

SELECTION & SPECIFICATION DATA

Generic Type	Waterborne acrylic
Description	A single package, high performance, direct-to-metal acrylic system. Carbocrylic 3356 has exceptional film strength and chemical resistance. Carbocrylic 3356 consists of five VOC compliant acrylic coatings for applications on tank exteriors and structural steel. May be used as a two, three or four coat all acrylic system. Carbocrylic 3356-1 (white) and 3356-2 (brown) are typically used as primers and are interchangeable as primers (white or brown as primer). In addition, Carbocrylic 3356-2 (brown) may also be used as a topcoat when a color match to weathering steel is desired.
Features	<ul style="list-style-type: none"> • Low odor • Excellent flexibility • Excellent corrosion protection • Excellent resistance to flash rusting • Meets most VOC regulations
Color	Brown 2277 (Fed Std Ref #20059)
Finish	Semi-Gloss
Dry Film Thickness	2 - 3 mils (51 - 76 microns) per coat Don't exceed 3 mils (75 microns) in a single coat. Excessive film thickness over inorganic zincs may increase damage during shipping or erection.
Solids Content	By Volume 43% +/- 2%
Theoretical Coverage Rate	690 ft ² /gal at 1.0 mils (16.9 m ² /l at 25 microns) 345 ft ² /gal at 2.0 mils (8.5 m ² /l at 50 microns) 230 ft ² /gal at 3.0 mils (5.6 m ² /l at 75 microns) Allow for loss in mixing and application.
VOC Values	As Supplied : Carbocrylic 3356-6: 0.96 lbs./gal (115 g/l) EPA Method 24
Dry Temp. Resistance	Continuous: 235°F (113°C) Non-Continuous: 300°F (149°C) Discoloration and loss of gloss is observed above 235 °F (113 °C). May be coated with Acrylics depending on exposure and need.
Topcoats	All products in the 3356 Series are compatible with each other. 3356-6 may be applied over most tightly adhering coatings. A mist coat may be required over inorganic zinc primers. Call Carboline Technical Service for recommendations.

SUBSTRATES & SURFACE PREPARATION

General	Remove all oil or grease from the surface with Thinner 2 or Carboline Surface Cleaner 3 (refer to Surface Cleaner 3 instructions) in accordance with SSCP-SP1.
Steel	Abrasive blast to a Commercial Finish in accordance with SSPC-SP6 and obtain a 1-3 mil (25-75 micron) blast profile. Hand or power tool cleaning per SSPC-SP2 or SSPC-SP3 to produce a rust-scale free surface is acceptable.

Carbocrylic[®] 3356-6

PRODUCT DATA SHEET



SUBSTRATES & SURFACE PREPARATION

Galvanized Steel | New or aged galvanized should be lightly abraded to remove sheen and/or surface deposits.

Concrete or CMU | Concrete must be cured at least 28 days at 70 °F (21 °C) and 50% R.H. or equivalent time. Remove fins and other protrusions by stoning, sanding or grinding. Abrasive blast to open all surface voids and remove form oils, incompatible curing agents, hardeners, laitance and other foreign matter and produce a surface texture similar to that of a medium grit sandpaper. Voids in concrete may require surfacing. Blow or vacuum off sand and dust.

TYPICAL CHEMICAL RESISTANCE

Exposure	Fumes	Splashes & Spills
Acids	Excellent	Very Good
Alkalies	Excellent	Very Good
Salt	Excellent	Excellent
Solvents	Good	Fair
Water	Excellent	Excellent

MIXING & THINNING

Mixing | Power mix until uniform in consistency. Avoid excessive air entrainment.

Thinning | May be thinned up to 6 oz/gal with clean, potable water where conditions dictate. Use of thinners other than those supplied or recommended by Carboline may adversely affect product performance and void product warranty, whether express or implied.

Pot Life | This is a single component product that has an indefinite working time. Keep container covered when not in use.

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.

Spray Application (General) | Pre-rinse equipment with undiluted Carboline Surface Cleaner 3 followed by clean potable water before spraying. The following spray equipment has been found suitable and is available from manufacturers.

Conventional Spray | Pressure pot equipped with dual regulators, 1/2" I.D. material hose, 0.086" fluid tip and appropriate air cap.

Airless Spray | Pump Ratio: 30:1 (minimum)*
GPM Output: 3.0 (minimum)
Material Hose: 3/8" I.D. (minimum)
Tip Size: 0.017"- 0.019"
Output PSI: 1800-2200
Filter Size: 60

*PTFE packings are recommended and available from the pump manufacturer.
For two or more spray guns a 45:1 ratio pump is recommended. For ease of application using airless spray equipment, remove the pickup tube and immerse the lower unit directly into the material.

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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.

Brush	Use a synthetic bristle brush. Multiple coats will be required in order to achieve desired film thickness and acceptable hiding characteristics.
Roller	For smooth surfaces use a short, woven nap synthetic roller. For rough surfaces, cinder block or very porous concrete, use a 3/8" woven nap synthetic roller. Multiple coats may be required to obtain desired appearance, hiding and recommended DFT.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	50°F (10°C)	50°F (10°C)	50°F (10°C)	0%
Maximum	105°F (41°C)	130°F (54°C)	110°F (43°C)	85%

Do not apply when the surface temperature is less than 5°F (3°C) above the dew point. Do not apply if temperatures are expected to drop below 50°F (10°C) within 24 hours of application. Special application techniques may be required above or below normal application conditions.

CURING SCHEDULE

Surface Temp.	Dry to Recoat & Topcoat w/ other finishes
50°F (10°C)	3 Hours
75°F (24°C)	2 Hours
90°F (32°C)	1 Hour

These times are based on a 2-3 mil (50-75 micron) thickness and 50% R.H. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure. The acrylic film forming process may require several weeks at 75 °F (24 °C) with proper ventilation to develop adhesion and water resistance. Waterborne acrylics are sensitive to moisture during early cure and are susceptible to handling damage.

CLEANUP & SAFETY

Cleanup	Use clean potable water, followed with suitable solvent to dry equipment. 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 SDS for this product. Employ normal workmanlike safety precautions. Use adequate ventilation. Keep container closed when not in use.

PACKAGING, HANDLING & STORAGE

Shelf Life	24 Months at 75 °F (24 °C) *Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers.
Storage Temperature & Humidity	40 - 110 °F (4 - 43 °C) 0-95% Relative Humidity
Storage	Store Indoors. KEEP FROM FREEZING.

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PACKAGING, HANDLING & STORAGE

Shipping Weight (Approximate)	1 Gallon Kit - 10 lbs. (5 kg)
	5 Gallon Kit - 52 lbs. (24 kg)

Flash Point (Setaflash)	>200 °F (>93 °C) for Carbocrylic 3356 Series
	>212 °F (>100 °C) for Surface Cleaner 3

WARRANTY

To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. User must contact Carboline Company to verify correctness before specifying or ordering. No guarantee of accuracy is given or implied. We guarantee our products to conform to Carboline quality control. We assume no responsibility for coverage, performance, injuries or damages resulting from use. Carbolines sole obligation, if any, is to replace or refund the purchase price of the Carboline product(s) proven to be defective, at Carbolines option. Carboline shall not be liable for any loss or damage. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY CARBOLINE, EXPRESS OR IMPLIED, STATUTORY, BY OPERATION OF LAW, OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE. All of the trademarks referenced above are the property of Carboline International Corporation unless otherwise indicated.