

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 SIS 05 5900 SA2.5 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 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 0.7-1.0mm (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. Troweling is possible.
APPLICATION:	Dependant upon end use and application conditions, Corrothane XT is normally applied in wet films of 1000 to 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.
POT LIFE:	Generally 50-70 minutes at 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 Litre composite kits. 20,5, and 1 litre kits are available on request. Due to the 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:	4 Months stored and away from heat sources and direct sunlight and below 20° C . Frequent temperature cycling will shorten storage life and affect pot life. Beyond 4 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).
COLOUR AVAILABILITY:	Off white or unpigmented (translucent brown) only. Other colours 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 400 microns and 3mm dependent upon environment, see application recommendations above.
THEORETICAL SPREADING RATE:	1.33m ² /litre at 750 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:	1.1 m ² /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 accept no responsibility for any deviation from these values.
FLASH POINT:	31°C
TEMPERATURE LIMITS:	150°C Immersed. No known lower limit. 260°C Non Immersed Note: These temperatures are maximums and are variable dependant 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.
CURING TIME:	Full cure is 4 days at 20°C. For optimum results a post cure of 4 hours minimum at circa 80°C is recommended. However, post cure is not necessary for many environments.
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.

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

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