

## SELECTION & SPECIFICATION DATA

<b>Generic Type</b>	Multi-Purpose Phenalkamine Epoxy High Build
<b>Description</b>	Carboguard® 636 is an advanced technology coating suited to marine and industrial applications and suitable for atmospheric and many immersion exposures. The DTM properties make Carboguard® 636 a versatile coating in maintenance and new work applications. Syntactic foam modification gives Carboguard® 636 unique thermal shock resistance and flexibility.
<b>Features</b>	<ul style="list-style-type: none"> <li>• Very good flexibility – resists chipping and aged embrittlement</li> <li>• Lighter weight – 13% lighter than most similar coatings</li> <li>• Versatile surface tolerant coating</li> <li>• Suitable for application over surfaces prepared by water-jetting</li> <li>• NZ approved for use in food processing plants - refer Approvals NZ/AU, page 4</li> <li>• AS4020 Potable Water Approval - refer Approvals NZ/AU, page 4</li> <li>• Lower viscosity allows application at higher solids (less thinning) and reduced VOC at application</li> <li>• Good thermal qualities by syntactic foam modification; excellent for use under insulation to 120°C</li> <li>• Good adhesion to tight rust - especially when used in conjunction with Rustbond® or Altra~Lock® 576</li> <li>• Tolerant to surface dampness - particularly when brush applied</li> <li>• Self-priming (DTM) for many applications</li> <li>• Fast dry to recoat</li> <li>• Excellent dry to handling</li> <li>• Suitable for fresh and salt water immersion</li> <li>• Low temperature cure to below freezing; -5°C</li> <li>• Reduced HAPS and Low VOC</li> </ul> <p>Altra~Lock® is the registered trademark of Altex Coatings Limited</p>
<b>Colour</b>	Haze Grey, Cloud Grey, MIOX, Golden Yellow LF, Aluminium and Black
<b>Gloss</b>	Low Sheen
<b>Primer</b>	Carbozinc® 859 EZ2, Carbozinc® 858, Carbozinc® 11, Carboguard® 504, Carbomastic® 615 Direct to steel prepared by power-tool cleaning or better. Over porous or rusty surfaces correctly sealed and strengthened with Rustbond® or Altra~Lock® 576.
<b>Film Build</b>	125-200 microns DFT per coat
<b>Solid(s) Content</b>	80% by volume
<b>Coverage Rate</b>	5.33 square metres per litre at 150 microns DFT (theoretical)
<b>VOC Value(s)</b>	213 grams per litre (mixed)
<b>Dry Temp. Resistance</b>	<p>Continuous: 90°C (194°F) Non-Continuous: 121°C (250°F)</p> <p>*This product will withstand non-exposed continuous 121°C as a coating under insulation (CUI) Discolouration will be observed above 93°C</p>
<b>Limitations</b>	Exterior exposure will cause early loss of sheen, possible discolouration and chalking. This will not affect the protective properties of the coating.

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<b>Topcoats</b>	<ul style="list-style-type: none"><li>• Carbothane® 134 HG or 133 LH</li><li>• Carboguard® 2929</li><li>• Sea~Barrier range of antifoulings</li><li>• E~Line range of finish coats</li><li>• Or self-finishing</li></ul>
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### SUBSTRATES & SURFACE PREPARATION

<b>General</b>	Remove any oil or grease from surface using clean rags soaked in Thinner #2 or toluene.
<b>Steel</b>	<ul style="list-style-type: none"><li>• <u>For optimum performance &amp; Immersion Service</u>: Abrasive blast to SSPC SP10 (AS1627.4 Class 2½) and achieve a uniform jagged blast profile of 35µm (minimum) and up to 75µm. Prime as required.</li><li>• <u>For general commercial work</u> : Abrasive blast to a minimum SSPC SP6 (AS 1627.4 Class 2) and achieve a uniform jagged blast profile of 35µm (minimum) and up to 75µm</li><li>• <u>For general maintenance</u>, minimum power-tool clean to SSPC SP3 (AS 1627.2)</li><li>• <u>For rapid turn-around ship dockings</u>, preparation by water-jetting to minimum WJ-2 M (NACE No.5 / SSPC-SP 12) is acceptable.</li></ul>
<b>Galvanized Steel</b>	<p><u>Not recommended for direct application.</u></p> Sweep abrasive blast to remove all passivation treatment, white rust etc and render to a profiled surface. Prime with Carboguard® 504 or as recommended.
<b>Concrete</b>	Concrete should be fully cured for 28 days at 21°C and 50% RH or equivalent. Remove all laitance by sweep abrasive blasting, HP Water-Jetting or acid etching. For maximum performance and to reduce the risk of pin-holing seal the prepared concrete with Carboguard® 1340.

### MIXING & THINNING

<b>Mixing</b>	Mix each component separately, then combine and mix to the correct 4:1 proportions.
<b>Thinning</b>	<ul style="list-style-type: none"><li>• For spray application thin up to 12.5% by volume with Thinner #12.</li><li>• For brush application thin as required with Thinner #25.</li></ul>
<b>Ratio</b>	<ul style="list-style-type: none"><li>• 4:1 by volume (Part A : Part B)</li><li>• <u>1.25 litre kit</u>: Part A 1 litre, Part B 0.25 litre</li><li>• <u>5 litre kit</u>: Part A 4 litres, Part B 1 litre</li><li>• <u>10 litre kit</u>: Part A 8 litres, Part B 2 litres</li></ul>
<b>Pot Life</b>	4 hours at 25°C (5 litre kit)
<b>Induction Time</b>	15 minutes at 25°C; longer if colder

### APPLICATION EQUIPMENT GUIDELINES

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.

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<b>Conventional Spray</b>	Pressure pot equipped with dual regulators, 9.5 mm (3/8") I.D. minimum material hose, 1.8 mm (.070") I.D. fluid tip and appropriate air cap. Hold gun 300-350 mm from the surface and at a right angle to the surface.
<b>Airless Spray</b>	<p>Pump Ratio: 45:1            Volume Output: 11.5 l/minute min.            Material Hose: 12.5mm min. (½" I.D.) recommended            Tip Size: 0.53-0.78mm (.021-.031")            Output Press.: 140-175kg/cm<sup>2</sup> (2000-2500 psi)            The following spray equipment has been found suitable; or equivalent.            Mfr. &amp; Gun: Graco 207-300            Pump*: Bulldog 45:1            *Teflon packings are recommended and available from pump manufacturer.</p>
<b>Brush &amp; Roller (General)</b>	<p>Manual application is not recommended for tank lining applications except when striping welds.            For non-immersion applications over damp surfaces, brush and roller is the preferred method.            Multiple coats may be required to obtain desired appearance, recommended dry film thickness and adequate hiding. Avoid excessive re-brushing or re-rolling. For best results, tie-in within 10 minutes at 24°C. Thin up to 12.5% by volume with Thinner #12. Use a short-nap synthetic roller cover with phenolic core.</p>

## APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	10°C (50°F)	-7°C (19°F)	-7°C (19°F)	0%
Maximum	32°C (90°F)	50°C (122°F)	35°C (95°F)	90%
Optimum	20°C (68°F)	20°C (68°F)	20°C (68°F)	30%

Industry standards are for substrate temperatures to be above the dew point. For immersion conditions it is recommended to follow this procedure. For non-immersion conditions This product can tolerate damp substrates. See Brush or Roller above. Special thinning and application techniques may be required above or below normal conditions.

## CURING SCHEDULE

Surface Temp.	Dry to Topcoat w/ Urethanes	Maximum Topcoat Time	Dry to Recoat Minimum
-5°C (23°F)	36 Hours	30 Days	16 Hours
16°C (61°F)	12 Hours	14 Days	5 Hours
24°C (75°F)	6 Hours	5 Days	3 Hours
32°C (90°F)	4 Hours	2 Days	2 Hours

The above data is indicative for finished DFT's of 150-200 microns. Drying and curing rates are influenced by ventilation, film thickness, humidity, thinning and other factors.

**\*Temperature Cautionary Note:** The temperatures in the table above refer to the time-weighted average substrate or coating temperatures NOT ambient air temperature. In exterior situations surface temperatures can vary widely with sunlit surfaces often being 20+°C higher than the air temperature.

**Antifouling Topcoat** – optimum time to topcoat Carboguard® 636 with antifouling coatings is when the film is just tack-free, firm to thumb pressure but 'thumbnail soft'; typically 2-3 hours at 24°C. Do not overcure.

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## CLEANUP & SAFETY

<b>Cleanup</b>	Use Thinner #2, #12 or acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.
<b>Safety</b>	Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions. Hypersensitive persons should wear protective clothing, gloves and use protective cream on face, hands and all exposed areas.
<b>Ventilation</b>	When used as a tank lining or 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 vapour concentration from reaching the lower explosion limit for the solvents used.
<b>Caution</b>	This product contains flammable solvents. Keep away from sparks and open flames.

## PACKAGING, HANDLING & STORAGE

<b>Shelf Life</b>	Part A: 24 months @ 24°C Part B: 24 months @ 24°C  *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
<b>Storage Temperature &amp; Humidity</b>	4-38°C 0-95%
<b>Flash Point (Setaflash)</b>	Mix: 38°C
<b>Storage</b>	Store indoors and KEEP DRY
<b>Packaging</b>	1.25 litre, 5 litre & 10 litre kits Available in NZ & Australia.

## APPROVALS

<b>Approvals NZ/AU</b>	<b>Food Processing</b> NZ AssureQuality assessed & passed for food/beverage including dairy farm & factory non-incident contact. Ref: H3107. <b>AS4020 Potable Water Approval</b> AWQC Ref: 130243-2017-CSR-1. Report #240955, Dec 2018. Exposure <5,000 mm <sup>2</sup> /L Approval applies to Haze Grey & Grey/White only.
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## WARRANTY

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