

Selection & Specification Data

Generic Type:	Two component, high build epoxy mastic.
Description	CARBOMASTIC 801 is a self priming, high build, semi-gloss epoxy mastic available in a wide variety of colors. Can be applied by spray, brush or roller over hand or power tool cleaned steel and is compatible with most existing coatings and tightly adhered rust. The cured film is tough and abrasion resistant and provides an easily cleanable aesthetic surface
Features	<ul style="list-style-type: none"> • Single coat corrosion protection. • Good weathering resistance. • Good flexibility and lower stress upon curing than most epoxy coatings. • Excellent tolerance of damp (not wet) substrate. • Can be spray applied up to 8 mils dry in One coat. • Has a higher flash point than most epoxy Coatings (over 106°F, including recommended Carboline Thinner). • Meets the most stringent VOC (Volatile Organic Content) regulations.
Color	Available in Carboline Color Chart Colors. Metallic aluminum colors are available upon special request. Some color may require two coats for adequate hiding. Consult your local Carboline Customer Service for availability.
Primers	Self priming
Topcoats	May be topcoated to upgrade weathering resistance
Dry Film Thickness	4-6 mils (100-150 microns) for use in mild environment. 6-8 mils (150-200 microns) for use over light tight rust. In more severe environments a second coat of 4-6 mils (100-150 microns) is recommended
Solids Content	By Volume : 76%±2%
Theoretical Coverage Rate	1219 mils sq. ft. (30.4 sq. m/l at 25 microns) 244 sq. ft. at 5 mils (6.0 sq. m/l at 125 microns)
VOC Values	As supplied: 1.74 lbs/gal (208 grams/liter)
Dry Temp. Resistance	Continuous: 250°F (121°C) Non-Continuous: 300°F (149°C)
Limitations:	Epoxies loss gloss and eventually chalk in sunlight exposure. Not recommended for : Immersion service, splash and spillage of very strong solvents or concentrated acids.

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated with clean rags soaked in Thinner # 2 or use SURFACE CLEANER # 3 (Refer to Surface Cleaner#3 instructions in accordance with SSPC-SP 1.
Steel	For mild environments Hand Tool or Power Tool Clean in accordance with SSPC-SP2, SSPC-SP11 or SSPC-SP3 to produce a rust-scale free surface.
Concrete	Concrete must be cured 28 days at 75°F(24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with ASTM D4258 Surface Cleaning of Concrete and ASTM D4259 Abrading Concrete. Voids in concrete may require surfacing.
Previously Painted Surfaces	Lightly sand or abraded to roughen and degloss the surface. Existing paint must attain a minimum 3B rating in accordance with ASTM D3359 "X Scribe" adhesion test.

Application Equipment

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 Guidelines:**

Spray Application (General)	This is a high solids coating and may require adjustments in spray techniques. Wet film thickness are easily and quickly achieved. The following spray equipment has been found suitable and available from manufacturers such as Binks, DeVilbiss and Graco..												
Conventional Spray	Pressure pot equipped with dual regulators, 3/8" I.D. minimum material hose, .086" I.D. fluid tip and appropriate air cap.												
Airless Spray	<table> <tr> <td>Pump Ratio :</td> <td>30 : 1 (min)</td> </tr> <tr> <td>GPM Output:</td> <td>3.0 (min)</td> </tr> <tr> <td>Material hose:</td> <td>3/8" I.D. (min)</td> </tr> <tr> <td>Tip Size:</td> <td>.017"-.021"</td> </tr> <tr> <td>Output psi:</td> <td>1900-2100</td> </tr> <tr> <td>Filter Size:</td> <td>60 mesh</td> </tr> </table>	Pump Ratio :	30 : 1 (min)	GPM Output:	3.0 (min)	Material hose:	3/8" I.D. (min)	Tip Size:	.017"-.021"	Output psi:	1900-2100	Filter Size:	60 mesh
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Brush & Roller (General)	Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling.												
Brush	Use a medium bristle brush.												
Roller	Use a medium-nap synthetic roller cover with phenolic core												

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Carbomastic® 801

Mixing & Thinning

- Mixing** Mix separately, then combine and mix in the following proportion. DO NOT MIX PARTIAL KITS
- Ratio** 1 : 1 Ratio (A to B) by volume
- Thinning** For spray applications may be thinned up to 12% (16 fl.oz/gal.) by volume with thinner #4
For brush and roller application, may be thinned up to 50% (32 fl.oz/gal) by volume with thinner#4
- Pot Life** Four hours at 75°F (24°C) and less at higher temperatures. Pot life ends when coating loses body and begins to sag. Thinning rates above 12% will shorten the working time to two hours due to reduce film build.

Cleanup & Safety

- Cleanup** Use CARBOLINE Thinner # 2
- Safety** Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation and wear gloves or use protective cream on face and hands if hypersensitive. Keep container closed when not in use.
- Ventilation** When used in enclosed area, 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 solvent used. User should test and monitor exposure levels to insure all personnel are below guidelines. If not sure or 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 the National Electric Code. In areas where explosion hazards exist, workmen should be required to use non-ferrous tools and wear conductive and non sparking shoes

Application Conditions

Condition	Material	Surface	Ambient	Humidity
Normal	60-85°F (16-29°C)	60-85°F (16-29°C)	60-85°F (16-29°C)	0-90%
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	90°F (32°C)	135°F (57°C)	110°F (43°C)	90%

Curing Schedule

Surface Temp. & 50% Relative Humidity	Dry to Recoat	Dry to Topcoat w/ Other Finishes	Final Cure
50°F (10°C)	36 hours	36 hours	3 days
60°F (16°C)	24 hours	24 hours	2 days
75°F (24°C)	12 hours	12 hours	24 hours
90°F (32°C)	6 hours	6 hours	12 hours

Packaging, Handling & Storage

Shipping Weight (Approximate) 10 Liters set 40 Gallons
 (15.8 kg) (63.4 kg)

Flash Point (Setaflash) CARBOMASTIC 801 111°F
 Part A (44°C)
 CARBOMASTIC 801 111°F
 Part B (44°C)

Storage Temperature & Humidity Store indoors.
 Temperature: 40-95°F (4-35°C)
 Humidity: 0-90%

Shelf Life Store in doors
 12 months at 32°C

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



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