

CODE: CR-630

PRODUCT NAME:

Chlorinated Rubber Tie coat

**DESCRIPTION:**

CR-630 is a one component air drying intermediate coat designed for application directly over Inorganic zinc primers and chlorinated rubber primers. It can also be used as topcoat, durable in sever marine atmosphere and industrial environments. Topcoats required where glossy finish and improved colour retention is desired.

This paint is suitable for water treatment plants, bridges , tank exteriors, structural steel and piping in chemical plants, refineries pulp and paper mills, offshore platforms , marine equipment , ship hulls, decks and superstructures and other structures exposed to sever weathering or salt spray.

**TECHNICAL DATA:**

Binder	Modified Chlorinated Resin
Pigment	No Leaded and Chromate pigments
Finish	Semi Flat-Flat
Shade	RAL Colors
Substrate	Cleaned or blasted steel, Concrete
Volume solid	45 ±3%
Typical dry film thickness	50 Microns per one coat
Number of coat	One or two
Flash point	26 °C
Specific gravity	1.3± 0.1 Kg/Lit
Theoretical spreading rate - one coat ( at 50 microns)	9 M <sup>2</sup> /Lit
Application method	Conventional or Airless spray , brush , roller
Thinner / Cleaner	T-600
Weight of added thinner	Max 15 %
Packing	25 kg
Shelf life	12 Months



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## Drying Time

Temp	Touch dry	Hard dry	Overcoating	
			Min	Max
15°C	60 minutes	15 hours	20 hours	-
25°C	30 minutes	10 hours	14 hours	-
40°C	15 minutes	6 hours	10 hours	-

**Note:** Drying times are dependent on applied film thickness; all data in this catalogue are reported at recommended DFT.

### SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. High pressure fresh water wash or fresh water wash, as appropriate, and remove all oil or grease, soluble contaminants, and other detrimental foreign matter in accordance with SSPC-SP1 solvent cleaning.

#### **NEW BUILDING/MAJOR REFURBISHMENT**

CR-630 should always be applied over a recommended primer coatings scheme. The primer surface should be dry and free from all contamination, and CR-630 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2 ½(ISO 8501-1:1998), or SSPC-SP-1, Hand/power cleaning) and patch primed prior to the application of CR-630.

#### **Previously painted surfaces:**

Remove all mill scale, loose rust, loose paint and other detrimental foreign matter by "Hand or Power Tool Cleaning" (SSPC-SP2 or SP3, respectively).

Apply one or more spot coats of CR-630, as specified.

Surface preparation shall not take place in the following conditions:

- A) At temperature below 5 °C
- B) When the relative humidity greater than 85%
- C) When the metal surface temperature is less than 3 °C above the dew point
- D) Outside day light hours on exterior locations

### Application Method:

This material is a one component coating and should always be mixed thoroughly with a power agitator before application. Stir during application to maintain uniformity of material.

### Application Equipments

Air less Spray	Tip range 0.017-0.019 inch Total output pressure at spray tip not less than 141 Bar (2000 psi)
Air Spray	Nozzle orifice 1.8mm Nozzle pressure: 2-4 Bar (43-56 psi)
Brush	Typically 30 mic can be achieved.
Roller	Typically 30 mic can be achieved.

**Flush Equipment with recommended Cleaner before and after use.**

### **ENVIRONMENTAL CONDITINS:**

- To prevent moisture condensation during application, surface temperature must be at least 3 °C above the dew point.
- Never apply coatings under reverse environmental condition.
- In hot climate, material temperature should be 20 to 25 °C prior to mixing.
- For satisfactory cure, air and surface temperature must be above 10 °C
- Paint shall not be applied when wind speed is in excess of 7 m/s

Air temperature	10 to 40 °C
Surface temperature	10 to 50 °C
Material temperature	15 to 40 °C
Relative humidity	Max 80 %

## HEALTH AND SAFETY:

This product is Flammable. Keep away from heat and open flame .Keep container closed .Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

- 1-Circulate adequate fresh air continuously during application and drying.
- 2-Use fresh air masks and explosion proof equipment.
- 3- Prohibit all flames, sparks, welding and smoking.

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