

TYPE:	A two-pack cold cured vinyl ester Laminating Resin.
SUGGESTED USE:	Use in conjunction with multi-directional roving to construct glass reinforced laminate and repair severely corroded and pitted areas or to offer additional protection in the corners of tankage prior to spray application. See Corrocoat Data Sheets TC1.
LIMITATIONS:	Not suitable as a protective coating without glass reinforcement and at films less than 3mm. It is suggested that where this product is used for lamination protection systems a top layer of Polyglass VE at 500 microns is applied to reduce permeation.
HEALTH & SAFETY:	Before handling this product the material Health & Safety Data Sheet for 600 Series should be consulted and all precautions observed. Only to be applied by competent, adequately trained personnel.
SURFACE PREPARATION:	Metal Surfaces: Grit blast to SIS 05 5900 SA 2.5 near 3 standard. For full details refer to Corrocoat Data Sheet SP1. The laminate will typically be applied over a primed surface.
APPLICATION EQUIPMENT:	Brush or roller.
MIX RATIO:	98:2 Base: Hardener
POT LIFE:	Variable with temperature. At 20°C approximately 20-30 minutes.
THINNERS:	The performance of 600 Laminating Resin may be adversely affected by the addition of solvent thinners (e.g. Xylene) and their use is prohibited. Should thinning be necessary use only styrene monomer to an absolute maximum of 5% by volume concentration.
PACKAGING:	20 Litre and 5 Litre pails.
STORAGE LIFE:	6 Months stored at temperatures below 24°C and away from direct light and sources of heat.
COLOUR:	Translucent brown.
RECOMMENDED DFT:	Dependent upon application and quantity of roving used.
VOLUME SOLIDS:	99.5%
PRACTICAL SPREADING RATE:	Dependent on roving used.

SPECIFIC GRAVITY:	600 Laminating base 1.065 gms/cc
CATALYST TYPE:	Methyl ethyl ketone peroxide, Corrocoat Catalyst P2.
OVERCOATING:	May take place as soon as the previous coat has gelled and whilst still tacky. Maximum overcoating time 72 hours. Please note: Maximum levels refer to ambient temperature of approximately 20°C. At higher temperatures the maximum overcoating time will reduce significantly. 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.
CURE TIME:	Full cure will be obtained in 4-6 days.
CLEANING SOLVENT:	Acetone, Methyl Ethyl Ketone and Methyl Iso Butyl Ketone prior to gelation.

PHYSICAL PROPERTIES:

Property	Unreinforced Castings	Glass Mat Reinforced Laminates
Tensile Strength	73 MPa	111 MPa
Tensile Modulus	3.5 MPa	10100 MPa
Tensile Elongation	4%	1.3%
Flexural Modulus	3.8 MPa	9800 MPa
Flexural Strength	133 MPa	205 MPa
Average Coefficient of Linear Expansion	$53 \times 10^{-6} \text{ } ^\circ\text{C}^{-1}$	

Note: (1) All test results shown at 20°C/

Results will vary depending upon temperature, degree of cure, percentage of glass and quality of workmanship.

All values are approximate. 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 – No Changes
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