Cor-Ban® 12 Instruction Manual

Cor-Ban® 12 Product Information and Benefits

1.) Cor-Ban® 12 is a transparent, a bluish-green, and non-blocking coating that is free of chromates, heavy metals, has a low toxicity level, and contains a low level of VOC's.

2.) Cor-Ban® 12 protects aluminum substrates from mechanical damage during fabrication and assembly operations.

3.) Cor-Ban® 12 protects all substrates from corrosion during transportation and storage of components under most conditions.

4.) Cor-Ban® 12 is UV resistant and provides protection under intense UV exposure but does not change color or become difficult to remove.

5.) The cured dry film of **Cor-Ban® 12** withstands exposure to outdoor elements and resists some solvents as well as light acid water and salt mist.

6.) Cor-Ban® 12 does not allow paper or cloth to adhere to the finished film.

7.) The dried coating of **Cor-Ban® 12** offers a fast curing and durable temporary protective coating.

8.) The dried **Cor-Ban® 12** coating is easily detectable so that it allows for maximum see-through QC inspection as required.

Safety Steps and Procedures To Follow Prior To Applying Cor-Ban® 12:

1.) Always refer to the safety data sheet (SDS) prior to applying **Cor-Ban® 12** if you have any questions regarding regulatory information about this product.

2.) Always wear gloves and protective eyewear to prevent **Cor-Ban® 12** from making contact with the skin and eyes.

3.) Vacuum and wipe surfaces so that moisture and other foreign material that is on them can be removed.

4.) Clean surfaces including bare or painted metal with the following aliphatic naphtha based wipe solvents, such as **Sur-Prep® 3160**, **Sur-Prep® 3167**, and **D-5640NS/ZC-640**.

5.) Pretreat surface or apply a conversion coating and apply the primer and topcoat afterwards if necessary.

6.) Inspect the area and remove any existing CIC's in areas where corrosion may be present, remove corrosion, and repair area if necessary.

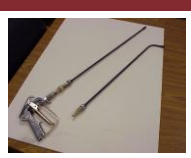
7.) Apply primer and topcoat with touch up kits if necessary.

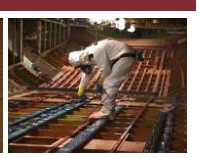
8.) Make sure that application equipment are properly set up so that **Cor-Ban® 12** transfers efficiently from its packaging and for applying it according to design for optimal weight to performance balance.

Methods For Applying Cor-Ban® 12:

Use the following equipment for applying **Cor-Ban® 12**.

* Spray Equipment (Airless, Air Assisted **(Recommended)**, High Volume Low Pressure (HVLP), Electro-Static)
* Brush
* Aerosol Can (Spray Any Way)





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Equipment Setup and Procedures For Applying Cor-Ban® 12 :

1.) Make sure that In-line pressure does not exceed 100 psi. Fluid pressure is typically 400-800 psi.

5 Gallon (18.9 Liter) Cart Sprayer

2.) Typical set-up consists of:
- *A piston type positive displacement pump
- *A pump ratio of 20:1 to 30:1
- *A high pressure in-line stainless steel filter with 200-300 mesh element

3.) Follow the recommended steps below for spraying **Cor-Ban® 12** via air assist:
- *For Graco equipment, apply **Cor-Ban® 12** at 40-50 psi
- *For Kremlin JBX 16 equipment, apply **Cor-Ban® 12** at 15-20 psi
- *Applying **Cor-Ban® 12**, start with a fluid pressure of 0 psi and gradually increase the pressure until the proper spray pattern is achieved.
- *For Graco equipment, apply **Cor-Ban® 12** at a fluid pressure of 30-40 psi and a tip size of 0.009-0.011 inches (0.22-0.27 mm)
- *For Kremlin JBX 16 equipment, apply **Cor-Ban® 12** at a fluid pressure of 30-40 psi and a tip size of 0.011-0.013 inches (0.27-0.33 mm)

4.) Follow the recommended steps below for spray applying **Cor-Ban® 12** via HVLP equipment.
- *Adjust the in-line pressure to the manufacturer's recommendations at a psi that is usually less than 60
- *Turn the fluid feed pressure to 0 psi
- *Gradually increase the fluid flow until the proper spray pattern is achieved

Airverter Spray Gun

5.) Follow the recommended steps below for spray applying **Cor-Ban® 12** via electro-static equipment.
- *Allow Electro-static equipment to charge the spray so that it is attracted to the nearest grounded object to reduce overspray and to enhance the transfer efficiency of **Cor-Ban® 12** from its packaging to where it needs to be applied
- *Use the configurations of the airless and air spray methods for applying **Cor-Ban® 12**.
- *Attach charging unit to the gun and object
- *Gradually increase in-line air pressure so that the spray provides the proper film build at the required coating speed so that the pressure does not exceed 100 psi. In-line pressure should be less than 60 psi according to the manufacturer's recommendations.
- *Turn fluid feed pressure to 0 psi and gradually increase the fluid flow until the proper spray pattern is achieved
- *Ensure that the fluid pressure is 400-800 psi
- *Turn on the charging unit and spray **Cor-Ban® 12** afterwards

6.) Proper application of **Cor-Ban® 12** via electro-static equipment can be achieved by following the steps below:
- *Minimize the flow of **Cor-Ban® 12** for the required speed and film thickness of that coating and minimizing the target distance of **Cor-Ban® 12**
- *Ensure that the **Cor-Ban® 12** being sprayed has a very high resistivity of greater than 1 mega-ohm

7.) Equipment must be properly set up prior to applying **Cor-Ban® 12** for the following reasons:
- *Decrease fogging, odor, and mist
- *Increase transfer efficiency of Cor-Ban 12 from its packaging to the area where it is being applied
- *Ensure that **Cor-Ban® 12** is applied according to the design for optimum weight to performance balance

Methods For Removing Cor-Ban® 12:

1.) The cured dry film of **Cor-Ban® 12** can be removed with a suitable alkaline wash process cleaner, such as **Calla® 301A**.

2.) Spray **Calla® 301A** to cured film to remove it.

3.) Apply **Calla® 301A** and let stand on the film until the **Cor-Ban® 12** coating begins to dissolve, which usually happens in 1-10 minutes.

4.) Use a water rinse or pressure spray to remove the **Cor-Ban® 12** coating along with the **Calla® 301A**

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Tips For Drying Cor-Ban® 12:

1.) When properly applied, allow **Cor-Ban® 12** to dry to the touch and be tack free in 1-2 hours.

2.) For a complete cure, allow **Cor-Ban® 12** to cure in 7 days at 75˚F (24˚C) and 50% relative humidity (RH).

Areas Where Cor-Ban® 12 Should Be Applied:

1.) Cor-Ban® 12 should be applied on:
* All metallic substrates, especially aluminum

Cor-Ban® 12 Product Pictures, Zip-Chem® Product Packaging Part Numbers, and Other Materials To Purchase:

Cor-Ban® 12
* Case of 12 of 16 fl oz (473 mL) Aerosols-**011666**
* Case of 4 each Gallon (4 each of 3.8 Liter) Cans-**011664**
* 5 Gallon (18.9 Liter) Pail-**011663**
* 55 Gallon (208 Liter) Drum-**002105**
* Specialized forms of packaging available upon request

Calla® 301A
* 22 fl oz (651 mL) Spray Bottle-**100453** (Ready For Use-4:1 Dilution)
* Case of 4 of 1 Gallon (4 each of 3.8 Liter) Bottles-**011866**
* 5 Gallon (18.9 Liter) Pails-**011865**
* 55 Gallon (208 Liter) Drum-**011864**
* 330 Gallon (1249 Liter) Tote-**100142**
* Specialized forms of packaging available upon request

D-5640NS/ZC-640
* Case of 12 of 16 fl oz (473 mL) Aerosols **(D-5640NS)-002070**
* Case of 4 each Gallon (4 each of 3.8 Liter) Cans **(ZC-640)-009430**
* 5 Gallon (18.9 Liter) Pails **(ZC-640)-002155**
* 55 Gallon (208 Liter) Drum **(ZC-640)-008181**
* Special forms of packaging available upon request **(ZC-640)**

Sur-Prep® 3160
* Case of 12 of 16 fl oz (473 mL) Aerosols-**010938**
* Case of 4 each Gallon (4 each of 3.8 Liter) Cans-**008578**
* 5 Gallon (18.9 Liter) Pails-**008579**
* 55 Gallon (208 Liter) Drum-**008580**
* Case of 6 Canisters of Towelettes-**100026**
* Case of 100 Individual Towelettes-**011844**
* Specialized forms of packaging upon request

Sur-Prep® 3167
* Case of 12 of 16 fl oz (473 mL) Aerosols-**103765**
* Case of 4 each Gallon (4 each of 3.8 Liter) Cans-**103762**
* 5 Gallon (18.9 Liter) Pails-**103763**
* 55 Gallon (208 Liter) Drum-**103764**
* Specialized forms of packaging available upon request

Other Aliphatic Naphtha Based Wipe Solvents	Gloves	Brush	
Protective Eyewear	Spray Equipment	Conversion Coating	Primer
Topcoat	Touch Up Kits		

*1 Gallon (3.8 Liter) Cans

*Aerosol

Sur-Prep® 3160 NSN: 6850-01-633-9843 (16 fl oz (473 mL) Aerosol); **D-5640NS NSN:** 8030-01-597-6958 (16 fl oz (473 mL) Aerosol)

•**Calla® 301A NSN:** 6850-01-159-8533 (55 Gallon (208 Liter) Drum)

For application questions regarding **Cor-Ban® 12** , contact **Zip-Chem® Aviation Products** at (1) 408 782 2335 or zipchem@addevmaterials.com.

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