

PRODUCT INFORMATION

COROFLAKE 68 PRIMER

PRODUCT DESCRIPTION

COROFLAKE 68 PRIMER is a moisture compatible, low viscosity, two-component primer based on a high-quality epoxy resin which provides exceptional resistance to rust and undercutting. It protects abrasive blasted steel surfaces from rust formation until subsequent protective coating or lining layers are applied. When applied to concrete the primer will effectively seal and strengthen prepared surfaces to improve the adhesion of subsequent coating and lining systems. **COROFLAKE 68 PRIMER** cures at ambient temperatures of +3°C.

FIELDS OF APPLICATION

COROFLAKE 68 PRIMER is used as a primer on properly prepared steel or concrete surfaces for coatings based on epoxy resins. In addition **COROFLAKE 68 PRIMER** can also be used as sealing of concrete surfaces.

FEATURES

- Outstanding adhesion to steel and concrete
- No fillers
- Easy processing
- Application by spraying, brushing or rolling

CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

SUBSTRATE

Substrates are components made of steel, concrete, screed or plaster. Components to be coated shall be designed and manufactured in accordance with EN 14879-1. For components made of concrete, screed or plaster DIN 1045 must also be observed.

SURFACE PRE-TREATMENT

C-STEEL

Surfaces to be coated must be clean, dry and free of contaminants. All contaminants, including non-visible detectable contaminants, must be removed in accordance with DIN TR 55684 and EN ISO 8502.

Non-alloyed steel surfaces shall be abrasive blasted to "Near White Metal" in accordance with EN ISO 12944-4. A surface preparation degree of SA 2½ (SSPC-SP 10; NACE No. 2) as specified in EN ISO 8501-1 and a "medium (G)" roughness degree as specified in EN ISO 8503-2 must be achieved. A minimum surface profile of $R_z \geq 70 \mu\text{m}$ is required.

To prevent flash rust, the primer must be applied immediately after the blasting and cleaning of the substrate or the component must be air conditioned to a relative humidity of $\leq 40\%$.

CONCRETE

Appropriate action shall be taken to prepare the concrete surfaces; dry and free of dust and free of contaminants such as oil or grease. The concrete shall have minimum tensile strength of 1.5 N/mm² and minimum compressive strength of 25 N/mm². The residual moisture content must not exceed 4%.

ENVIRONMENTAL CONDITIONS

Throughout the coating process, the temperatures of the substrate and coating materials shall be maintained within the range specified by TIP TOP. All surfaces shall be maintained at a temperature at least 3K above the dew point in order to prevent condensation.

APPLICATION

During the application of the product, the application instruction must always be observed.

COROFLAKE 68 PRIMER is applied to the substrate using an airless air spray system or by rolling or brushing. The primer must be applied to cover. Subsequent coatings can be applied after hardening of the primer according to the table "Recoat Time".

Note: During primer application, the lined surface should be shaded from direct or indirect sunlight whenever possible.

MIXING RATIO

The primer and coating components are supplied in pre-measured units so that weighing or measuring of the components is kept to a minimum. After the unit has been mixed it shall be used within the specified pot life.

Primer	Parts by Weight	Parts by Volume
COROFLAKE 68 PRIMER	100	100
HARDENER No. 4	30	33.7

CONSUMPTION

Product	Thickness [µm]	Coverage [g/m ²]
COROFLAKE 68 PRIMER	covering	ca. 300 (concrete)
COROFLAKE 68 PRIMER	covering	ca. 150 (steel)
COROFLAKE 68 PRIMER (as sealing)	covering	ca. 2 x 300

The information about coverage is an average for spray applications. Actual coverage depends on the object geometry and the method of application. It can vary.

POT LIFE / WORKING TIME [min]

Product	15°C	20°C	30°C
COROFLAKE 68 PRIMER	ca. 120	ca. 60	ca. 30

RECOAT TIME (20°C)

Product	Min. [h]	Max. [Days]
COROFLAKE 68 PRIMER	ca. 12	ca. 7

CLEANING

Clean all equipment with **SOLVENT T-200** immediately after use. Frequency of cleaning will depend upon amount applied, temperature and elapsed time, including any delays.

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SAFETY MEASURES

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
COROFLAKE 68 PRIMER	12 kg	590 0851
HARDENER No. 4	3.6 kg	590 0875
SOLVENT T-200	4 kg	590 0610
SOLVENT T-200	8 kg	590 0611

STORAGE

The products must be stored in a cool and dry place, away from direct sunlight. At the specified storage temperatures a shelf life of the products is given of at least for the following periods:

Product	Temperature	Shelf Life
COROFLAKE 68 PRIMER	5 - 25°C	12 Months
HARDENER No. 4	5 - 25°C	12 Months
SOLVENT T-200	5 - 25°C	60 Months

If the storage time is exceeded, the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof. In addition, the DIN 7716 must be observed.

Technical Data	Standard	Unit	Value
Density (Mixture)	EN ISO 2811 (ASTM D1475)	g/cm ³	1.14 ± 0.01
Min. Adhesion Strength Concrete	EN ISO 4624 (ASTM D7234)	N/mm ²	1.5*
Min. Adhesion Strength Steel	EN ISO 4624 (ASTM D4541)	N/mm ²	≥ 10
Viscosity	EN ISO 2555 (ASTM D2196)	mPa·s	325 ± 50
Max. Operating Temperature	-	°C	Depends on the subsequent coating system

* Depending on the concrete strength

Information given in the fact sheet above corresponds to the current knowledge available to us regarding our products at the time of its drafting and is intended as a guideline for informational purposes. However, because of the multiple possibilities regarding possible applications, processing and on site conditions, any information given in the fact sheet above is not legally binding, in particular, without being limited to, such information shall not be interpreted as a warranty of merchantability or of fitness for a particular purpose. Customer therefore is advised to conduct its own testing or make an inquiry with our technical department before ordering. We reserve the right to change the product at any time, in particular, without being limited to, minor changes because of advancements in technology. If by way of exception, the information given in the fact sheet above is incorporated by reference into any contract concluded with us under German Law, such information, shall only be interpreted as determining the specific requirements of the contractual products as set out in § 434 BGB (German Civil Code) and shall not be interpreted as constituting a guarantee of condition.

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TIP TOP Oberflächenschutz Elbe GmbH	COROFLAKE 68 PRIMER	Revision 1.03 - 11.03.2021
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