

CORROCOAT

Corrocoat EC

Product reference: 3/17

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Product title: Corrocoat EC

Valid from: 18th December 2007

Last reviewed: May 2019

Type

A solvent-free, two pack epoxy coating for use with E series materials as a veil coat or on its own for cavitation resistance.

Suggested use

Corrocoat EC is the surface veil coating for use with Corrocoat EB and Corrocoat EA. The coating possesses good chemical resistance and when applied to a thickness over 1.5mm good cavitation resistance.

Limitations

This material should not be applied at temperatures below 41°F (5°C). Thixotropic properties are such that multiple coats will be required to achieve thicknesses over 300mm. Keep overcoating times short.

Health & safety

Health and Safety information should be read and observed 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 followed.

Surface preparation

For optimum performance under immersed conditions this product should be applied to surfaces, grit blasted to SPCC-SP10 (ISO 8501-1 SA 2½) or equivalent. For full details refer to Corrocoat Surface Preparation SP1 or SP2.

Application equipment

Brush or air assisted spray gun and pressure pot.

Application

Apply at approximately 12 mils (300 microns) DFT over the E series material, or in multiple coats to achieve the required thickness.

Mixing ratio

2 parts base by weight / 1 part hardener.

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 color and consistency. Then immediately prior to application the Adhesion Promoter should be added and mixed well.

Pot life

180 mins at 68°F (20°C).
1 hour 14 mins at 68°F (20°C)
40 mins at 77°F (25°C).

VOC level

4.54g per litre.

Theoretical spreading rate

80 sf per gal at 20 mils (1.95m² per litre at 500 microns).

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Minimum overcoating times

As this product contains no solvent, minimum overcoating 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 overcoating. As a guide only, the minimum overcoating times will generally be as follows:

Temperature	Time
54°F (12°C)	12 hours
68°F (20°C)	10 hours
86°F (30°C)	8 hours

Maximum overcoating

It is essential, to achieve intercoat adhesion, the maximum overcoating time is strictly adhered to. The maximum overcoating times are as follows:

Temperature	Time
54°F (12°C)	72 hours
68°F (20°C)	48 hours
86°F (30°C)	24 hours

Curing times

In order to achieve the full properties of this material a period of 3 days at 68°F (20°C), in ventilated conditions, 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, the coating 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 68°F (20°C) or 4 days at 86°F (30°C)

NOTE: Cure below 50°F (10°C) will be slow, exposure to higher temperatures 59-95°F (15-35°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.

Reviewed 12/2007 (No changes)
Revised 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.