

PRODUCT INFORMATION

COROPUR TF 21

PRODUCT DESCRIPTION

COROPUR TF 21 is an extremely fast curing polyurethane coating in combination with iron mica.

COATING LAYERS CONSUMPTION

The coating system consists of the primer **COROPUR ZINC M** and several **COROPUR TF 21** top coats. The recommended DFT is about 80 - 500 µm per coat. For medium heavy corrosion protection, **COROPUR TF 21** can be applied without primer.

FIELDS OF APPLICATION

COROPUR TF 21 is used mainly as topcoat on primed surfaces or as a single coating without primer for moderate corrosion protection. Typical applications are coatings of pressure pipelines, biogas plants, flood gates, sewage treatment plants, hydraulic steel structures and objects under water.

FEATURES

- Good chemical resistance
- Fast curing
- Can be used in industrial and marine climate
- Suitable for over and under water objects
- High abrasion resistance

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

Environmental Conditions	Value
Relative Humidity	30% - 95%
Surface Temperature	-5°C (ice free) up to +30°C

Attention at low temperatures: The material dries less quickly - the more careful the processing must be!

APPLICATION

The primer **COROPUR ZINC M** and each **COROPUR TF 21** are applied to the substrate using an airless air spray system or by rolling or brushing. When brushing, a paint grid must be used in order to achieve a uniform wet film thickness. Once activated, **COROPUR TF 21** has the tendency to a very quick skin formation. This can be avoided by applying a thin layer of thinner onto the surface or to cover the container with a solvent soaked cloth.

SETTINGS AIRLESS SPRAYING

Pressure [bar]	Nozzle [mm]	Thinning [%]
150 - 200	0.42 - 0.53	0 - 5

MIXING RATIO

Coating	Parts by Weight
COROPUR TF 21	10
ACTIVATOR A-1786	1

CONSUMPTION

Product	Thickness [µm]	Coverage [g/m²]
COROPUR ZINC M	ca. 60 - 150	ca. 540 (60 µm)
COROPUR TF 21	ca. 100	ca. 680

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.

CURING TIME (20°C)

Load Capacity	Time
Dust dry	ca. 15 min
Touch dry	ca. 35 min
Loadable	ca. 2.5 h

CLEANING

Clean all equipment with **COROPUR ROLLTHINNER A-851** or **COROPUR SPRAYTHINNER T-1900** 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.

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PACKING UNITS

The products are supplied in the following standard package sizes:

Product	Size	Article No.
COROPUR TF 21 - RAL 7035 + ACTIVATOR A-1786	9,9 kg	580 0880
COROPUR TF 21 - RAL 8012 + ACTIVATOR A-1786	9,9 kg	580 0870
COROPUR ROLLTHINNER A-851	0.80 kg	580 0315
COROPUR ROLLTHINNER A-851	4 kg	580 0322
COROPUR ROLLTHINNER A-851	9 kg	580 0339
COROPUR SPRAYTHINNER T-1900	0.80 kg	580 0353
COROPUR SPRAYTHINNER T-1900	4 kg	580 0360
COROPUR SPRAYTHINNER T-1900	9 kg	580 0377
COROPUR ZINC M	2.50 kg	580 0016
COROPUR ZINC M	12 kg	580 0023
COROPUR ZINC M	20 kg	580 0030

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
COROPUR ROLLTHINNER A-851	5 - 25°C	24 Months
COROPUR SPRAYTHINNER T-1900	5 - 25°C	24 Months
COROPUR TF 21	5 - 20°C	6 Months
COROPUR ZINC M	5 - 20°C	12 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	Unit	Value
Density	g/cm ³	2.10 ± 0.1
Solids by Weight / Volume	%	84 ± 1 / 71 ± 1
Max. Operating Temperature Dry	°C	+50

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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