

Product reference: 3/66

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Product title: CorrothaneXT Veilcoat

Valid from: 22nd December 2004

Last reviewed: May 2019

Type

A three-pack cold cured vinyl ester/urethane IPN (Interpenetrating Polymer Network).

Suggested use

As a topcoat for Corrothane XT products in aggressive service environments which may affect glass or where a smooth surface veil is required.

Limitations

This product is extremely moisture sensitive and may foam if mixed or applied at relative humidities above 75% or in moisture condensing conditions. Tins are nitrogen filled, **do not open before use**. It is strongly recommended that de-humidification equipment is used during the application of this product.

Health & safety

Before handling or using this product it is important that the material safety data sheet is read and all precautions observed. Attention is drawn to Hardener B which contains Isocyanates.

Surface preparation

XT Veilcoat is applied over Corrothane XT while still tacky or before the maximum over coating period has expired.

Application equipment

45:1 or greater airless spray pump, with an output of at least 1 gallon (4 litres) per minute. Spray tip and fan pattern can vary and should be selected to suit the nature of the work. XT Veilcoat can be applied by brush or roller in areas of limited access but not generally recommended.

Application

Due to the hygroscopic nature of this product, the Base and Hardener B should be kept sealed until required. It is recommended that kit sizes are ordered to allow complete use of the product during each application to prevent moisture absorption when using part tins.

Dependent upon end use and application conditions, Corrothane XT is normally applied in wet film thickness of between 8-15 mils (200-375 microns).

Mixing ratios

By Weight:

87.83 parts Base

01.57 parts Hardener A (organic peroxide)

10.60 parts Hardener B (Isocyanate)

Mixing instructions

Mix the base with a mechanical stirrer until it is uniformly mixed. Add Hardener A (organic peroxide) to the Base and mix thoroughly, allow to stand for 10 minutes. Thoroughly stir the Base/peroxide blend again and leave to stand for a further 5 minutes (NB. The Base/peroxide blend is relatively stable and will not react significantly until the Hardener B is added). Add Hardener B (Isocyanate) and mix thoroughly before applying.

Pot life

Variable dependent upon temperature. 40-60 Minutes at 68°F (20°C) Refer to Corrocoat technical services for instructions regarding application in hot climatic conditions.

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Thinners

The performance of Corrothane XT **will be adversely affected** by the addition of solvent thinners and their use is **prohibited**.

Packaging

1 Gallon and 5 Gallon kits

Storage life

6 Months unopened stored at temperatures below 68°F (20°C) and away from heat sources and direct sunlight. Frequent temperature cycling will shorten storage life.

Color availability

Unpigmented (translucent amber/brown) only. Other colors are not available and it should be noted that the addition of dyes will adversely affect chemical resistance.

Recommended DFT

Between 8-12 mils (200-350 microns), as required.

Theoretical spreading rate

136 sf per gal at 12 mils (3.33m²/litre at 300 microns).

Volume solids

This material contains volatile liquid convertible to solids. Volume solids obtained will vary dependent upon polymerisation conditions. Nominally 99% of the contents are convertible to solid.

Practical spreading rate

82 sf per gal at 12 mils (2.0m²/litre at 300 microns).

NOTE: This information is given in good faith but may vary dependent upon environmental conditions, the geometry and nature of work undertaken and the skill and care of application. Corrocoat accepts no responsibility for any deviation from these values.

Flash point

88°F (31°C).

Temperature limits

302°F (150°C) Immersed. No known lower limit. 500°F (260°C) Non immersed.

Variable dependent upon environment.

Overcoating

May take place as soon as the previous coat has gelled and while still tacky. Maximum overcoating time is 48 hours at 68°F (20°C). XT Veilcoat is normally applied in a single application but may be over coated where required.

Curing time

Cure before service is 4 days at 68°F (20°C). For optimum results a short post cure for 4 hours at 140-176°F (60-80°C) is recommended. This is not necessary for many environments.

Cleaning fluid

Methyl Ethyl Ketone, Methyl Iso Butyl Ketone and Acetone - before gelation. **These fluids are flammable. Observe Safety Regulations.**

THIS PRODUCT IS STILL UNDER DEVELOPMENT TO IMPROVE CHARACTERISTICS IN CONSEQUENCE THE DATA IS UNDER CONSTANT REVIEW AND ASPECTS OF IT MAY CHANGE.

Revised 02/2010 Revised 07/2012
Reviewed 02/2014 (No changes)
Reviewed 11/2015 (No changes)