

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

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

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

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

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

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

Have adequate lighting available to see where **Cor-Ban® 35 Undyed** is being applied and to inspect areas for contamination and rework prior to applying **Cor-Ban® 35 Undyed**.

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 Undyed** 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 Undyed Product Information

Cor-Ban® 35 Undyed is a high solids, low volatile, high penetration, water displacing, and long lasting non-decorative coating with a transparent yellow tint and offers a fast dry time and thin film with long lasting corrosion inhibiting properties and is free of chromates, heavy metals, and has low toxicity and VOC levels.

Cor-Ban® 35 Undyed dries quickly, is solvent removable, has a high solids percentage of >51%, provides **2000 hours** of salt spray protection, does not crack or flake to **-40°F (-40°C)**, and has a film that is non-tacky, thixotropic, and non-sagging.

Cor-Ban® 35 Undyed has a very low dry film weight of **< 1 mil (25 microns)** required to surpass specification.



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

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)

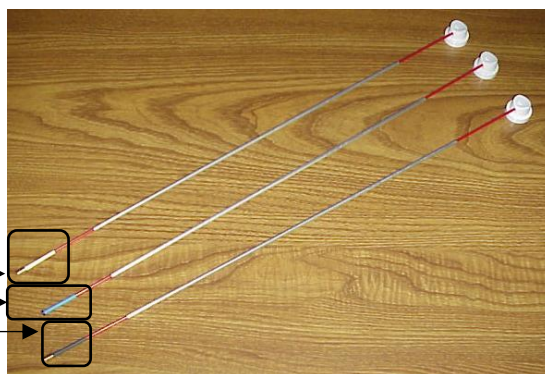


Methods For Applying Cor-Ban® 35 Undyed:

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

- * 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.
- * Bulk Application Equipment

HLVP Gun



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

Zip-Chem® Aerosol Trigger Sprayer



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

Formit® 360° Spray Demonstration Video



Formit® Fan Spray Demonstration Video



Formit® 180° Spray Demonstration Video

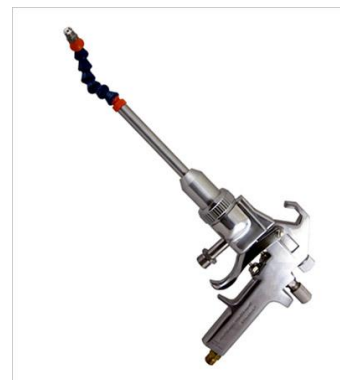


Please reach out to a **Zip-Chem®** application experts for tips on how to properly apply **Cor-Ban® 35 Undyed** for your unique application needs.

1.) HVLP Spray Gun Setup

- A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.
- B.) Set the **air pressure**. This is very important because **Cor-Ban® 35 Undyed** is applied **thin** so **too much pressure** will result in a **dry spray** and texture of **Cor-Ban® 35 Undyed** while **too little pressure** will result in a **poor atomization** and **orange peeling** of **Cor-Ban® 35 Undyed**.
- C.) If you see texture in the spray of **Cor-Ban® 35 Undyed**, then increase the **air pressure** of your **HVLP gun**. If you see an **overspray cloud** of **Cor-Ban® 35 Undyed**, then decrease the **air pressure** slightly. The proper spray pattern for **Cor-Ban® 35 Undyed** should be a **slightly wet pass** with **no flooding or sagging** because **thinly applied products** like **Cor-Ban® 35 Undyed** can run very fast.
- D.) One pattern that should be used when using the **HVLP gun** to apply **Cor-Ban® 35 Undyed** is the **fan pattern** because it uses a **full wide fan spray** which provides better consistency and leveling when applying **Cor-Ban® 35 Undyed** with the **HVLP spray guns**.
- E.) 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**.
- F.) Always set the pressure with the **trigger fully pulled** because the **pressure drops under flow**.
- G.) Close off the **air** and **fluid adjustment knobs**.
- H.) Slowly open the **air adjustment knob** with the **trigger** pulled.
- I.) Open the **fluid adjustment knob** slowly until you see a **fine mist** from the **air cap**.
- J.) Continue to fine tune the settings until the desired spray pattern is achieved.

HVLP Spray Gun



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

2.) Air Assisted Spray Gun Setup

Air Assisted Spray Gun

A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.

B.) For **pressure settings**, use the **lowest pressure** possible so that **Cor-Ban® 35 Undyed** can be spray applied as a **clean fan** with the width of the spray being shaped like a **fan**.

C.) Slowly increase the **pressure** to the gun until the **fan spray pattern** of **Cor-Ban® 35 Undyed** 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 Undyed**, 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 Undyed** 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 **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 Undyed** at a distance closer than **12"**, then there will be a heavy buildup of **Cor-Ban® 35 Undyed**, tiger stripping of material from the surface where the **Cor-Ban® 35 Undyed** was applied, and a variation in the gloss of the **Cor-Ban® 35 Undyed**.

G.) Consider the passing speed of **Cor-Ban® 35 Undyed** because the output of **Cor-Ban® 35 Undyed** 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**.



3.) Airless Spray Setup

Airless Spray Equipment

A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.

B.) For **pressure settings**, use the **lowest pressure** possible so that **Cor-Ban® 35 Undyed** 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** to the gun until the **fan spray pattern** of **Cor-Ban® 35 Undyed** 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 Undyed**, then the **pressure** of the **airless spray gun** is **too high**. None of these observations should occur because **thin materials** like **Cor-Ban® 35 Undyed** 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



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

Airless Spray Setup (Continued From Page 4)

- 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 Undyed** at a distance closer than **12"**, then there will be a heavy buildup of **Cor-Ban® 35 Undyed**, tiger stripping of material from the surface where the **Cor-Ban® 35 Undyed** was applied, and a variation in the gloss of the **Cor-Ban® 35 Undyed**.
- G.) Consider the passing speed of **Cor-Ban® 35 Undyed** because the output of **Cor-Ban® 35 Undyed** 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 Undyed** should be spray applied as a **smooth continual pass** with a **50% overlap**.

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

- A.) Determine the tip size for the gun. The recommended tip size for the gun should be **1.0 mm to 1.5 mm**.
- B.) For **pressure settings**, use the **lowest pressure** possible so that **Cor-Ban® 35 Undyed** 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** to the gun until the **fan spray** pattern of **Cor-Ban® 35 Undyed** 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 Undyed**, then the **pressure** of the **airless spray gun** is **too high**. None of these observations should occur because thin materials like **Cor-Ban® 35 Undyed** 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 Undyed** at a distance closer than **12"**, then there will be a heavy buildup of **Cor-Ban® 35 Undyed**, tiger stripping of material from the surface where the **Cor-Ban® 35 Undyed** was applied, and a variation in the gloss of the **Cor-Ban® 35 Undyed**.
- G.) Consider the passing speed of **Cor-Ban® 35 Undyed** because the output of **Cor-Ban® 35 Undyed** 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 Undyed** should be spray applied as a **smooth continual pass** with a **50% overlap**.

5 Gallon Cart Sprayer



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

5.) Electro-Static Spray Gun Setup

Electro-Static Spray Gun



- A.) Minimize the flow of **Cor-Ban® 35 Undyed** for the required **coating speed** and **film thickness**.
- B.) Minimizing the target distance of spraying **Cor-Ban® 35 Undyed**.
- C.) Ensure that the **Cor-Ban® 35 Undyed** 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 Undyed**.
- E.) Gradually increase in-line **air pressure** so that the spray provides proper **Cor-Ban® 35 Undyed** 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 Undyed**.

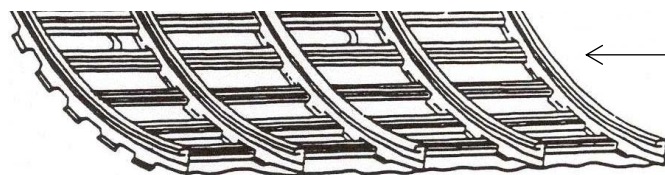
Areas Where Cor-Ban® 35 Undyed Should Be Applied:

Cor-Ban® 35 Undyed 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



Stinger

Tips For Applying Cor-Ban® 35 Undyed:

Focus the application process of **Cor-Ban® 35 Undyed** 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.

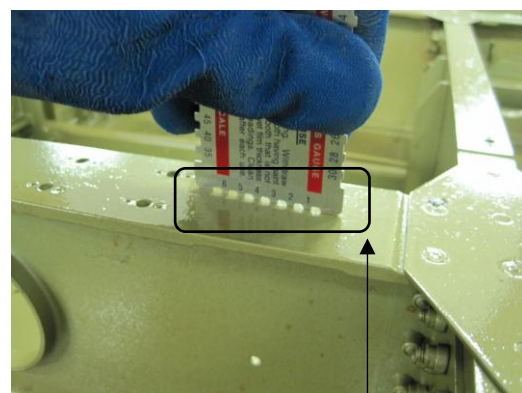


The applied **Cor-Ban® 35 Undyed** coating should be continuous and free of voids. Runs, drips, sags, etc, are allowed provided that the drain holes and cross drains for where **Cor-Ban® 35 Undyed** should drain out of are not blocked. If the drain holes or cross drains become blocked, then wipe up the excess **Cor-Ban® 35 Undyed** using clean, dry gauze, or rags.

The **Cor-Ban® 35 Undyed** 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 on the next page in the **instructions for removing Cor-Ban® 35 Undyed**.

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

The application thickness of **Cor-Ban® 35 Undyed** 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 Undyed**, 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 Undyed** material via hand after the **Cor-Ban® 35 Undyed** has been allowed to flow for a **few minutes**.



The thickness of the **Cor-Ban® 35 Undyed** 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 Undyed** may be verified using **paint thickness instruments**.

Tips For Drying Cor-Ban® 35 Undyed:

Cor-Ban® 35 Undyed 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 Undyed** 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 Undyed** should be applied at under the **Tips For Measuring The Thickness of Cor-Ban® 35 Undyed** section. The speed at which **Cor-Ban® 35 Undyed** dries and cures at is also influenced by **humidity and temperature**.

Methods For Removing Cor-Ban® 35 Undyed:

Cor-Ban® 35 Undyed can be removed with an aliphatic naphtha based wipe solvents or its equivalents. **Cor-Ban® 35 Undyed** can also be removed with corrosion preventive compound/corrosion inhibiting compound removers, such as **Sur-Prep® 3160**, **Sur-Prep® 3167**, **D-5640NS/ZC-640**, and **Zip-Strip™ 125M**.

Cured **Cor-Ban® 35 Undyed** can be removed with **Sur-Prep® 3160**, **Sur-Prep® 3167**, and **Zip-Strip™ 125M**



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Removing Cured Cor-Ban® 35 Undyed:

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

1.) Identify the area that needs the Cor-Ban® 35 Undyed 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.

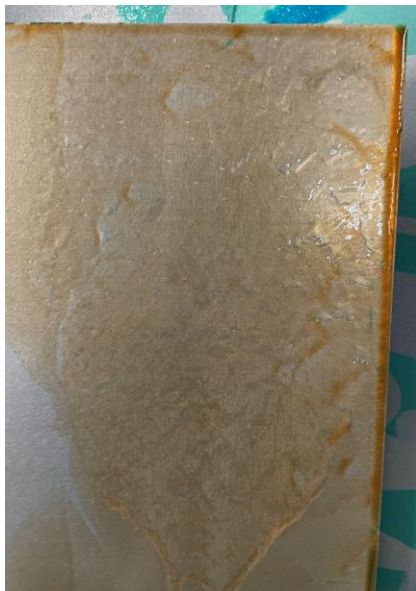


5.) Continue wiping until the area is clean

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

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

1.) Identify the area that needs the **Cor-Ban® 35 Undyed** 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 Undyed Product Pictures, Zip-Chem® Product Packaging Part Numbers, and Other Materials To Purchase:

Cor-Ban® 35 Undyed

- *Case of 12 of 16 fl oz (473 mL) Aerosols-**006710**
- *Case of 12 each Quart (946 mL)-**101482**
- *8 oz (227 gram) Brush In Cap-**101477**
- *Case of 12 each Gallon (4 each of 3.8 Liter) Cans-**009410**
- *5 Gallon (18.9 Liter) **Pail-006708**
- *55 Gallon (208 Liter) Drum-**006709**
- *Specialized forms of packaging available upon request

Zip-Strip™ 125M

- *Case of 12 of 16 fl oz (473 mL) Aerosols-**102614**
- *Case of 12 each Gallon (4 each of 3.8L) 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 12 each Gallon (4 each of 3.8L) 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**)

Masking Tape | Protective Clothing | Protective Eyewear

Aliphatic Naphtha Based Wipe Solvents or Equivalents

Curing Materials and Devices | Vacuum

Spill containment vessels and other proper devices for collecting material spills and overruns

Sur-Prep® 3160

- *Case of 12 of 16 fl oz (473 mL) Aerosols-**010938**
- *Case of 12 each Gallon (4 each of 3.8L) 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 12 each Gallon (4 each of 3.8L) 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**

Brushing Devices | Bulk Application Equipment | Paint Thickness Instruments

Tin Foil | Gloves | Spray Equipment | Ventilation Equipment

Proper Mask | Lighting and Inspecting Equipment | Cloth, Rag, Or Towel

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



← *16 Fluid Ounce (473 mL) Aerosol

← 8030-01-516-6254 (16 fl oz (473 mL) Aerosol (QPL))



← 1 Gallon (3.8 Liter) Can
NSN: 8030-01-615-4751 (QPL)

Additional Cor-Ban® 35 Undyed NSN's: 8030-01-531-7364 (5 Gallons (18.9 Liter) (QPL)), 8030-01-615-4749 (Undyed) (QPL)
8030-01-615-4738 (8 oz (227 gram) Brush In Cap QPL)



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

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, 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 Undyed**, contact **Zip-Chem® Aviation Products** at (1) 408 782 2335 or zipchem@addevmaterials.com.



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