

SELECTION DATA

GENERIC TYPE : Single package, chlorinated plasticizer modified acrylic.

GENERAL PROPERTIES : Carboline 4688 Finish is a fast drying, single package finish coat that exhibits excellent color retention. It has excellent weathering properties and very good abrasion resistance.

RECOMMENDED USES : Carboline 4688 Finish is an excellent topcoat for use in all industries including chemical processing, pulp and paper, petroleum, railroads, marine, etc. It is generally used for the protection of structural steel, equipment exteriors, marine containers and concrete when applied over properly primed surface.

NOT RECOMMENDED FOR : Immersion service or solvent exposure.

CHEMICAL RESISTANCE :

<u>Exposure</u>	<u>Fumes</u>
Acids	Good
Alkalies	Good
Solvents	Fair
Salt	Excellent
water	Excellent

TEMPERATURE RESISTANCE : (Non-immersion)

Continuous : 150°F(65°C)
Non-continuous : 200°F(93°C)

FLEXIBILITY : Very Good

WEATHERING : Excellent

ABRASION RESISTANCE : Very Good

SUBSTRATES : Properly primed surfaces

TOPCOAT REQUIRED : None.

COMPATIBILITY WITH OTHER COATINGS : Apply over properly prepared chlorinated rubbers or others as recommended. Consult Carboline for specific recommendations.

SPECIFICATION DATA

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL :

	<u>By Volume</u>
Carboline 4688 Finish	35% ± 2%

RECOMMENDED DRY FILM THICKNESS PER COAT :
2 mils (50μ)

THEORETICAL COVERAGE PER MIXED GALLON : *

561 mil sq. ft. (14 m²/ℓ at 25μ)
187 sq. ft. at 3 mils (4.7m²/ℓ at 75μ)

*** NOTE :** Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.

SHELF LIFE : 12 months when stored at 75°F(24°C)

COLORS : Consult Carboline Color Chart.

GLOSS : Gloss

ORDERING INFORMATION

Prices may be obtained from Carboline Sales Representative or Main Office. Terms – Net 30 days.

SHIPPING WEIGHT :

	<u>1's</u>	<u>5's</u>
Carboline 4688 Finish	10 lbs.(5.5 kg)	50 lbs.(22.7 kg)
Carboline Thinner #10	9 lbs.(4.1 kg)	45 lbs.(20.4 kg)

FLASH POINT : (Pensky-Martens Closed Cup)

Carboline 4688 Finish	70°F(21°C)
Carboline Thinner #10	77°F(25°C)
Carboline Thinner #10S	109°F(43°C)

APPLICATION INSTRUCTIONS

SURFACE PREPARATIONS : Remove any oil or grease from surface to be coated with clean rags soaked in Carboline Thinner #2, in accordance with SSPC-SP-1.

Apply over clean, dry, recommended coatings.

MIXING : Mix to a uniform consistency before thinning. May be thinned up to 25% by volume with Carboline Thinner #10 for normal temperature. For extremely warm and windy conditions, may be thinned up to 25% by volume with Carboline Thinner #10S.

APPLICATION TEMPERATURES :

	<u>Material</u>	<u>Surfaces</u>
Normal	60–90°F(16–32°C)	65–85°F(18–29°C)
Minimum	40°F(4°C)	35°F(2°C)
Maximum	100°F(38°C)	150°F(66°C)
	<u>Ambient</u>	<u>Humidity</u>
Normal	55–100°F(13–38°C)	10–85%
Minimum	40°F(4°C)	0%
Maximum	120°F(49°C)	95%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point.

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

SPRAY : Use adequate air volume for correct operation.

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

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

Conventional : Use a 3/8 " minimum I.D. material hose. Hold gun 8–10 inches from the surface and at a right angle to the surface.

<u>Mft. & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	63	63PB
DeVilbiss P-MBC or JGA	E	704
	Approx..070" I.D.	

Airless : Use a 3/8" minimum I.D. material hose. Hold gun 12–14 inches from the surface and at a right angle to the surface.

<u>Mft. & Gun</u>	<u>Pump*</u>
DeVilbiss JGB-507	QFA-519 32 : 1
Graco 205-591	Bulldog 30 : 1
Binks Model 700	B8-36 37 : 1

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

Use a .017~.021" tip with 2200 psi.

BRUSH OR ROLLER : Use natural bristle brush applying with full strokes. Avoid rebrushing. If rolled, use short nap, mohair roller with phenolic core. Avoid rerolling.

DRYING TIMES :

<u>Temperature</u>	<u>Recoat or to Handle</u>
40°F(4°C)	12 Hours
50°F(10°C)	10 Hours
60°F(16°C)	5 Hours
75°F(24°C)	3 Hours
90°F(32°C)	1 Hour

This coating is also excellent in force curing situations, such as fabrication shops.

CLEAN UP : Use Carboline Thinner #2.

STORAGE CONDITIONS :

Temperature : 40°F–110°F(4–43°C)
Humidity : 0–100%

CAUTION: CONTAINS FLAMMABLE SOLVENTS. KEEP AWAY FROM SPARKS AND OPEN FLAMES. IN CONFINED AREAS WORKMEN MUST WEAR FRESH AIRLINE RESPIRATORS. HYPERSENSITIVE PERSONS SHOULD WEAR GLOVES OR USE PROTECTIVE CREAM. ALL ELECTRIC EQUIPMENT AND INSTALLATIONS SHOULD BE MADE AND GROUNDED IN ACCORDANCE WITH THE NATIONAL ELECTRICAL CODE. IN AREAS WHERE EXPLOSION HAZARDS EXIST. WORKMEN SHOULD BE REQUIRED TO USE NONFERROUS TOOLS AND TO WEAR CONDUCTIVE AND NONSPARKING SHOES.

