

PRODUCT INFORMATION

COROFLAKE T PRIMER

PRODUCT DESCRIPTION

COROFLAKE T PRIMER is a low viscosity, two-component primer based on a high temperature resistant Novolac vinyl ester resin which provides exceptional resistance to rust and undercutting. **COROFLAKE T PRIMER** protects abrasive blasted steel surfaces from rust formation until subsequent protective coating or lining layers are applied.

FIELDS OF APPLICATION

COROFLAKE T PRIMER is used as a primer on properly prepared steel surfaces for **COROFLAKE 29**.

FEATURES

- Outstanding adhesion to steel
- Excellent dry temperature stability
- Easy to apply
- Application by spraying, brushing or rolling

CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

SUBSTRATE

Substrates are steel components. Components to be coated shall be designed and manufactured in accordance with EN 14879-1.

SURFACE PRE-TREATMENT

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 $\leq 40\%$.

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 T 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 T PRIMER | 100 | 100 |
| HARDENER No. 1 CLEAR | 2 | 2.1 |

CONSUMPTION

| Product | Thickness [μm] | Coverage [g/m^2] |
|---------------------------|-----------------------------|------------------------------------|
| COROFLAKE T PRIMER | covering | ca. 150 |

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 T PRIMER | ca. 60 | ca. 50 | ca. 30 |

RECOAT TIME (20°C)

| Product | Min. [h] | Max. [Days] |
|---------------------------|----------|-------------|
| COROFLAKE T PRIMER | ca. 4 | ca. 3 |

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.

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.

COROFLAKE T PRIMER

PACKING UNITS

The products are supplied in the following standard package sizes:

| Product | Size | Article No. |
|----------------------|--------|-------------|
| COROFLAKE T PRIMER | 5 kg | 590 3035 |
| COROFLAKE T PRIMER | 20 kg | 590 3033 |
| HARDENER No. 1 CLEAR | 0.1 kg | 590 0181 |
| HARDENER No. 1 CLEAR | 0.4 kg | 590 0019 |
| 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 T PRIMER | 5 - 20°C | 4 Months |
| HARDENER No. 1 CLEAR | 5 - 20°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 | 1.06 |
| Min. Adhesion Strength Steel | EN ISO 4624 (ASTM D4541) | N/mm ² | 7 |
| Viscosity | EN ISO 2555 (ASTM D2196) | mPa·s | 350 ± 50 |
| Max. Operating Temperature | - | °C | Depends on the subsequent coating system |

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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