

SELECTION & SPECIFICATION DATA

Generic Type	Chlorinated rubber
Description	A single pack steel primer designed for use in industrial and marine applications
Features	<ul style="list-style-type: none"> • Single pack direct to steel primer • Excellent corrosion protection • Fast dry time • Excellent application properties • Excellent water immersion resistance • Reinforced with aluminium flake • Cost effective & easy to use product for dockings • Simplified coating system for maintenance repaints in the commercial marine sector • Extended time to overcoat with antifoulings • Supported by many case histories within the commercial marine market over sequential dockings
Colour	Metallic grey
Finish	Satin
Dry Film Thickness	50 - 75 microns 221 microns wet to obtain 75 microns dry
Solids Content	By volume 34% ± 1%
Theoretical Coverage Rate	4.5 m ² /L at 75 microns Allow for loss in mixing and application.
VOC Values	As Supplied : 578 g/L
Dry Temp. Resistance	60°C Dry
Topcoats	For atmospheric exposure, Chem~Bar™ 3500 is typically overcoated with Chem~Bar™ 900 vinyl acrylic. For use in the commercial marine sector, Chem~Bar™ 3500 is normally overcoated with Sea~Barrier® 1000, 3000, Altra® or Sea~Barrier® Alloy 100 PLUS Antifouling.

SUBSTRATES & SURFACE PREPARATION

General	All surfaces must be sound and free of oil, grease, dirt, loose and flaking paint, moisture, and other foreign substances prior to application of Chem~Bar™ 3500. Clean and/or degrease with either a suitable non-ionic detergent (such as Altex P40 Cleaner), or solvent wipe with Altex C50 Surface Cleaner. Chem~Bar™ 3500 may be applied directly over steel or over zinc primers such as Altra~Zinc 605, Carbozinc® 858, Zinkex 100 or Carbozinc® 11
Steel	For the best results, abrasive blast to SSPC-SP 10/NACE No.2 (AS 1627.4 Sa 2½) The steel profile after blasting should be 35 to 75 microns in depth and be of a jagged nature as opposed to a peen pattern. Satisfactory results will be achieved by abrasive blasting to SSPC-SP 6 (AS1627.4 Sa 2). In marine applications, Wet abrasive blasting to NACE WAB-2/SSPC-SP 10 (WAB) (Near-White Metal Wet Abrasive Blast) and Waterjet cleaning to NACE/SSPC-SP WJ-1 (Clean to bare substrate) are also acceptable preparation methods. Ensure that the degree of flash rusting shall be no greater than M – Medium For small areas power tool cleaning to SSPC-SP 3 (AS 1627.2 St 3) or hand tool clean to SSPC-SP 2 (AS 1627.2 St 2) may be utilised.

SUBSTRATES & SURFACE PREPARATION

Antifouling Coated Surfaces

High pressure water clean (5,000 – 10,000 psi/330 – 660 bar) to remove all marine growth, hydrolysed antifouling, salts, loose paint, and any other foreign matter. The cleaned surface, once dry should be free of any powdered antifouling residues and should be inspected for defects in the film. Repairs to the coating system should be completed with Chem~Bar™ 3500 before the application of any subsequent coat of Sea~Barrier® antifouling. Chem~Bar™ 3500 is used extensively as:

- a barrier/seal coat over aged or incompatible/unknown antifouling
- a tie coat over suitably prepared, aged epoxy coatings prior to application of the selected Sea~Barrier® antifouling
- a sealant to assist in the prevention of TBT leaching from an underlying antifouling coating - provided it is applied at a minimum dry film thickness of 80 microns (minimum 2 coats by roller)

Consult your Altex Coatings Representative for specific recommendations regarding compatibility with existing antifouling systems.

MIXING & THINNING

Mixing | Stir thoroughly to ensure a homogeneous condition.

Thinning

Thinning may be required in high temperatures, or when brush and roller application is being used. Small amounts (10% or less) of Altex Thinning Solvent #10 may be added to the mixed material.

Note: Excessive thinning can cause low film thickness, sagging and other film defects.

Use of thinners other than those supplied or recommended by Altex Coatings may adversely affect product performance and void product warranty, whether expressed or implied.

Ratio | N/A – single component coating

Pot Life | N/A

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)

The preferred method of application for Chem~Bar™ 3500 is spray.

Conventional Spray

1.4mm to 2.2mm fluid tip with appropriate air cap.

Airless Spray

Pump Ratio 30:1
Material Hose 3/8" I.D min
Tip Size 0.015 – 0.019

(Note: The above is a guide. Other equipment to the above may be used.)

Brush & Roller (General)

Brush and roller application are acceptable as long as conditions are not extreme. however, care must be taken to ensure the correct film build is applied.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	7°C	2°C	2°C	0%
Maximum	32°C	37°C	35°C	85%
Optimum	16-24°C	16-24°C	16-24°C	30-70%

CURING SCHEDULE

Surface Temp.	Dry to Handle	Dry to Recoat	Dry to Topcoat*	Dry to Touch
2°C	8 Hours	8 Hours	24 Hours	2-3 Hours
15°C	4 Hours	3½ Hours	10 Hours	1 Hour
24°C	2 Hours	2 Hours	6 Hours	35 Minutes
37°C	45 Minutes	45 Minutes	2 Hours	25 Minutes

* Relates to application of antifoulings. The Sea~Barrier® range of antifoulings may be applied to Chem~Bar™ 3500 up to 30 days after application (Surfaces must be clean and oxidation/salts free)

CLEANUP & SAFETY

Cleanup | Use Altex Thinning Solvent #10

Safety | For industrial use only: Read and follow all the caution statements on this Product Data Sheet, the product label, and the Safety Data Sheet (SDS) for health and safety information prior to use.

Ventilation | It is very important for the safety of the applicator and the proper performance of Chem~Bar™ 3500 that good ventilation be provided to all portions of the enclosed area. It is equally important to bring into the enclosed area dry fresh air to remove all solvent vapours. Since solvent vapours are heavier than air, ventilation ducts should reach to the lowest portions of the enclosed areas as well as into any structural pockets. Ventilation should be provided throughout the cure period to ensure all the solvents are removed from the coating.

PACKAGING, HANDLING & STORAGE

Shelf Life | 48 months at 24°C

Shelf Life | Shelf Life: (actual stated shelf life) when kept at recommended storage conditions and in original unopened containers. For products/components exceeding the stated shelf life, contact Technical Services for further advice.

Shipping Weight (Approximate) | 4L - 5.4 kg
10L - 13.5 kg

Storage Temperature & Humidity | Optimum: 15-20°C

Flash Point (Setaflash) | 30°C

Storage | Store under cool, dry conditions.
Avoid large fluctuations between high and low temperatures.
Avoid the formation of condensate due to low temperatures.

WARRANTY

DISCLAIMER

The information in this datasheet is provided as a guide only and is provided without warranty, implied or otherwise. It is your responsibility to determine the suitability of any information or product for the use contemplated. Conditions of use, application and the substrate are beyond our control so no liability whatsoever (whether as to coverage, performance, injury or otherwise) is accepted for the information contained herein.

Data sheets may change from time to time and it is your responsibility to ensure you have the latest product datasheet and material safety data sheet from your supplier. Check the data sheet date with the listings at www.altexcoatings.com Altex Terms and Conditions of Trade, available at www.altexcoatings.com, apply in respect of all coating products and materials supplied, including samples.