

Safety Steps and Procedures To Follow Prior To Applying Cor-Ban® 35:

Always refer to the safety data sheet (SDS) and technical data sheet (TDS) prior to applying **Cor-Ban® 35** if you have any questions about this product.

Always wear gloves, protective clothing, and protective eyewear to prevent **Cor-Ban® 35** from making contact with the skin and eyes.

Make sure there is proper airflow in the area where **Cor-Ban® 35** will be applied and wear a respiratory device if the ventilation in the area where **Cor-Ban® 35** will be applied is insufficient to prevent the inhalation of fumes from the **Cor-Ban® 35**.

Make sure there are no sparks, open flames, or other combustion sources in the area where **Cor-Ban® 35** will be applied.

Cure sealants to recommendations set by the manufacturer prior to applying **Cor-Ban® 35**.

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

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



If the sprayed form of **Cor-Ban® 35** shows fisheyes, separations, or anything that prevents it from being homogeneous and free of voids, then the surface is not clean and needs to be vacuumed and/or wiped again.

Cor-Ban® 35 Product Information and Benefits:

Cor-Ban® 35 is a high solids, low volatile, high penetration, water displacing, and long lasting non-decorative coating with a salmon pink tint and has a very low dry film weight of < 1 mil (25 microns).

Cor-Ban® 35 is free of chromates, heavy metals, and has a low toxicity and VOC level.

Cor-Ban® 35 dries quickly and has a film that is thin, detectable, non-sagging, and thixotropic.

Cor-Ban® 35 surpasses >2000 hours of salt spray, is removable by solvents, and has long lasting corrosion inhibiting properties

Cor-Ban® 35 does not crack or flake in environments as low as - 40°F (-40°C).

Areas To Mask Prior To Applying Cor-Ban® 35:

Mask areas that will not to be coated, such as:

- * Electrical Connectors
- * Pins In Sliding Surface Contact
- * Joints In Sliding Surface Contact
- * Control Cables
- * Pulley and Quadrant Cable Grooves
- * Bushing and Bearings For All Types, which includes lined Teflon
- * Silicone or Rubber Seals
- * High Temperature Areas
- * Wire Bundles
- * Lubricated Surfaces
- * Drain Valves
- * Oxygen System Components (i.e. Bottles, Pressure Metering and Indicating Equipment and Connections)



Methods For Applying Cor-Ban® 35:

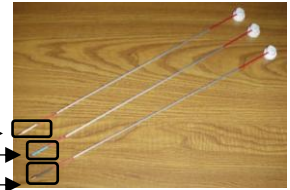
Use the following equipment for applying **Cor-Ban® 35**.

- * HVLP Guns
- * Airless Spray Equipment
- * Aerosol
- * **Formit®** Extension Wands-For use with all **Zip-Chem®** aerosols to reach difficult to access areas, such as stringer edges.
- * **Zip-Chem® Aerosol Trigger Sprayer**-For use with any **Zip-Chem®** Aerosol can
- * Bulk Application Equipment

HLVP Gun



- * **Formit®** 360° Spray (White Tube) Wand
- * **Formit®** Fan Spray Spray (Blue Tube) Wand
- * **Formit®** 180° Spray (Black Tube) Wands



Zip-Chem® Aerosol Trigger Sprayer

Formit® 360° Spray Demonstration Video



Formit® Fan Spray Demonstration Video



Formit® 180° Spray Demonstration Video



Methods For Applying Cor-Ban® 35 (Continued From Page 2):

1.) HVLP Spray Gun Setup

- A.) Set the air pressure. This is very important because if there is too much pressure, then the texture and spray of **Cor-Ban® 35** will be dry. Too little pressure however, results in a poor atomization and orange peeling of **Cor-Ban® 35**.
- B.) If you see texture in the spray of **Cor-Ban® 35**, then increase the air pressure of your **HVLP gun**. If you see an overspray cloud of **Cor-Ban® 35**, then decrease the air pressure slightly. The proper spray pattern for **Cor-Ban® 35** should be a **slightly wet pass with no flooding or sagging** because thinly applied products like **Cor-Ban® 35** can run very fast.
- C.) One pattern that should be used when using the **HVLP gun** to apply **Cor-Ban® 35** is the **fan pattern** because it uses a **full wide fan spray** which provides better consistency and leveling when applying **Cor-Ban® 35** with the **HVLP spray guns**.
- D.) The air pressure when the trigger is pulled for the gun should be **20–30 PSI** even though most guns specify **10 PSI** at the air cap.
- E.) Always set the pressure with the trigger fully pulled because the pressure drops under flow.
- F.) Close off the air and fluid adjustment knobs.
- G.) Slowly open the air adjustment knob with the trigger pulled.
- H.) Open the fluid adjustment knob slowly until you see a fine mist from the air cap.
- I.) Continue to fine tune the settings until the desired spray pattern is achieved.

HVLP Spray Gun



2.) Air Assisted Spray Gun Setup

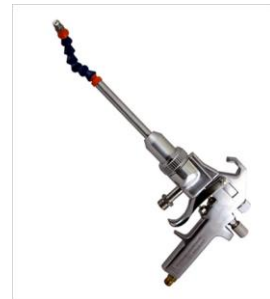
- A.) Determine the tip size for the gun. This is very important especially for a thin material, such as **Cor-Ban® 35**.

Note: Do not increase the gun tip size especially to **.015 “ or more** when applying **Cor-Ban® 35** because the applied material will exhibit the following characteristics below.

- *Too much **Cor-Ban® 35** being applied
- ***Cor-Ban® 35** runs
- *Orange peel in the **Cor-Ban® 35**
- *An overspray cloud in the applied **Cor-Ban® 35**

- B.) For pressure settings, use the lowest pressure possible so that **Cor-Ban® 35** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**. The setup of **air assisted spray equipment** varies based on the size and type of gun that is being used but a good starting point for the pressure of the **air assisted spray gun** should be around **900-1200 PSI**.
- C.) Slowly increase the pressure of the gun until the **fan spray** pattern of **Cor-Ban® 35** is fully developed and even and there are no fingers or tails on the edges of the spray equipment. If you hear a harsh hissing noise or see fogging in the spraying of the **Cor-Ban® 35**, then the pressure of the air assisted spray gun is too high. None of these observations should occur because thin materials like **Cor-Ban® 35** atomize very easily.
- D.) Set the pump ratio of the equipment to a range of **20:1 to 30:1**.
- E.) Setup the following parts for the airless spray equipment below.
- ***Displacement Pump With A Positive Piston Type**
 - ***Stainless Steel Filter With A High Pressure With 200-300 mesh element**

Airverter Spray Gun



Part of



Methods For Applying Cor-Ban® 35 (Continued From Page 3):

Air Assisted Spray Gun Setup (Continued From Page 3)

- F.) Maintain your distance of the gun from the surface as the distances between **air assisted spray guns** and other spray methods can vary. A good distance to follow for **air assisted spray guns** is about **12” or more**. If you spray apply **Cor-Ban® 35** at a distance closer than **12”**, then there will be a heavy buildup of **Cor-Ban® 35**, tiger stripping of material from the surface where the **Cor-Ban® 35** was applied, and a variation in the gloss of the **Cor-Ban® 35**.
- G.) Consider the passing speed of **Cor-Ban® 35** because the output of **Cor-Ban® 35** from **air assisted spray guns** can vary between other spray methods. Therefore, you may need to move faster or slower than other spray methods, such as **HVLP guns**.
- H.) The **Cor-Ban® 35** should be spray applied as a **smooth continual pass** with a **50% overlap**.
- I.) The table below lists some differences between the **HVLP spray** method and the **air assisted spray gun** methods.

HVLP	Air Assisted Spray Gun
Soft spray of Cor-Ban® 35	More aggressive fan spray of Cor-Ban® 35
Slow Cor-Ban® 35 output	Fast output of Cor-Ban® 35
Very forgiving when applying Cor-Ban® 35	Cor-Ban® 35 can run quickly
Less overspray bounce of Cor-Ban® 35	More fogging potential for Cor-Ban® 35 than with HVLP spray method

3.) Airless Spray Setup

- A.) Determine the tip size for the gun. This is very important especially for a thin material such as **Cor-Ban® 35**.

Note: Do not increase the gun tip size especially to **.015 “ or more** when applying **Cor-Ban® 35** because the applied material will exhibit the following characteristics below.

- *Too much **Cor-Ban® 35** being applied
- ***Cor-Ban® 35** runs
- *Orange peel in the **Cor-Ban® 35**
- *An overspray cloud in the applied **Cor-Ban® 35**



- B.) For pressure settings, use the lowest pressure possible so that **Cor-Ban® 35** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**. The setup of **airless spray equipment** varies based on the size and type of gun that is being used but a good starting point for the pressure of the **airless spray gun** should be around **900-1200 PSI**.
- C.) Slowly increase the pressure of the gun until the **fan spray** pattern of **Cor-Ban® 35** is fully developed and even and there are no fingers or tails on the edges of the spray equipment. If you hear a harsh hissing noise or see fogging in the spraying of the **Cor-Ban® 35**, then the pressure of the airless spray gun is too high. None of these observations should occur because thin materials like **Cor-Ban® 35** atomize very easily.
- D.) Set the pump ratio of the equipment to a range of **20:1 to 30:1**.
- E.) Setup the following parts for the airless spray equipment below.
 - ***Displacement Pump With A Positive Piston Type**
 - ***Stainless Steel Filter With A High Pressure With 200-300 mesh element**
- F.) Maintain your distance of the gun from the surface as the distances between airless spray guns and other spray methods can vary. A good distance to follow for airless spray guns is about **12” or more**. If you spray apply **Cor-Ban® 35** at a distance closer than **12”**, then there will be a heavy buildup of **Cor-Ban® 35**, tiger stripping of material from the surface where the **Cor-Ban® 35** was applied, and a variation in the gloss of the **Cor-Ban® 35**.

Methods For Applying Cor-Ban® 35 (Continued From Page 4):

Airless Spray Setup (Continued From Page 4)

- G.) Consider the passing speed of **Cor-Ban® 35** because the output of **Cor-Ban® 35** from **airless spray guns** can vary between other spray methods. Therefore, you may need to move faster or slower than other spray methods, such as **HVLP guns**.
- H.) The **Cor-Ban® 35** should be spray applied as a **smooth continual pass** with a **50% overlap**.
- I.) The table below lists some differences between the **HVLP spray** method and the **airless spray gun** methods.

HVLP	Airless Spray Gun
Soft spray of Cor-Ban® 35	More aggressive fan spray of Cor-Ban® 35
Slow Cor-Ban® 35 output	Fast output of Cor-Ban® 35
Very forgiving when applying Cor-Ban® 35	Cor-Ban® 35 can run quickly
Less overspray bounce of Cor-Ban® 35	More fogging potential for Cor-Ban® 35 than with HVLP spray method

4.) Cor-Ban® 35 5 Gallon (18.9 Liter) Cart Sprayer Setup

- A.) Determine the tip size for the gun. This is very important especially for a thin material such as **Cor-Ban® 35**.

Note: Do not increase the gun tip size especially to **.015" or more** when applying **Cor-Ban® 35** because the applied material will exhibit the following characteristics below.

- *Too much **Cor-Ban® 35** being applied
- ***Cor-Ban® 35** runs
- *Orange peel in the **Cor-Ban® 35**
- *An overspray cloud in the applied **Cor-Ban® 35**



- B.) For pressure settings, use the lowest pressure possible so that **Cor-Ban® 35** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**. The setup of **5 Gallon (18.9 Liter) Cart Sprayer** varies based on the size and type of gun that is being used but a good starting point for the pressure of the **5 Gallon (18.9 Liter) Cart Sprayer** should be around **900-1200 PSI**.
- C.) Slowly increase the pressure of the gun until the **fan spray** pattern of **Cor-Ban® 35** is fully developed and even and there are no fingers or tails on the edges of the spray equipment. If you hear a harsh hissing noise or see fogging in the spraying of the **Cor-Ban® 35**, then the pressure of the gun is too high. None of these observations should occur because thin materials like **Cor-Ban® 35** atomize very easily.
- D.) Set the pump ratio of the equipment to a range of **20:1 to 30:1**.
- E.) Setup the following parts for the **5 Gallon (18.9 Liter) Cart Sprayer** below.
 - ***Displacement Pump With A Positive Piston Type**
 - ***Stainless Steel Filter With A High Pressure With 200-300 mesh element**
- F.) Maintain your distance of the gun from the surface as the distances between **5 Gallon (18.9 Liter) Cart Sprayers** and other spray methods can vary. A good distance to follow for airless spray guns is about **12" or more**. If you spray apply **Cor-Ban® 35** at a distance closer than **12"**, then there will be a heavy buildup of **Cor-Ban® 35**, tiger stripping of material from the surface where the **Cor-Ban® 35** was applied, and a variation in the gloss of the **Cor-Ban® 35**.
- G.) Consider the passing speed of **Cor-Ban® 35** because the output of **Cor-Ban® 35** from **5 Gallon (18.9 Liter) Cart Sprayers** can vary between other spray methods. Therefore, you may need to move faster or slower than other spray methods, such as **HVLP guns**.
- H.) The **Cor-Ban® 35** should be spray applied as a **smooth continual pass** with a **50% overlap**.

Methods For Applying Cor-Ban® 35 (Continued From Page 5):

Airless Spray Setup (Continued From Page 5)

I.) The table below lists some differences between the HVLP spray method and the 5 Gallon (18.9 Liter) Cart Sprayer spray methods.

HVLP	5 Gallon (18.9 Liter) Cart Sprayer
Soft spray of Cor-Ban® 35	More aggressive fan spray of Cor-Ban® 35
Slow Cor-Ban® 35 output	Fast output of Cor-Ban® 35
Very forgiving when applying Cor-Ban® 35	Cor-Ban® 35 can run quickly
Less overspray bounce of Cor-Ban® 35	More fogging potential for Cor-Ban® 35 than with HVLP spray method

4.) Electro-Static Spray Gun Setup

- A.) Minimize the flow of Cor-Ban® 35 for the required coating speed and film thickness.
- B.) Minimizing the target distance of spraying Cor-Ban® 35.
- C.) Ensure that the Cor-Ban® 35 to be sprayed has a very high resistivity of at least 1 mega-ohm.
- D.) Attach charging unit to the gun and object to be sprayed with Cor-Ban® 35.
- E.) Gradually increase in-line air pressure so that the spray provides proper Cor-Ban® 35 build at the required coating speed and ensure that the pressure does not exceed 100 psi.
- F.) Fluid pressure is typically 400-800 psi so make sure it is set to that psi range.
- G.) Turn on charging unit and begin spraying Cor-Ban® 35 .

Electro-Static Spray Gun



It is important to ensure that the HVLP, air assisted, airless, or electrostatic paint gun for applying Cor-Ban® 35 are properly setup for the following reasons below.

- *Decrease odor, fogging, and mist from the application of Cor-Ban® 35
- *Increase the transfer efficiency of the Cor-Ban® 35 from the equipment to the area it needs to be applied to
- *Ensure that Cor-Ban® 35 will be applied according to how it was designed to be applied with respect to optimum weight to performance balance

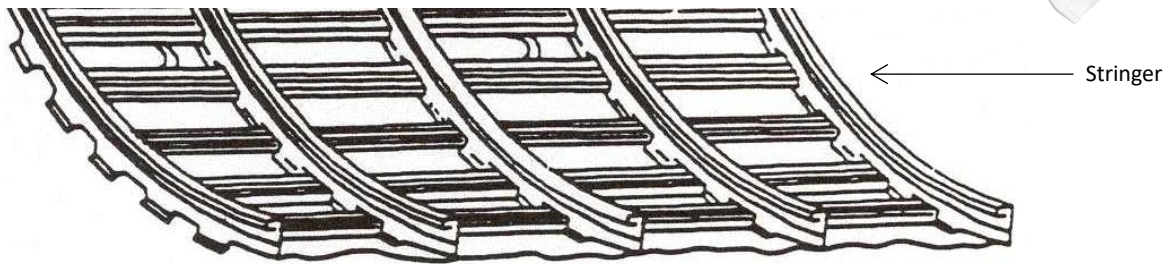
Areas Where Cor-Ban® 35 Should Be Applied:

Cor-Ban® 35 should be applied on:

- * Any Faying Surface
- * Stingers
- * Formers
- * Upper Edge Floor Beams
- * Wheel Wells
- * Pressure Deck
- * Center Wing Sections
- * Interior Fuselage
- * Landing Gear Wells



Center Wing Section



Stringer

Tips For Applying Cor-Ban® 35:

Focus the application process of Cor-Ban® 35 on all faying surfaces to ensure joint penetration and then then coat the entire area before moving on to the next section.

Inspect the surface for proper coating under stringers, formers, and other structures that are not in the line of sight.



The applied Cor-Ban® 35 coating should be continuous and free of voids.

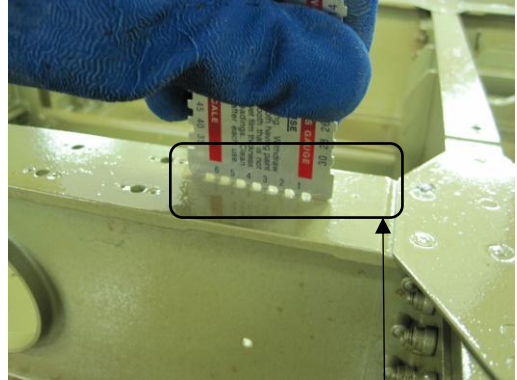
Runs drips, sags, etc, are allowed provided that the drain holes and cross drains for where Cor-Ban® 35 should drain out of are not blocked.

If the drain holes or cross drains become blocked, then wipe up the excess Cor-Ban® 35 using clean, dry gauze, or rags.

The Cor-Ban® 35 material will exhibit slight sags or wavy material lines on inclined surfaces in some situations. Immediate attention with a paint brush, however, will eliminate thick runs and sags. Extremely thick areas or puddles need to be wiped up quickly using solvents that are listed below in the removal instructions.

Thickness For Cor-Ban® 35 Including Tips For Measuring That Thickness:

The application thickness of **Cor-Ban® 35** should be approximately **1.0 to 1.5 mils (25-38 microns) wet** and **0.75 mils (19 microns) dry**. For measuring the **wet film thickness** of **Cor-Ban® 35**, use protection for your hand so that you can push **Zip-Chem® 's Wet Film Thickness Gauge** as shown below into the **Cor-Ban® 35** material via hand after the **Cor-Ban® 35** has been allowed to flow for a few minutes.



The thickness of the **Cor-Ban® 35** can be determined by the **visible tracks** in the **wet film** that are left by the **gauge fingers** of the **Wet Film Thickness Gauge**. The **dry film thickness** of **Cor-Ban® 35** may be verified using **paint thickness instruments**.

Tips For Drying Cor-Ban® 35:

Cor-Ban® 35 typically will dry to a hard, tack free film in **45 minutes to 2 hours**. These dry times should be accurate provided that adequate ventilation was utilized and that the **Cor-Ban® 35** material was applied within the thickness range that was called out in the paragraph for the thickness that the dry material of **Cor-Ban® 35** should be applied at under **Tips For Measuring The Thickness of Cor-Ban® 35** section above. The speed at which **Cor-Ban® 35** dries and cures at is also influenced by:

- * Temperature
- * Humidity

Methods For Removing Cor-Ban® 35:

1.) **Cor-Ban® 35** can be removed with an aliphatic naphtha based wipe solvent s or its equivalents. **Cor-Ban® 35** can also be removed with corrosion preventive compound/corrosion inhibiting compound removers, such as:

- * **Sur-Prep® 3160**
- * **Sur-Prep® 3167**
- * **D-5640NS/ZC-640**
- * **Zip-Strip™ 125M**

2.) Cured **Cor-Ban® 35** can be removed with:

- * **Sur-Prep® 3160**
- * **Sur-Prep® 3167**
- * **Zip-Strip™ 125M**



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Removing Cured Cor-Ban® 35:

Steps for removing cured Cor-Ban® 35 using Sur-Prep® 3160, Sur-Prep® 3167, or D-5640NS/ZC-640

1.) Identify the area that needs the Cor-Ban® 35 to be removed from.



2.) Spray the solvent, such as the Sur-Prep® 3160, Sur-Prep® 3167, or D-5640NS/ZC-640 .



3.) Soak a rag with the solvent mentioned above.



4.) Wipe the area that was treated with the solvent with the rag that was soaked with the solvent.

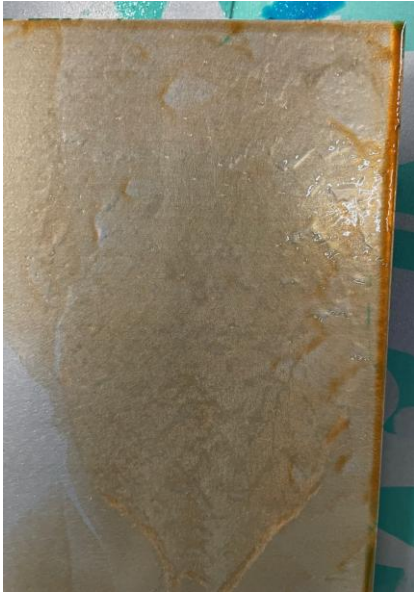


5.) Continue wiping until the area is clean

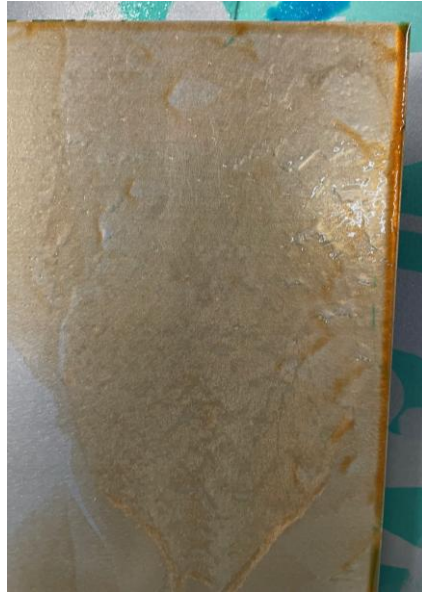
Removing Cured Cor-Ban® 35 (Continued From Page 9):

Removing Cor-Ban® 35 using Zip-Strip™ 125M

1.) Identify the area that needs the Cor-Ban® 35 to be removed from.



2.) Spray the area with Zip-Strip™ 125M



3.) Allow Zip-Strip™ 125M to dwell on the area for **15 minutes or longer** depending on the tenacity of the CIC film.



4.) Rinse the area with water or take a water soaked rag and wipe up the area until it is clean.



Cor-Ban® 35 Instruction Manual

Cor-Ban® 35 Product Pictures, Zip-Chem® Product Packaging Part Numbers, and Other Materials To Purchase:

Cor-Ban® 35

- *Case of 12 of 16 fl oz (473 mL) Aerosols-**004675**
- *Case of 12 of 8 oz (227 gram) Brush In Cap-**010884**
- *Case of 12 each Quart (946 mL)-**009408**
- *Case of 4 each Gallon (4 each of 3.8 Liter) Cans-**009409**
- *5 Gallon (18.9 Liter) Pail-**002104**
- *55 Gallon (208 Liter) Drum-**002105**
- *Specialized forms of packaging available upon request

Zip-Strip™ 125M

- *Case of 12 of 16 fl oz (473 mL) Aerosols-**102614**
- *Case of 4 each Gallon (4 each of 3.8 Liter) Cans-**102608**
- *5 Gallon (18.9 Liter) Pails-**102609**
- *55 Gallon (208 Liter) Drum-**102610**
- *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**)

Formit® Wands (12 Assemblies Per Package)

- *Formit®-18-Fan-006224
- *Formit®-18-180-006226
- *Formit®-18-360-006227
- *Formit®-18-STD-FOG-008352
- *Formit®-18-90-FOG-008353
- *Formit®-29-360-101321
- *Formit®-36-360-009131
- *Formit®-48-360 with metal sleeve-**009132**
- *Formit®-48-360 without metal sleeve-**100424**
- *Formit®-48-Fan-008460
- *Formit® Sample Pack (3 each of Formit®-18-Fan, Formit®-18-180, Formit®-18-360, Formit®-18-STD-FOG-100107)

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

Wet Film Thickness Gauge

- ***100266**

Zip-Chem® Aerosol Trigger Sprayer

- ***010040**

Bulk Application Equipment	Gloves	Protective Clothing	Respiration Devices	Spray Equipment	Protective Eyewear	Tin Foil
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Ventilation Equipment	Curing Devices	Masking Tape	Vacuum	Paint Thickness Instruments	Wiping Devices
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Aliphatic naphtha based wipe solvents or equivalents



Part of

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MATERIALS

Cor-Ban® 35 Product Pictures, Zip-Chem® Product Packaging Part Numbers, and Other Materials To Purchase (Continued From Page 11):



← *Cor-Ban® 35 1 Gallon (3.8 Liter) Can



← *Cor-Ban® 35 16 Fluid Ounce (473 mL) Aerosol

← NSN: 6850-01-492-2932

← NSN: 8030-01-531-7358

Additional Cor-Ban® 35 NSN's: 8030-01-531-7360 (5 Gallons (18.9 Liter)), 8030-01-615-4737 (Quart (946 mL)),
NSN: 8030-01- 615-4733 (8 oz (227 gram) Brush In Cap)

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)

Zip-Strip™ 125M NSN's: 6850-01-695-8514 (5 Gallon (18.9 Liter) Pail), 6850-01-707-8887 (16 fl. oz (473 mL) Aerosol)

Formit® NSN's: 4730-01-612-9914, NSN: 4730-01-661-8773 (**Formit®-18-Fan**); 6850-01-492-2942 (**Formit®-18-360**);
4730-01-632-0156 (**Formit®-18-STD-FOG**); 1560-01-658-8943 (with metal sleeve),
4730-01-659-5461 (without metal sleeve) (**Formit®-48-360**) 4730-01-632-0157 (**Formit®-48-Fan**)

For application questions regarding **Cor-Ban® 35**, contact **Zip-Chem® Aviation Products** at (1) 408 782 2335 or zipchem@addevmaterials.com.