

**SELECTION DATA**

**GENERIC TYPE :** Single package, modified chlorinated rubber.

**GENERAL PROPERTIES :** Carboline 3630 Finish is a fast drying, single package finish coat that exhibits high gloss and good color retention. It is frequently used as a topcoat over corrosion resistant chlorinated rubber systems. It has excellent weathering properties and very good abrasion resistance.

**RECOMMENDED USES :** Carboline 3630 Finish is an excellent maintenance coating 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 and concrete when applied over properly primed surfaces. It is very effective in exposure of high humidity, such as pulp mills.

**NOT RECOMMENDED FOR :** Immersion service or solvent exposures.

**CHEMICAL RESISTANCE :** (with recommended topcoat) :

<u>Exposure</u>	<u>Fumes</u>
Acids	Very Good
Alkalies	Good
Solvents	Fair
Salt(Brines)	Excellent
Water	Excellent

**TEMPERATURE RESISTANCE :** (Non-immersion)

Continuous : 150°F(66°C)  
Non-continuous : 200°F(93°C)

**FLEXIBILITY :** 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. A mist coat or tie-coat of Rustbond 8 HB or is required over inorganic zincs.

**SPECIFICATION DATA**

**THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL :**

By Volume

Carboline 3630 Finish 33% ± 2%

**RECOMMENDED DRY FILM THICKNESS PER COAT :**

2 mils (50µ)

**THEORETICAL COVERAGE PER MIXED GALLON\* :**

529 mil sq. ft. (13.2 sq. m/ℓ at 25µ)

265 sq. ft. at 2 mils (6.6 sq. m/ℓ at 50µ)

**\*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 :** High

**ORDERING INFORMATION**

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

**APPROXIMATE SHIPPING WEIGHT :**

	<u>1's</u>	<u>5's</u>
Carboline 3630 Finish	10 lbs.(4.5 kg)	50 lbs.(4.5 kg)
Carboline Thinner #10	9 lbs.(4.1 kg)	45 lbs.(20 kg)

**FLASH POINT :** (Pensky-Martens Closed Cup)

Carboline 3630 Finish	70°F(21°C)
Carboline Thinner #10	77°F(25°C)

**APPLICATION INSTRUCTIONS**

**SURFACE PREPARATIONS :** Remove any oil or grease from surface to be coated with clean rags soaked in Carboline Thinner #2.

Apply over clean, dry, recommended coatings.

**MIXING :** Mix to a uniform consistency before thinning. Thin up to 25% by volume with Carboline Thinner #10.

**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 conditions.

**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 approximately 8–10 inches from the surface and at a right angle to the surface.

<u>Mfr. &amp; 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 3/8" minimum I.D. material hose. Hold gun approximately 12–14 inches from the surface and at a right angle to the surface.

<u>Mfr. &amp; Gun</u>	<u>Pump*</u>
DeVilbiss JGN–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 .017–0.21 " tip with 2200 psi.

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

**DRYING TIMES :**

<u>Temperature</u>	<u>Final Cure</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

**CLEAN UP :** Use Carboline Thinner #2.

**STORAGE CONDITIONS :**

Temperature : 40°F–110°F(4–49°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.

