

ENDURACOAT 3630 HB & FINISH

SELECTION DATA

GENERIC TYPE: Chlorinated Rubber. Single package. ENDURACOAT 3630 Finish contains modifying resin to improve weatherability.

GENERAL PROPERTIES: ENDURACOAT 3630 High Build contains no oil or alkyd modifiers, and exhibits the excellent chemical resistance properties of chlorinated rubber. Particularly recommended for exposure to splash, spillage and fumes of caustics, acids, salts and water. Frequently used as a topcoat over inorganic zinc base coats. Abrasion resistance and weathering properties are very good.

ENDURACOAT 3630 Finish is a fast drying finish coat that exhibits high gloss and good colour 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: ENDURACOAT 3630 High Build, over an appropriate primer, provides an excellent maintenance system for use in all industries including chemical processing, pulp and paper, petroleum, railroads, marine, etc. Very effective in exposures of high humidity such as paper pulp mills. ENDURACOAT 3630 Finish is used as topcoat on outdoor structural steel, equipment exteriors and concrete when its superior weather resistance is required.

NOT RECOMMENDED FOR: Immersion service other than water or solvent exposures other than straight-chain hydrocarbons.

CHEMICAL RESISTANCE GUIDE:

	<u>High Build</u>	<u>Finish</u>
Acids	Excellent	Very Good
Alkalies	Excellent	Good
Solvents	Poor	Poor
Salts	Excellent	Excellent
Water	Excellent	Excellent

TEMPERATURE RESISTANCE:

Continuous:	65°C
Non-Continuous:	93°C

FLEXIBILITY: Good

WEATHERING: High Build Very Good
Finish Excellent

ABRASION RESISTANCE: Very Good

SURFACES: Steel, concrete, inorganic zinc primers.

TOPCOAT REQUIRED: ENDURACOAT 3630 High Build is normally applied over inorganic zinc silicate primers with an optional third coat of ENDURACOAT 3630 Finish for a glossy appearance. Other topcoats may be used eg acrylics, silicones, alkyds, or others as recommended.

COMPATIBILITY WITH OTHER COATINGS: Generally used on new work or existing chlorinated rubber surfaces but may be applied over some alkyds or well aged oil paints; refer manufacturer. Also on most epoxy primers, or chlorinated rubber primers. ENDURACOAT 3630 HB only may be used directly over inorganic zinc primers.

SPECIFICATION DATA

THEORETICAL SOLIDS CONTENT:

	<u>By Volume</u>
ENDURACOAT 3630 High Build	32% ± 1%*
ENDURACOAT 3630 Finish	32% ± 1%*

* May vary with certain colours.

COVERAGE DATA AND SYSTEMS:

	<u>Thickness</u>	<u>Theo. Coverage*</u> m ² /litre
ENDURACOAT 3630 HB	75 microns	4.3
ENDURACOAT 3630 Finish	<u>50 microns</u> 25 microns	6.4

* NOTE: Material losses during mixing and application will vary and must be considered when estimating requirements.

COLOURS:

ENDURACOAT 3630 High Build - White and selected colours
ENDURACOAT 3630 Finish - White and selected colours
Other colours are available on special order and are not returnable.

MIXING: Mix to a smooth consistency. Thin up to 25% by volume with Thinner #P10 (or P18) if necessary.

GLOSS: ENDURACOAT 3630 High Build - Flat
ENDURACOAT 3630 Finish - Semi-Gloss.

April 2016 replaces August 2013

APPLICATION INSTRUCTIONS

SURFACE PREPARATIONS: Prepare the steel as demanded by the primer employed. The primer surface must be clean and dry. On other surfaces, loose paint should be removed and the remaining tight compatible material should be free of any contamination and thoroughly cleaned. Inorganic zincs should be free of any soluble or loose residue or curing solutions. Concrete must be clean and dry and should be roughened or acid-etched if smooth.

THINNER: Thinner P10 up to 25% by volume, for spray application, Thinner No. P18 for brush, roller or hot windy conditions.

METHOD OF APPLICATION: Spray preferred for smooth finish and best edge protection. Small areas may be brushed.

	Spray Guns	Fluid Tip	Air Cap
ENDURACOAT 3630 Finish	Binks 230 De Vilbiss JGA	60 FF	63PB 704
ENDURACOAT 3630 High Build	Binks 230 De Vilbiss JGA	071 E	63PB 704

Airless: Use 13.8 Mpa (2,000 psi) fluid pressure and a 380- to 430-micron (15-17 mil) orifice.

SHELF LIFE: Up to 12 months if stored in unopened containers under proper conditions.

APPLICATION TEMPERATURES:

	<u>Surface</u>	<u>Ambient</u>	<u>Humidity</u>
Minimum	4°C	4°C	0%
Normal	18-29°C	13-38°C	10-85%
Maximum	49°C	49°C	95%

Special thinning and application techniques may be required outside normal temperatures.

DRYING TIMES: (at 25°C)

ENDURACOAT 3630 High Build - Allow 4-8 hours before topcoating.

ENDURACOAT 3630 Finish - Allow 2 hours before recoating (up to 5 hours in cold poor drying conditions).

FLASH POINT: (Pensky-Martens Closed Cup)

ENDURACOAT 3630 High Build	20°C
ENDURACOAT 3630 Finish	20°C
Thinner #P10	24°C
Thinner P18	55°C

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