

Selection & Specification Data

Generic Type	Single package, modified Acrylic				
Description	Carbocryl 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 acrylic systems. It has excellent weathering properties and very good abrasion resistance				
Color	Normally stocked colors are White 0800, Gray C703, Red 0516 and Black C900. Other colors are available on special order.				
Gloss	Semi flat				
Primer	Can be used over Carbocryl 3631 HB; Epoxy primer and Carbozinc A tie coat of Carbocryl 3630 Finish is required over inorganic zincs.				
Dry Film Thickness	3 mils (75 microns).				
Solids Content	<p>THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL:</p> <table border="0"> <tr> <td></td> <td style="text-align: center;"><u>By Volume</u></td> </tr> <tr> <td>Carboline 3630</td> <td style="text-align: center;">33% ± 2%</td> </tr> </table>		<u>By Volume</u>	Carboline 3630	33% ± 2%
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Carboline 3630	33% ± 2%				
Theoretical Coverage Rate	<p>PER GALLON*: 529 mi/ sq. ft. {13.2 m²/l @ 25 microns)</p> <p>*NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.</p>				
Dry Temp. Resistance	<p>(non-immersion) Continuous: 150°F(65°C) Non-continuous: 176°F (80°C)</p>				
Limitations	<p>Note: Application over Carbo Zinc primers may require a mist coat. NOT RECOMMENDED FOR: Tank lining service or solvent exposure. Being a thermoplastic product , prolonged direct contact at temperatures approximately 104°F (40°) may cause film indentation. When temperatures drop below , mechanical strength is recover</p>				

Substrates & Surface Preparation

General	Remove any oil or grease from surface to be coated with clean rags soaked in Carboline thinner #2 or Toluol.
Steel	Apply over clean dry recommended coatings.

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Carbocryl®3630

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) 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 Spray Use a 3/8" minimum I.D. material line. Hold gun 8-10 inches from the surface and at right angle to the surface.

Airless Spray Use 3/8" I.D. minimum material line
Mfr. & Gun DeVilbiss JGA-5026
Graco 205-162
Binks 500
Pump* QFA-514
President 30:1
Bulldog 30:1
Mercury 5C

*Teflon packing are recommended and available from manufacturer. Use a 017" - 0.21" tip with 2200 psi.

Brush & Roller (General) Spray application preferred. May be brushed or rolled using natural bristle brush or short nap roller.

Mixing & Thinning

Mixing Mix to smooth consistency before thinning.

Thinning Thin up to 25% by volume with Carboiine Thinner #10.

Cleanup & Safety

Cleanup Use Thinner #2 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. 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 areas, 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 solvents 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. In confined areas, workmen must wear appropriate respirator protection. 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	60-90°F (16-32°C)	65-85°F (18-29°C)	55-100°F (13-38°C)	10-85%
Minimum	40°F (4°C)	35°F (2°C)	40°F (4°C)	0%
Maximum	100°F (38°C)	150°F (66°C)	120°F (49°C)	95%

Curing Schedule

Temperature	Dry to touch
75°F (24°C)	3 - 4 hours

In case of multi-coat application, drying time and minimum recoat interval will be influence by the number of coats and by the thickness of each coat

Packaging, Handling & Storage

Shipping Weight (Approximate)	Carbocryl 3630 Finish	5 Ltrs (5.5 kg)	20 Ltrs. (22 kg)
	Thinner #10	5 (4.25 kg)	20 Ltrs. (17 kg)

Flash Point (Setaflash) (Pensky-Martens Closed Cup)
Carbocryl 3630 Finish 77°F (25 °C)
Carboline Thinner #10 77°F (25°C)

Storage Temperature & Humidity Temperature: 40-110°F(4-43°C)
Humidity: 0-100%

Shelf Life 12 months minimum at 32°C

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



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