

TYPE:	A Two Component, High Build Glassflake Vinyl Ester Lining And Repair Material.
SUGGESTED USE:	This product is outstanding in its performance and can be used in many areas of application to build thick layers, it can also be moulded and machined. Corroglass 602 has the same field of application as Corroglass 202 but with a much improved resistance to many chemicals and solvents, offering in addition, increased temperature resistance. 600 series materials have greater resistance to hydrolysis, they are suitable for demineralised or distilled water applications.
LIMITATIONS:	Not suitable for some highly polar solvents.
CHEMICAL RESISTANCE:	Refer to the chemical resistance list. Affected by some highly polar solvents and some solutions having a high pH above 50°C.
HEALTH & SAFETY:	Before handling or using this product the material safety data sheet should be read and all precautions observed.
SURFACE PREPARATION:	Metals: Grit blast to ISO standard 8501-1 Sa 2½. SSPC-SP 10. (For full details refer to Corrocoat Surface Preparation SP1.) Concrete: refer to Corrocoat SP5. Coating of the substrate should then take place as soon as possible. Although 602 can be applied directly to the substrate, its wet out properties are poor and in order to reduce application time of the first coat, it is advisable to use Corroglass 632 as a primer under this material.
APPLICATION EQUIPMENT:	Brush, trowel or float.
APPLICATION:	Corroglass 602 should be applied to a properly prepared substrate and preferably over the top of 632, as the main build coat in the predominant 600 series specification:- (1 coat 632, 2 coats 602, 1 coat 652 to a total DFT of 1500 microns). 602 can be applied at varying thicknesses being capable of applied between 200 and 3000 microns without sag in a single film. Final thickness will vary to suit service environment. There is no maximum to the thickness of Corroglass 602 and voids/landings etc can be built up several centimetres thick. However, single coat applications should not normally exceed 8mm.

APPLICATION CONTINUED:

After applying this material to the substrate and ensuring the film is of even thickness, the surface should be lightly brushed or trowelled with Styrene Monomer, catalysed with P2 at the 2% level, to close any voids and assist with orientation of the flake structure. However, care must be taken to avoid the excessive use of Styrene which may degrade the surface layer or cause problems with intercoat adhesion. Where it is necessary to use dye, only the recommended dye for the product should be used and dye must be used sparingly so that only sufficient is used to give good distinction from the previous application. Dyes can affect chemical and corrosion resistance in some environments and the advice of Corrocoat UK should be sought where the material will work close to either its chemical resistance or temperature limit. In some environments dyes are not colour stable and a change in colour may take place in service which is rarely detrimental to coating performance.

MIXING RATIO:

Corroglass 602 can be catalysed within the ratios of 100:1 PARTS BASE TO CATALYST BY WEIGHT to 100:2 PARTS BASE TO CATALYST BY WEIGHT. The ratio should always be within these limits, 2% addition of catalyst being the norm with a reduction being made for high ambient temperatures.

MIXING:

Weigh out only the proportion of material which can be used within the pot life and place into a suitable mixing container. Measure the correct proportion of catalyst for the amount of base and carefully add this to the base, using a suitable clean implement. Mix thoroughly then add dye where necessary and mix to an even colour. After stirring it is advisable to remove the contents from the mixing container on to a clean flat surface or shallow receptacle and remix.

POT LIFE:

40 to 50 minutes at 20°C. Pot life will be shorter at higher temperatures and longer at lower temperatures. Where high temperatures are encountered, refrigerate material before use or seek the advice of Corrocoat UK for availability of inhibitor or material with longer pot life.

THINNERS:

Corroglass 602 is adversely affected by the addition of **solvents** and their use is prohibited. Where a less viscous material is required the addition of 632 will lower the viscosity without significant effect on performance. **No other diluents or thinner should be used.** The use of acetone or similar thinners in Corroglass **will severely affect** product performance.

PACKAGING:	20 Litre composites.
STORAGE LIFE:	Base and catalyst (Hardener) 6 months, stored at temperatures below 20°C, away from heat sources and out of direct sunlight. Frequent temperature cycling will shorten storage life. See 'other information' in the Corrocoat 'Tech Manual' for extension of shelf life.
COLOUR AVAILABILITY:	Unpigmented (Translucent Brown) or Pigmented White. Dyes can be used to effect colour change where chemical resistance is not of paramount importance.
RECOMMENDED DFT:	1.0 to 3.0mm in two coats. Or as advised, may be built up to any desired thickness for repair.
THEORETICAL SPREADING RATE:	1.25kg per square metre at 1mm thickness.
VOLUME SOLIDS:	99.8% solvent free.
PRACTICAL SPREADING RATE:	Regular surfaces e.g. new steel - 1.8kg per m ² at 1mm thickness minimum. Irregular surfaces e.g. badly pitted steel - 2.8 kg per m ² at 1mm. Note: This information is given in good faith but may increase 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 these values.
SPECIFIC GRAVITY:	Apparent 1.03 gms/cc. Actual 1.19 gms/cc.
FLASH POINT:	38°C
CATALYST TYPE:	Methyl Ethyl Ketone Peroxide: Corrocoat Type P2.
MIXING RATIO:	100:1 to 100:2 base to catalyst.
HARDNESS:	Circa 45 Barcol.
TENSILE STRENGTH:	27.5 N/mm ² (3994 psi)
COHESIVE STRENGTH:	26.6 N/mm ² (3860 psi)
ELONGATION:	0.7%
THERMAL COEFFICIENT OF LINEAR EXPANSION:	19.5 x 10 ⁻⁶ /°C
MOISTURE VAPOUR TRANSMISSION RATE:	0.939 x 10 ⁻² gms/hr/m ² (0.0006 perm inches)

THERMAL CONDUCTIVITY:	0.398 W/m ² K
DIELECTRIC STRENGTH:	Approximately 26 kV at 1mm film. Arc resistance 60 seconds minimum.
TEMPERATURE LIMITS:	Dependant upon environment 110°C immersed. 200°C non-immersed. No known lower limit.
OVERCOATING:	May take place as soon as previous coat has gelled sufficiently to resist movement of next application and whilst still tacky. Maximum overcoating without treatment 2 days. Shorter at ambient temperatures above 30°C and in strong sunlight. Once the maximum overcoating time has been reached, the adhesion values attained by any subsequent coat will reduce dramatically. It is important to observe maximum overcoating times and note these will vary with climatic conditions. Any further application of coating at this juncture should be treated as a repair, with the surface flashed over to provide a physical key. Styrene cannot be used to reactivate the surface and may in some cases impair adhesion.
CLEANING FLUID:	Acetone or Methyl Ethyl Ketone before gel.
MACHINING:	For best surface finish use pure carbide or carbide tips with small radius and neutral rake. Material has similar machining characteristics to those of grey cast iron. Tool must be kept sharp. Run out will occur due to tool wear over relatively short distances, especially when facing from OD to centre. Clean water may be used as lubricant or dust damper.
CURE TIME:	At 20°C, 90% cure will be attained within 8 hours. Full cure for chemical resistance will be 6 days. Cure time may be shortened and a beneficial increase in final cure may be attained by post heat treatment. Consult Corrocoat UK for specific information. Although not cured, after gel this material may be immersed in some environments without detriment to the coating.

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

Reviewed 10/2007