primer or intermediate coating for protection of steel in corrosive environments or water immersion. Low temperature curing and fast overcoatable.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Excellent anti-corrosive properties</li> <li>• Self-priming capability</li> <li>• Fast recoat time</li> <li>• Excellent leveling with good corrosion protection, also at low DFT</li> <li>• Very good abrasion resistance</li> <li>• NORSOK System 1 and 7B pre-qualified</li> <li>• Excellent for atmospheric and submerged corrosion protection</li> </ul>
<b>Color</b>	Off-white, Yellow (RAL 1004) and Grey (RAL 7038) A broad range of colors are available using Carboline RTS Tinting System
<b>Finish</b>	Semi-Gloss
<b>Primer</b>	Self-priming. Can be applied over most tightly adhering coatings. For heavy duty corrosion protection zinc rich primer is recommended as 1.st coat in a paint system.
<b>Wet Film Thickness</b>	150 - 625 µm per coat
<b>Dry Film Thickness</b>	120-500 µm per coat
<b>Solid(s) Content</b>	By volume: 80 ± 2%
<b>Theoretical Coverage Rates</b>	6.7 m <sup>2</sup> /l at 120 µm DFT 2,7 m <sup>2</sup> /l at 300 µm DFT Allow for loss in mixing and application.
<b>VOC Value(s)</b>	<b>As supplied:</b> 180 g/l These are nominal values and vary with color.
<b>Dry Temp. Resistance</b>	Continuous: 120°C (248°F) Non-Continuous: 150°C (302°F)
<b>Approvals</b>	Grain, Newcastle Occupational Health and Hygiene.
<b>Limitations</b>	Epoxies discolour and eventually chalk in sunlight exposure.

## SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Surface 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.
<b>Steel</b>	Surface preparation to be minimum St 3 (ISO 8501-1). Alternatively, ultra high pressure water jetting to Nace No. 7 min. C Vis WJ-2. Max flash rust; C Vis WJ-2M.
<b>Galvanized Steel</b>	Light sweep-blasting to achieve even roughness.

# Carbomastic 652

## PRODUCT DATA SHEET



### SUBSTRATES & SURFACE PREPARATION

**Aluminum** | Light sweep-blasting to achieve even roughness. Alternatively wash surface with alkaline detergent, e.g. Carboline Surface Cleaner No.3.

**Stainless Steel** | Light sweep-blasting to achieve even roughness.

### MIXING & THINNING

**Mixing** | Power mix separately, then add Part B to Part A and power mix. DO NOT MIX PARTIAL KITS.

**Thinning** | Typically not necessary, but depends on material temperature. May be thinned up to 10% with Carboline Thinner #2.

**Ratio** | 3 : 1 (A to B) by volume.

**Pot Life** | 1.5 hour at 20°C and longer at lower 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.

**Airless Spray** | Pump ratio: 45:1 (min.)\*  
GMP Output: 3.0 (min.)  
Material Hose: 3/8" I.D. (min.)  
Tip Size: 0.015-0.021"  
Output PSI: 2400  
Filter Size: 60 mesh

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

**Brush & Roller (General)** | For small areas and stripe coating only. Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding.

### APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	5°C (41°F)	-5°C (23°F)	-5°C (23°F)	10%
Maximum	35°C (95°F)	50°C (122°F)	40°C (104°F)	85%

Industry standards are for substrate temperatures to be 3°C above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate. Special application techniques may be required outside normal application conditions.

## CURING SCHEDULE

Surface Temp.	Dry to Touch	Dry to Handle	Dry to Recoat	Cure for Service
-5°C (23°F)	48 Hours	3 Days	48 Hours	30 Days
5°C (41°F)	8 Hours	16 Hours	8 Hours	21 Days
10°C (50°F)	6 Hours	12 Hours	6 Hours	14 Days
15°C (59°F)	4 Hours	8 Hours	4 Hours	7 Days
23°C (73°F)	3 Hours	6 Hours	3 Hours	5 Days
32°C (90°F)	2 Hours	4 Hours	2 Hours	3 Days

The above times are based on recommended DFT. Higher DFT, insufficient ventilation or lower ambient temperatures would cause longer curing times. \*Maximum recoating time up to 3 months depending on temperature and curing conditions. If exceeded, contact Carboline for further information about recoating procedures

## CLEANUP & SAFETY

<b>Cleanup</b>	Use Carboline Thinner #2. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	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.
<b>Ventilation</b>	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.
<b>Caution</b>	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

<b>Shelf Life</b>	24 months at 24°C
<b>Storage Temperature &amp; Humidity</b>	5° - 45°C 0 - 95% relative humidity
<b>Storage</b>	Store indoors
<b>Packaging</b>	Part A: 15 litres Part B: 5 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.