

SELECTION DATA

GENERIC TYPE : Single package chlorinated rubber.

GENERAL PROPERTIES : Since Carboline 3630 Primer and High Build contains no oil or alkyd modifiers, the excellent inherent chemical resistance properties of chlorinated rubber are retained. Particularly recommended for splash, spillage and fumes of caustics, acids, salts and water. Performs well over non-blasted surfaces. Frequently used as a topcoat over inorganic zinc base coats, such as Carbozinc 11. Abrasion resistance and weathering properties are very good.

RECOMMENDED USES : An excellent maintenance system for use in all industries including chemical processing, pulp and paper, petroleum, railroads, marine, etc. Generally used for the protection of structural steel, equipment exteriors and concrete. Although sandblasting is recommended, the Carboline 3630 system performs very well and is commonly used over power tool or hand cleaned surfaces. Very effective in exposure of high humidity, such as pulp mills. Plant successfully using chlorinated rubbers can upgrade their protection with the Carboline 3630 system.

NOT RECOMMENDED FOR : Immersion service or solvent exposures.

CHEMICAL RESISTANCE : (with recommended topcoat) :

<u>Exposure</u>	<u>Fumes</u>
Acids	Excellent
Alkalies	Excellent
Solvents	Poor
Salt(Brines)	Excellent
Water	Excellent

FLEXIBILITY : Good

WEATHERING : Very Good

ABRASION RESISTANCE : Very Good

SUBSTRATES : Steel

TOPCOAT REQUIRED : Carboline 3630 Primer is normally topcoated with Carboline 3630 HB with an optional third coat of Carboline 3630 Finish for a glossy appearance. May be topcoated with acrylics, silicones, alkyds, or others as recommended.

COMPATIBILITY WITH OTHER COATINGS : May be applied over certain synthetics such acrylics, some alkyds or well aged oils, and inorganic zincs, such as Carbozinc. Consult Carboline Technical Service for specific recommendations.

SPECIFICATION DATA

THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL :

	<u>By Volume</u>
Carboline 3630 Primer	32% ± 2%
Carboline 3630 HB	38% ± 2%

RECOMMENDED DRY FILM THICKNESS PER COAT :

Carboline 3630 Primer	2 mils (50µ)
Carboline 3630 HB	3-4 mils (75-100µ)

THEORETICAL COVERAGE PER MIXED GALLON* :

Carboline 3630 Primer

513 mil sq. ft. (12.8 sq. m/l @ 25µ)
257 sq. ft. at 2 mils (6.4 sq. m/l @ 50µ)

Carboline 3630 HB

610 mil sq. ft. (15.2 sq. m/l @ 25µ)
203 sq. ft. at 3 mils (5.2 sq. m/l @ 75µ)
153 sq. ft. at 4 mils (3.8 sq. m/l @ 100µ)

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

SHELF LIFE : 12 months minimum

COLORS :

Carboline 3630 Primer : Red only.
Carboline 3630 HB : Consult Carboline Color Chart.

GLOSS : Flat

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 3630 Primer	11 lbs.(5.0 kg)	55 lbs.(25.0 kg)
Carboline 3630 HB	11 lbs.(5.0 kg)	45 lbs.(25.0 kg)
Carboline Thinner #10	9 lbs.(4.1 kg)	45 lbs.(20.4 kg)

FLASH POINT : (Pensky-Martens Closed Cup)

Carboline 3630 Primer	56°F(13°C)
Carboline 3630 HB	80°F(27°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 or toluol.

STEEL : For best performance, dry abrasive blast to a Commercial Finish in accordance with SSPC-SP6 to a degree of cleanliness in accordance with NACE #3 to obtain a 1-2 mil (25-50µ) blast profile. Power Tool Cleaning per SSPC-SP3, or Hand Cleaning per SSPC-SP2 is acceptable.

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 angles to the surface.

<u>Mfr. & Gun</u>	<u>Fluid Tip</u>	<u>Air Cap</u>
Binks #18 or #62	66	66PB
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. & Gun</u>	<u>Pump*</u>
DeVilbiss JGB-507	QFA-519 32 :1
Graco 205-591	Bulldog 30 :1
Binks Model 500	Jupiter 8D 35 :1

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

BRUSH OR ROLLER : For small areas or touch-up only. Use a natural bristle brush applying with full strokes. Avoid rebrushing. If rolled, use a short nap mohair roller with phenolic core. Avoid rerolling.

DRYING TIMES :

Carboline 3630 Primer	<u>Temperature</u>	<u>Final Cure</u>
	40°F (4°C)	12 Hours
	60°F (16°C)	5 Hours
	75°F (24°C)	3 Hours
Carboline 3630 HB	90°F (32°C)	1 Hour
	<u>Temperature</u>	<u>Final Cure</u>
	40°F (4°C)	12 Hours
	60°F (16°C)	5 Hours
	75°F (24°C)	3 Hours
	90°F (32°C)	1 Hour

STORAGE CONDITIONS :

Temperature : 40°F-110°F (4-49°C)
Humidity : 0-100%

CLEAN UP : Use Carboline Thinner #2 or toluol.

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.

