

Product reference: 3/34

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Product title: Corrofill

Valid from: 30th December 1999

Last reviewed: May 2019

### Type

A two-pack organic peroxide catalysed bisphenol 'A' polyester filler or grout.

### Suggested use

As a filler for badly pitted steel in applications which require a high performance, chemically resistant coating system.

### Limitations

Not suitable for immersion in some highly polar solvents, de-mineralised water or extremes of pH values. 90deg C immersed 120deg C atmospheric.

### Health & safety

Before handling or using this product, the material safety data sheets relating to 200 series product and organic peroxides, should be read and all precautions observed.

### Surface preparation

The surface to be coated should be free from grease etc. Metal should be grit blasted to a minimum ISO 8501-1 Sa 2½ or equivalent with a grit profile of at least 50 microns, 100-125 microns being the ideal key. All blast residues should be removed by sweeping clean, blowing and vacuuming where necessary. Coating of the substrate should take place as soon as possible. For full surface preparation details see relevant surface preparation specification sheets. This product should preferably be applied over Polyglass PPA primer or the first coat of other Corroglass/ Polyglass series materials. It may, however, be used on its own but surfaces should be blast cleaned to ISO 8505-1 Sa 2½ in accordance with Corrocoat data sheet SP1.

### Application equipment

Short hair stiff brush, trowel or scraper blade.

### Mixing ratios

Corrofill can be catalysed within the ratios of 100:1 PBW base to catalyst to 100:2 PBW base to catalyst. The ratio should always be within these limits, 2% addition of catalyst being the norm, 1% being used at ambient temperatures above 28deg C or film thickness above 5mm.

### Catalyst type

Use catalyst P2; below 10°C for optimum results use catalyst P4.

### Mixing

Weigh out only the proportion of material, which can be used within the pot life and place into a mixing container. Measure the correct proportion of catalyst for the base amount and carefully add this to the base using a suitable clean implement. Mix thoroughly then add dye if required and mix to an even colour. After stirring it is best to remove the contents from the mixing container into a shallow receptacle and remix.

### Pot life

50-60 Minutes at 20°C. Pot life will be shorter at higher temperatures and longer at lower temperatures. Where high temperatures are encountered, refrigerate material before use or else seek the advice of Corrocoat UK.

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### Application

Using application tool, the catalysed material should be vigorously worked into the surface profile, ensuring that the maximum possible wet out of the surface area is achieved. Following this procedure, the coating thickness can be built up to the required thickness. The material may be applied at DFT's of up to 8mm but this thickness generally should not be exceeded in a single layer. Material may be applied up to 20mm when used as a grouting compound at and below 20°C.

### Thinners

**DO NOT THIN. NO DILUENT OR THINNER MAY BE USED.** The addition of Styrene may adversely affect the performance of this product do not add without consulting Corrocoat UK.

### Packaging

10 or 20 litre drums.

### Storage life

12 Months maximum, when stored at temperatures below 20°C and away from radiating heat sources or direct sunlight.

### Colour

Dark grey.

### Theoretical spreading rate

1.25 kg/m<sup>2</sup> @ 1mm DFT.

### Volume solids

99.8%. This product contains volatile monomer convertible to solid. Actual solids obtained will vary dependent upon cure conditions.

### Practical spreading rate

Regular surfaces, e.g. new steel - 1.9kg/m<sup>2</sup> @ 1mm DFT.  
Irregular surfaces, e.g. pitted steel - 3kg/m<sup>2</sup> @ 1mm DFT.

**NOTE:** This information is given in good faith but 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.

### Specific gravity

1.23 gcm<sup>-3</sup>

### Flash point

32°C.

### Shrinkage ratio

Approximately 6.5% dependent upon speed of cure.

### Hardness

Minimum 40 Barcol (ASTM) Standard D-2583.

### Overcoating

May take place as soon as the previous coat has gelled sufficiently to resist movement of next application and whilst still tacky. Maximum overcoating without treatment is 4 days @ 20°C (shorter at ambient temperatures above 30°C).

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### Cure time

In ventilated conditions at 20°C, 90% cure will be attained in 8 hours. Full cure for chemical resistance will require 6 days @ 20°C. Cure times will be shortened, and the degree of final cure improved by post curing at elevated temperatures.

Reviewed 10/2001 (No changes)  
Reviewed 02/2014 (No changes)  
Reviewed 05/2016 (No changes)  
Reviewed 05/2019

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Unless otherwise stated, physical data is based on a test temperature of 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.