

## Selection & Specification Data

<b>Generic Type</b>	Single package, modified Acrylic				
<b>Description</b>	Carbocryl 3631 HB is modified Acrylic with a wide range of compatibility with other coatings. Can be used as an exterior coating for structural steel, tank exteriors and miscellaneous equipment, particularly where a semi-gloss finish is desired for appearance.				
<b>Features</b>	<ul style="list-style-type: none"> <li>*An easily applied</li> <li>*Fast drying,</li> <li>*High build,</li> <li>*Semi-gloss</li> <li>*Can be applied at 3 mils (75 microns) dry film thickness in one coat</li> <li>*Good flexibility</li> <li>*Excellent weathering resistance</li> <li>*Good abrasion resistance</li> </ul>				
<b>Color</b>	Normally stocked colors are White 0800, Gray C703, Red 0516 and Black C900. Other colors are available on special order.				
<b>Gloss</b>	Semi-gloss				
<b>Primer</b>	Can be used over chlorinated rubber primers or Carbo Zinc® primers as recommended.				
<b>Topcoats</b>	Normally none. May be topcoated with itself, Carboline 3630 Finish or Polyclad® Anti-foulings as recommended.				
<b>Dry Film Thickness</b>	3 mils (75 microns).				
<b>Solids Content</b>	<p>THEORETICAL SOLIDS CONTENT OF MIXED MATERIAL:</p> <table border="0" style="margin-left: 20px;"> <tr> <td></td> <td style="text-align: center;"><u>By Volume</u></td> </tr> <tr> <td>Carboline 3631 HB</td> <td style="text-align: center;">34% ± 2%</td> </tr> </table>		<u>By Volume</u>	Carboline 3631 HB	34% ± 2%
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<b>Theoretical Coverage Rate</b>	<p>PER GALLON*:</p> <p>545 mi<sup>2</sup>/sq. ft. {13.6 m<sup>2</sup>/l @ 25 microns}</p> <p>182 sq. ft. at 3 mils (4.5 m<sup>2</sup>/l @ 75 microns)</p> <p>*NOTE: Material losses during mixing and application will vary and must be taken into consideration when estimating job requirements.</p>				

<b>Dry Temp. Resistance</b>	<b>(non-immersion)</b>
	Continuous: 150°F(65°C)
	Non-continuous: 200°F (93°C)

<b>Limitations</b>	<p><b>Note:</b> Application over Carbo Zinc primers may require a mist coat.</p> <p><b>NOT RECOMMENDED FOR:</b> Tank lining service or solvent exposure.</p>
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## Substrates & Surface Preparation

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

December 2008 replaces February 2008

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# Carbocryl®3631HB

## 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 or  
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

Between Coats or To Handle	Temperature	Final Cure
24 hours	40°F (4°C)	48 hours
18 hours	5CTF(10°C)	36 hours
10 hours	60°F(16°C)	20 hours
5 hours	75°F (24°C)	10 hours
3 hours	90°F (32°C)	6 hours

## Packaging, Handling & Storage

Shipping Weight (Approximate)	Carbocryl 3631 HB	5 Ltrs (5.9 kg)	20 Ltrs. (23.9 kg)
	Thinner #10	5 (4.25 kg)	20 Ltrs. (17 kg)

**Flash Point (Setaflash)** (Pensky-Martens Closed Cup)Carboline 3631 HB 58°F (14°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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