

CHAMPION 636 FDA

DESCRIPTION

Polyurethane liner

PRINCIPAL CHARACTERISTICS

- Excellent flexibility
- Fast curing
- Excellent chemical resistance
- Compliant with US FDA 21 CFR 175.300 for food grade cargoes
- Low VOC, low HAPs

COLOR AND GLOSS LEVEL

- Light Blue, White
- Gloss

BASIC DATA AT 68°F (20°C)

Data for mixed product	
Number of components	Two
Volume solids	87 ± 2%
VOC (Supplied)	max. 0.9 lb/US gal (approx. 104 g/l)
Recommended dry film thickness	10.0 - 12.0 mils (250 - 300 µm) per coat
Theoretical spreading rate	1395 ft ² /US gal for 1.0 mils (140.0 m ² /l for 25 µm) 140 ft ² /US gal for 10.0 mils (3.4 m ² /l for 250 µm)
Dry to touch	4 hours
Dry to overcoat	6 hours
Dry to handle	8 hours
Overcoating Interval	See overcoating tables
Full cure after	7 days
Shelf life	Base: at least 24 months when stored cool and dry Hardener: at least 24 months when stored cool and dry

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURES

- Ambient temperature should be 50°F to 100°F (10°C to 38°C)
- Material temperature should be between 50 °F (10 °C) and 90 °F (32 °C)
- Surface temperature should be 50°F to 100°F (10°C to 38°C).
- The surface temperature must be at least 5°F (3°C) above dew point
- Relative humidity should not exceed 85%; surface must be free of visible moisture
- Area should be sheltered from airborne particulates and pollutants. Ensure good ventilation during application and curing. Provide shelter to prevent wind from affecting spray patterns.



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Steel

- Remove weld spatter, protrusions, and laminations in steel. Grind welds smooth in accordance with NACE RP-0178 Grade C or better. Remove all surface contaminants, oil and grease in accordance with SSPC-SP1. Abrasive blast with an angular abrasive to an SSPC-SP10 level of cleanliness or higher for immersion service. Achieve a surface profile of 2.5 - 4.5 mils. Use SSPC-SP11 for minor repairs in immersion service. Check with PPG technical service for the maximum allowable soluble salt level for water immersion service; this will vary based on the water chemistry and service temperatures.

Non-ferrous metals

- Lightly abrasive blast in accordance with SSPC SP-16 to achieve a uniform and dense 2.0 - 4.0 mil anchor profile

Stainless steel

- Abrasive blast with a hard, angular, non-metallic abrasive to achieve a uniform and dense anchor profile of 2.0 - 4.0 mils.

INSTRUCTIONS FOR USE

- MIX RATIO BY VOLUME: 3 parts base to 1 part hardener

Pot life

25 minutes at 70°F (21°C)

Note: See ADDITIONAL DATA – Pot life

Airless spray: Plural component

- Graco OEM X-Treme Mix capable of 3,000 psi with a mixer manifold. Pump ratio 56:1 (minimum). Tip size 0.015 - 0.019, 3/8" ID fluid hose. 60 mesh filter. Plural component pump must have in-line heaters, insulated hoses, and recirculation capabilities. This product must be sprayed with plural component. Touch ups can be done with small quantities sprayed airless.

Brush/roller

- Not recommended

Recommended thinner

PPG THINNER 21-06 (AMERCOAT 65) (normally not necessary)

Cleaning solvent

PPG THINNER 90-58 (AMERCOAT 12 CLEANER)



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ADDITIONAL DATA

Overcoating interval for DFT up to 10.0 mils (250 µm)				
Overcoating with...	Interval	50°F (10°C)	70°F (21°C)	90°F (32°C)
itself	Minimum	12 hours	6 hours	4 hours
	Maximum	48 hours	48 hours	48 hours

Note: Dry times are dependent on air and surface temperatures as well as film thickness, ventilation, and relative humidity. Maximum recoating time is highly dependent upon actual surface temperatures – not simply air temperatures. Surface temperatures should be monitored, especially with sun-exposed or otherwise heated surfaces. Higher surface temperatures shorten the maximum recoat window

Curing time for DFT up to 10.0 mils (250 µm)			
Substrate temperature	Dry to touch	Dry to handle	Full cure
50°F (10°C)	8 hours	16 hours	12 days
70°F (21°C)	4 hours	8 hours	7 days
90°F (32°C)	2 hours	4 hours	5 days

Note: Adequate ventilation must be maintained during application and curing

Pot life (at application viscosity)	
Mixed product temperature	Pot life
50°F (10°C)	40 minutes
70°F (21°C)	25 minutes
90°F (32°C)	20 minutes

SAFETY PRECAUTIONS

- For paint and recommended thinners see INFORMATION SHEETS 1430, 1431 and relevant Material Safety Data Sheets
- This is a solvent-borne paint and care should be taken to avoid inhalation of spray mist or vapor, as well as contact between the wet paint and exposed skin or eyes

WORLDWIDE AVAILABILITY

It is always the aim of PPG Protective and Marine Coatings to supply the same product on a worldwide basis. However, slight modification of the product is sometimes necessary to comply with local or national rules/circumstances. Under these circumstances an alternative product data sheet is used.



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REFERENCES

• CONVERSION TABLES	INFORMATION SHEET	1410
• EXPLANATION TO PRODUCT DATA SHEETS	INFORMATION SHEET	1411
• SAFETY INDICATIONS	INFORMATION SHEET	1430
• SAFETY IN CONFINED SPACES AND HEALTH SAFETY, EXPLOSION HAZARD – TOXIC HAZARD	INFORMATION SHEET	1431

WARRANTY

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Product code	Description
CM632-2	White Base
CM632-923	Blue Base
CM632-B	Hardener

Note: Available in 4-gallon kits.

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