

Selection & Specification Data

Generic Type	High build modified aluminium epoxy mastic. Part A and Part B mixed prior to application.				
Description	Carbomastic 186 is a self-priming high build coating with excellent adhesion to rusted steel and most aged paints. Only a single coat required for most applications. Hand or power tool cleaning is acceptable surface preparation for most surfaces.				
Features	<ul style="list-style-type: none"> - Recommended for repainting rusty steel and upgrading old, deteriorated coatings - Ideal for metal buildings, piping, process equipment, highway bridges and exposed structural steel - Excellent flexibility - Excellent weathering - Fair abrasion resistance - May be used over most generic types of coating which are tightly adhering and properly prepared. A test patch is recommended for use over existing coatings. - A mist coat is recommended to minimize bubbling over inorganic zinc primers - Not recommended for immersion service in acids, alkalis or solvents 				
Colour	Aluminium only				
Finish	N/A				
Topcoat	Normally none required. Consult StonCor Africa Sales or Technical Service for specific recommendations.				
Dry Film Thickness	125 Microns minimum				
Solids Content	By Volume 90% ± 2%				
Theoretical Coverage Rate	7.2m ² /litre at 125 microns				
Dry Temp Resistance	<p>NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.</p> <p>Non-immersion</p> <table border="0"> <tr> <td>Continuous</td> <td>82°C</td> </tr> <tr> <td>Non-continuous</td> <td>121°C</td> </tr> </table>	Continuous	82°C	Non-continuous	121°C
Continuous	82°C				
Non-continuous	121°C				

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated prior to abrasive blast, power or hand cleaning.
Steel	<p>Non-immersion service:</p> <p>Clean per power or hand tool in accordance with ISO 8501 St3 or St2 respectively, to produce a rust scale free surface. Alternatively, for more severe environments, dry abrasive blast per ISO 8501 Sa1 (brush off blast). Water blasting followed by hand or power tool cleaning as required is an acceptable means of preparing the surface to a cleanliness defined by ISO 8501 St2.</p>

Performance Data

Test Method	System	Results
ASTM B117 Salt Spray	1 Coat Carbomastic 186	2000 Hours, no blistering. Rusting or softening. No rust creep from scribe

Application Equipment

Spray Use sufficient air volume for correct operation of the equipment.

Use a 50% overlap with each pass of the gun. On irregular surfaces, coat the edges first, making an extra pass later.

The following equipment has been found suitable, however equivalent equipment may be substituted:

Conventional Use a 12mm minimum I.D. material hose. Hold gun approximately 300 to 350mm from the surface and at right angles to the surface.

Mfr & Gun	Fluid Tip	Air Cap
Binks # 18 or # 62	67	67PB
DeVilbiss MBC or JGA	D	64

Airless Use 10mm minimum I.D. material hose. Hold gun approximately 450 to 500mm from the surface and at right angles to the surface.

Mfr & Gun	Pump *
DeVilbiss JGB or JGN	QFA-514 or QFA-519 32:1
Graco 208-663	President 30:1 or Bulldog 30:1
Binks Model 700	B5-18 29:1 or B8-36 37:1

* Teflon packings are recommended and are available from pump manufacturers. Use a .021" to .025" tip with 2400 psi (166 bar)

Brush or Roller Use clean natural bristle brush or medium nap roller. Work coating into all irregularities. Brush or roller application may result in a non-uniform bronze colour.

Mixing & Thinning

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

	2 Litre	10 Litre
Part A	1 litre	5 litre
Part B	1 litre	5 litre

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

NOTE: Use of thinners other than those supplied or approved by StonCor Africa may adversely affect the performance and void product warranty, whether express or implied.

Pot Life 4 Hours at 25°C when thinned 25%, 2 hours at 25°C unthinned and 1 hour at 32°C unthinned. Pot life ends when coating becomes too viscous to use.

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	18-29°C	18-29°C	18-29°C	35-80%
Minimum	10°C	10°C	10°C	0%
Maximum	32°C	54°C	38°C	95%

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

Special thinning and application techniques may be required above or below normal conditions.

Curing Schedule

Surface Temp. & 50% Relative Humidity	Between Coats	Final Cure
10°C	24 Hours	10 Days
16°C	12 Hours	7 Days
25°C	4 Hours	3 Days
32°C	3 Hours	2 Days

Cleanup & Safety

Cleanup Use Thinner # 2

Safety Read and follow all caution statements on this product data sheet and on the material safety data sheet 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 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, appropriate respirators must be used by all application personnel.

Packaging, Handling & Storage

Shipping Weight (Approximate)	Carbomastic 186	2 Litre	10 Litre
	Thinner # 2	3kg	14.3kg
		4.8kg	

Flash Point (Pensky Martens Closed Cup)	Part A	25°C
	Part B	28°C
	Thinner # 2	22°C

Storage Temperature & Humidity 7 to 43°C
0 to 100%
Store indoors

Shelf Life 36 Months minimum when stored at 25°C

***Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.**



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