T: (904) 268-4000 E: info-usa@corrocoat.com

CORROCOAT Corrothane XT Filler

Product reference: 3/44

Product title: Corrothane XT Filler

Valid from: 25th October 2007

Last reviewed: 31 May 2019

Type

A three-pack cold cured vinyl ester - urethane copolymer filler.

Suggested use

As a heavy-duty filler, where good chemical and high temperature resistance are required, either for immersed or non-immersed service.

Limitations

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

Health & safety

Before handling or using this product the material safety data sheet should be read and all precautions observed. Particular attention is drawn to Hardener B which contains Isocyanate.

Surface preparation

Use over the top of a pre-primed surface. For further information, refer to Corrocoat Technical Services.

Application equipment

Brush or trowel or scraper.

Application

Using a suitable implement, work the product into the pre-primed area. Ensure the area is thoroughly wetted out. Apply further coats to the required film thickness.

Corrothane XT Filler may be applied to pits and small areas up to 6mm dft in one coat. It is not recommended that large areas are applied in excess of 3mm in one coat.

Mixing ratios

88.02 parts Base
01.30 parts Hardener A (organic peroxide)
10.68 parts Hardener B (Isocyanate)
(All ratios by weight)

Mixing instructions

Product should be at ambient temperature before mixing. Mix the base with a good mechanical stirrer until it is uniformly mixed. Add Hardener A (organic peroxide) to the Base and mix thoroughly. Allow mix to stand for a minimum period of 10 minutes. (NB. The Base peroxide blend is relatively stable and will not react significantly until Hardener B is added). Add Hardener B (Isocyanate) and mix thoroughly immediately before applying.

Pot life

Generally 50 - 70 minutes at 68°F (20°C). Pot life **will vary substantially** with temperature. Refer to Corrocoat technical services for instructions regarding application in hot climatic conditions.

Thinners

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

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Packaging

1 and 5 gallon kits. Due to hydroscopic nature of this product the use of part tins is not recommended, suitable kit sizes should be purchased to meet usage requirements.

Storage life

6 Months stored and away from heat sources and direct sunlight and **below 68ºF (20°C).** Frequent temperature cycling will shorten storage life and affect pot life.

Beyond 6 months this product becomes increasingly susceptible to moisture uptake and foaming and **out of shelf-life material must not be used**. (Discoloration of Hardener B will occur with time. This has no detrimental effect on the product). All components must be used within their designated shelf life.

Color availability

Off white only.

Recommended DFT

Between 20 mils (500 microns) and 6mm dependent upon requirements.

Theoretical spreading rate

32 sf per gal at 40 mils (1.21 kg/m²/litre at 1mm) dft.

Volume solids

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

Density

0.03lbs/cubic inch (1.072 g/cm^3).

Flash point

88°F (31°C).

Temperature limits

302°F (150ºC) Immersed. No known lower limit. 500°F (260ºC) Non-Immersed (provisional figures)

NOTE: These temperatures are maximums and are variable dependent upon environment.

Overcoating

It is recommended that over coating takes place within 12 hours. Although longer over coating times may be acceptable this will depend upon climatic conditions and the level of ultraviolet light which significantly accelerates speed of cure.

Curing Time

Full cure is 4 days at 68°F (20°C). For optimum results a short post cure of 4 to 6 hours at circa 176°F (80˚C) is recommended. However, post cure is not necessary for many environments.

Cleaning fluid

Methyl Ethyl Ketone, Methyl Iso Butyl Ketone - before gelation.

Reviewed 08//2011
Reviewed 05/2019

All values are approximate. Physical data is based on the product being in good condition before polymerization, correctly catalyzed and full cure being attained. Unless otherwise stated, physical data is based on a test temperature of 68°F (20°C), test results may vary with temperature. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.