

## PRODUCT INFORMATION

### COROFLAKE 300

#### PRODUCT DESCRIPTION

**COROFLAKE 300** is a solvent-free two-component, filled polymer coating based on a chemical and thermal resistant Novolac epoxy resin.

#### COATING LAYERS CONSUMPTION

The coating system consists of at least three coats of the two-component **COROFLAKE 300** topcoats applied at approx. 400 - 600 µm DFT per coat. For storage tanks for concentrated sulphuric acid a DFT of  $\geq 1.5$  mm is required.

#### FIELDS OF APPLICATION

**COROFLAKE 300** is mainly used for the protection of storage vessels and steel structures against concentrated sulphuric acid up to +40°C.

#### FEATURES

- Easy Processing
- Solvent free
- Excellent chemical resistance against concentrated sulphuric acid up to +40°C
- Outstanding adhesion to steel
- Application by spraying

#### 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  $R_z \geq 70$  µm 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.

Each **COROFLAKE 300** topcoat is applied to the substrate using an airless air spray system.

**Note:** During application, the lined surface should be shaded from direct or indirect sunlight whenever possible. In atmospheric exposure coatings based on epoxy resins have the tendency to chalking with time. Under the load of concentrated sulphuric acid a colour change can occur. Therefore, the colour Terra should always be used for the last layer.

#### MIXING RATIO

The 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.

Coating	Parts by Weight	Parts by Volume
<b>COROFLAKE 300 COMP. A</b>	100	100
<b>COROFLAKE 300 COMP. B</b>	40	43.5

#### CONSUMPTION PER COAT

Product	Thickness [µm]	Coverage [g/m²]
<b>COROFLAKE 300</b>	ca. 400 - 600	ca. 500 - 750

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
<b>COROFLAKE 300</b>	ca. 50	ca. 35	ca. 20

#### RECOAT TIME (20°C)

Product	Min. [h]	Max. [Days]
<b>COROFLAKE 300</b>	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.

#### 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 300

### PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
COROFLAKE 300 COMP. A - BEIGE	18 kg	590 2320
COROFLAKE 300 COMP. A - TERRA	18 kg	590 2300
COROFLAKE 300 COMP. B	7.2 kg	590 2340
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 300 COMP. A	5 - 25°C	12 Months
COROFLAKE 300 COMP. B	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
Hardness Shore D	DIN EN ISO 48-4 (ASTM D2240)	-	82
Min. Adhesion Strength Steel	EN ISO 4624 (ASTM D4541)	N/mm <sup>2</sup>	7
Test Voltage (earliest after 24 hours)	EN 14879-2	kV / 100µm DFT	0.5
Max. Operating Temperature Liquids	-	°C	+60
Max. Operating Temperature Dry (Flue Gas)	-	°C	+95

**Note:** The indicated temperatures are dependent on the present load and may vary

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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