### Selection & Specification Data

<table>
<thead>
<tr>
<th>Generic Type</th>
<th>Coal-tar epoxy polyamide</th>
</tr>
</thead>
<tbody>
<tr>
<td>Description</td>
<td>Renowned high build coal tar epoxy polyamide for protection of steel and concrete in single or two-coat applications in a broad variety of aggressive industrial applications.</td>
</tr>
</tbody>
</table>
| Features              | • Excellent chemical, corrosion and abrasion resistance  
                         • High-build, 16-24 mils (400-610 microns) in a single coat (up to 35 mils with force curing)  
                         • Compatible with controlled cathodic protection  
                         • Suitable for use in exposures as referenced in the following specifications:  
                           Corp of Engineers C-200, C200a  
                           AWWA C-210 for exterior  
                           SSPC-Paint 16  
                           Steel Tank Institute Corrosion Control System STI-P3  
                         • Self-priming, or use suitable prime as recommended by Carboline. |
| Dry Film Thickness     | 16.0 mils (406 microns) in one or two coats |
| Total dry film thickness less than 8 mils (200microns) or in excess of 35 mils (875 microns) is not recommended. Wet-on-wet spray techniques should be used for high thicknesses allowing time for solvents to flash between passes. |
| Solids Content         | By Volume 74% +/- 2% |
| Theoretical Coverage Rate | 1187 ft² at 1.0 mils (29.1 m²/l at 25 microns)  
                              74 ft² at 16.0 mils (1.8 m²/l at 400 microns) |
| Allow for loss in mixing and application. |
| VOC Values             | Thinner 10  10 oz/gal: 2.2 lbs/gal 269 g/l  
                              As Supplied  1.85 lbs/gal 222 g/l |
| These are nominal values.  
                             Thinner 10: 25 oz/gal: 2.7 lbs/gal 327 g/l  
                             *Maximum thinning for 250 g/l restricted areas is 6 oz/gal. |
| Dry Temp. Resistance   | Continuous: 350 °F (177 °C)  
                              Non-Continuous: 370 °F (188 °C) |
| Limitations            | Do not use for potable water requirements. |
| Topcoats               | Not recommended |
| Wet Temp. Resistance   | Immersion temperature should not exceed 120°F (49°C) |

### 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.

#### Steel
- **Immersion:** SSPC-SP10  
  - **Non-Immersion:** SSPC-SP6  
  - SSPC-SP2 or SP3 as minimum requirement.  
- **Surface Profile:** 2.0-3.0 mils (50-75 micron)

### Performance Data

<table>
<thead>
<tr>
<th>Test Method</th>
<th>System</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>ASTM B117 Salt Fog</td>
<td>Blasted Steel 2 cts. 300M</td>
<td>No blistering, rusting or delamination. No measurable undercutting at scribe after 2000 hours</td>
</tr>
</tbody>
</table>
| ASTM D2794 Impact    | Blasted Steel 2 cts. 300M | Impact site diameter, inches: 3/8,3/8, 1/2  
                              100 in/lbs Gardner Impactor at 1/2 in. diam. |
| ASTM D4060 Abrasion  | Blasted Steel 2 cts. 300M | 130 mg. loss after 1000 cycles, CS17 wheel, 1000 gm load |
| ASTM D4541 Adhesion  | Blasted Steel 2 cts. 300M | 1443 psi (Pneumatic) |

Test reports and additional data available upon written request. *Disclaimer: Bitumastic 300M is a proprietary formula that is not necessarily formulated to the exact compositional guidelines set forth in some of these standards. Minor deviations that control and improve application characteristics may be present, but does not have a detrimental effect on the suitability for use outlined therein.

### Mixing & Thinning

#### Mixing
Power mix separately, then combine and power mix for a minimum of two minutes. DO NOT MIX PARTIAL KITS.

#### Thinning
- Up to 10 oz/gal (8%) w/ #10  
- Up to 25 oz/gal (20%) w/ #10 for the first coat application to concrete.

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
4:1 Ratio (A to B)

#### Pot Life
75°F (24°C) 2 Hours  
90°F (32°C) 1 Hour

Pot life ends when coating loses body and begins to sag.

### 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.

#### Spray Application (General)
This is a high solids coating and may require adjustments in spray techniques. Wet film thickness is easily and quickly achieved. The following spray equipment has been found suitable and is available from manufacturers such as Binks, DeVilbiss and Graco.

#### Conventional
Pressure pot equipped with dual regulators, 3/8” I.D. minimum material hose, with 50’ maximum material hose .086” I.D. fluid tip and appropriate air cap.
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: 30:1*
- GPM Output: 3.0 (min.)
- Material Hose: ½” I.D. (min.)
- Tip Size: .023-.035”
- Output PSI: 2100-2500
- Filter Size: 30 mesh

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

Brush & Roller
(General)
- Recommended for touch up, striping of weld seams and hard-to-coat areas only. Avoid excessive re-brushing or re-rolling.

Brush
- Use a medium bristle brush.

Roller
- Use a short-nap synthetic roller cover with phenolic core.

Application Conditions

<table>
<thead>
<tr>
<th>Condition</th>
<th>Material</th>
<th>Surface</th>
<th>Ambient</th>
<th>Humidity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Minimum</td>
<td>50 °F (10 °C)</td>
<td>50 °F (10 °C)</td>
<td>50 °F (10 °C)</td>
<td>0%</td>
</tr>
<tr>
<td>Maximum</td>
<td>90 °F (32 °C)</td>
<td>125 °F (52 °C)</td>
<td>110 °F (43 °C)</td>
<td>90%</td>
</tr>
</tbody>
</table>

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 above or below normal application conditions.

Curing Schedule

<table>
<thead>
<tr>
<th>Surface Temp.</th>
<th>Dry to Touch</th>
<th>Final Cure Immersion</th>
<th>Maximum Recoat Time</th>
<th>Minimum Recoat Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>50 °F (10 °C)</td>
<td>8 Hours</td>
<td>14 Days</td>
<td>24 Hours</td>
<td>10 Hours</td>
</tr>
<tr>
<td>75 °F (24 °C)</td>
<td>4 Hours</td>
<td>7 Days</td>
<td>24 Hours</td>
<td>6 Hours</td>
</tr>
<tr>
<td>90 °F (32 °C)</td>
<td>2 Hours</td>
<td>5 Days</td>
<td>24 Hours</td>
<td>3 Hours</td>
</tr>
</tbody>
</table>

These times are based on a 16.0 mil (400 micron) dry film thickness. Higher film thickness, insufficient ventilation, high humidity or cooler temperatures will require longer cure times. Excessive humidity or condensation on the surface during curing can interfere with the cure, can cause discoloration and may result in a surface haze. Any haze or blush must be removed by water washing before recoating. If the maximum recoat time is exceeded, the surface must be abraded by sweep blasting prior to the application of additional coats. Holiday Detection (if required): Wet sponge types may be used if the dry film thickness is below 20 mils (500 microns). High voltage spark testing should be used when the dry film thickness exceeds 20 mils (500 microns). Refer to the latest version of NACE SP0188 for specific procedures.

FORCE CURING recommended for thicknesses above 24 mils
Hold substrate at 150 F for 8 hours and material will be ready to handle for immersion service.

Cleanup & Safety

Cleanup
- Use #2 Thinner or Acetone. 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.

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, workers should be required to use non-ferrous tools and wear conductive and non-sparking shoes.

Packaging, Handling & Storage

Shelf Life
- Part A: Min. 24 months at 75°F (24°C)
- Part B: Min. 36 months at 75°F (24°C)

Shipping Weight
- 1.25 Gallon Kit - 12 lbs (6 kg)
- 5 Gallon Kit - 50 lbs (26 kg)

Storage
- 40°F -110°F (4°-43°C)

Flash Point
- Part A: 75°F (24°C)
- Part B: >200°F (93°C)

Storage
- Store indoors

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Cleveland 1-800-362-9267
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