

CORROCOAT

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DESCRIPTION:	A SOLVENT-FREE, TWO PACK EPOXY COATING WITH EXCELLENT EROSION RESISTANCE, TOUGHNESS AND OUTSTANDING ANTI-CORROSIVE PROPERTIES.
SUGGESTED USES:	Ideally suited for brush application to areas subjected to sea-water or other aqueous immersion. The coating also possesses good chemical resistance and when used at over 2mm thickness is cavitation resistant.
LIMITATIONS:	The material does not adequately cure below 5°C. It may be applied at such temperatures, but a measure of post curing at 15°C or above will be necessary to achieve optimum properties.
HEALTH & SAFETY:	Health and Safety information should be read and complied with, before handling this material. Avoid contact with skin or eyes. Do not ingest. Wear protective clothing and goggles. Ventilate confined spaces. The base and activator materials are not particularly hazardous and are safe to use provided good hygiene and working practices are observed.
SURFACE PREPARATION:	For optimum performance under immersed conditions the product should be applied to surfaces, grit blasted to SIS 055900 SA 2.5 Standard. For full details refer to Corrocoat Surface Preparation SP1 or SP2.
APPLICATION EQUIPMENT:	Brush.
MIXING RATIO:	100 pbw base to 36 pbw activator and where required adhesion promoter 2 pbw to mixed material.
MIXING PROCEDURE:	The material is supplied in kits consisting of the base component (large tin) together with an appropriate amount of activator. An additional component (Adhesion Promoter), can also be supplied. Mix the base and activator components thoroughly, until the material is homogenous in colour and consistency. Then immediately prior to application the Adhesion Promoter should be added and mixed well.
POT LIFE:	1 hour 45 mins at 15°C. 1 hour 14 mins at 20°C. 40 mins at 25°C.
APPLICATION:	Multiple coats should be applied, until a minimum DFT of 850 microns has been achieved. Runs and sags should be avoided and removed before over-coating
VOLUME SOLIDS:	98% (calculated).
THEORETICAL SPREADING RATE:	1.96m ² per litre at 500 microns.

PRACTICAL SPREADING RATE: 1.57m²/litre at 500 microns.
Note: This information is given in good faith but may vary dependent upon environment conditions, the geometry and nature of work undertaken and the skill and care of application. Corrocoat accept no responsibility for any deviation from this value.

MINIMUM OVER-COATING TIMES: As this product contains no solvent, minimum over-coating time is not important except in avoiding disruption and drag of the previous coating.

Short overcoating times as opposed to long overcoating times, are recommended for optimum intercoat adhesion properties. In order to check that surface drag is not likely to occur, a finger or thumb, can be used to pull the surface and where movement is observed, a longer period should be allowed before over-coating. As a guide, the minimum over-coating time will generally be as follows:

Temperature Time

12°C	12 hours
20°C	10 hours
30°C	8 hours

MAXIMUM OVERCOATING: It is essential, to achieve intercoat adhesion, the maximum over-coating time is strictly adhered to. The maximum over-coating times are as follows:

Temperature Time

12°C	72 hours
20°C	48 hours
30°C	24 hours

CURING TIMES: In order to achieve the full properties of this material, a period of 3 days at 20°C should be allowed before service. Where chemical or erosive forces are likely to be encountered a period of 7 days should be allowed. However, due to the cure action of this product, it can be put to light aqueous service as soon as the product has gelled. This should generally be in accordance with the minimum overcoating time. Product will then continue to cure in service.

TIME TO ACHIEVE FULL CURE: 7 days at 20°C
or 4 days at 30°C

Note: Cure below 10°C will be slow, exposure to higher temperatures (15°C-35°C): will improve the rapidity and degree of cure achieved. High humidity will extend cure times.

THINNERS: The product should not require thinning. The use of solvent thinners can lead to solvent entrapment in the film, which will adversely affect performance.

CLEAN-UP SOLVENT: A blend of xylene/n-Butanol at 4:1 v/v may be used. Alternatively, any proprietary epoxy clean-up solvent may be used.

All values given are approximate.

Reviewed 05th October 2001 – No changes