

CORROCOAT

Corrothane XT

Product reference: 3/26

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Product title: Corrothane XT

Valid from: 6th February 2008

Last reviewed: May 2019

Type

A three-pack cold cured vinyl ester - urethane polymer alloy with glassflake.

Suggested use

For coating both steel and concrete surfaces, 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

Metals: Grit blast to SSPC SP 10 (SIS 05 5900 Sa 2½) standard and **vacuum clean**. Refer to Corrocoat Data Sheet SP1.

For other substrates and further information, refer to Corrocoat Technical Services.

Application equipment

Airless spray pump 45:1 ratio minimum and capacity of at least 1 gallon (4 litres) per minute. The pump should be fitted with leather seals and all fluid filters removed. Use a 10mm diameter (3/8") internal bore spray line with a short 6mm (1/4") whip end. A large bore contractor type spray gun fitted with a swivel connector and 29-40 thou

reversible spray tip is recommended. The spray tip size and fan pattern should be selected to suit the nature of the work. Product may be applied by brush for small areas or stripe coating. Trowelling is possible.

Application

Dependent upon end use and application conditions, Corrothane XT is normally applied in wet films of 40-52 mils (1000-1300 microns). Where conditions allow it is preferable to apply the product in a single coat application. Where multi-coats are required it is essential that overcoating times are kept as short as is possible.

Mixing ratios

89.62 parts Base
01.09 parts Hardener A (organic peroxide)
09.29 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. Thoroughly stir the Base/peroxide mix again and leave to stand for a further 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 before applying.

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

Packaging

10 Liter Kits. Due to the hygroscopic 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 75°F (24°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**. (All components must be used within their designated shelf life). *Please note that smaller pack sizes have often shown susceptibility for shorter practical shelf life.

Color availability

Off white or unpigmented (translucent brown) only. Other colors are not available and it should be noted that the addition of dyes will adversely affect performance and in particular chemical resistance.

Recommended DFT

Between 16 mils (400 microns) and 3mm dependent upon environment, see application recommendations above.

Theoretical spreading rate

54 sf per gal at 30 mils (1.33m²/litre at 750 microns).

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.

Practical spreading rate

44 sf per gal at 30 mils (1.1 m²/litre at 750 microns).

NOTE: This information is given in good faith but consumption may increase dependent upon environment 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

300°F (150°C) Immersed. No known lower limit. 500°F (260°C) Non-Immersed

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

Overcoating

It is recommended that overcoating takes place as soon as possible and within 12 hours. Although longer overcoating times may be acceptable this will depend upon climatic conditions and ultra violet light levels that affect speed of cure.

Cure time

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

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Spark testing

This product is subject to dielectric fatigue and repeated testing should be avoided, refer to data sheet 7/30

Cleaning fluid

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

**THESE PRODUCTS ARE A FIRE HAZARD.
OBSERVE SAFETY REGULATIONS.**

Reviewed 07/2011
Reviewed 02/2014 (No changes)
Reviewed 11/2015 (No changes)
Reviewed 10/2017 (No changes)
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.