

TYPE:	A hand applied, three-pack cold cured, vinyl ester - urethane polymer alloy, glass flake coating.
SUGGESTED USE:	For coating both steel and concrete surfaces, where good chemical and high temperature resistance are required, either for immersed or non-immersed service.
LIMITATIONS	This product is very moisture sensitive and may foam if mixed or applied in moisture condensing conditions, or at relative humidities above 75%. Tins are nitrogen filled, do not open before use . It is recommended that where possible de-humidification equipment is used during the application of this product.
HEALTH & SAFETY:	Before handling or using this product the material safety data sheet should be read and all precautions observed. Particular attention is drawn to Hardener B which contains Isocyanate.
SURFACE PREPARATION:	Metals: Grit blast to SIS 05 5900 SA2.5 standard and vacuum clean , refer to Corrocoat Data Sheet SP1. For other substrates and further information, refer to Corrocoat Technical Services.
APPLICATION EQUIPMENT:	May be applied by brush, trowel or roller.
APPLICATION:	Dependent upon intended use and site conditions, but Corrothane XT/HA is normally applied in wet films between 300 and 600 microns.
MIXING RATIOS: (All ratios by weight)	88.43 parts Base 01.31 parts Hardener A (organic peroxide) 10.26 parts Hardener B (Isocyanate)
MIXING INSTRUCTIONS:	Product should be at ambient temperature before mixing. Mix the base with a good mechanical stirrer until it is uniformly mixed. Add Hardener A (organic peroxide) to the Base and mix thoroughly. Allow mix to stand for a minimum period of 10 minutes. Thoroughly stir the Base/peroxide mix again and leave to stand for a further minimum period of 10 minutes (NB. The Base/peroxide blend is relatively stable and will not react significantly until Hardener B is added). Add Hardener B (Isocyanate) and mix thoroughly before applying.
POT LIFE:	Generally 50-70 minutes at 20°C. Pot life will vary substantially with temperature. Refer to Corrocoat technical services for instructions regarding application in hot climatic conditions.
THINNERS:	The performance of Corrothane XT/HA can be adversely affected by the addition of solvent thinners and their use is prohibited
PACKAGING:	Standard is 10 litres but 1, 5, and 20 Litre composites are available. Due to the moisture sensitive nature of this material, it is not advisable that kits are divided on site.

STORAGE LIFE:	4 Months stored and away from heat sources and direct sunlight and below 20°C . Frequent temperature cycling will shorten storage life and affect pot life. Beyond 4 months this product becomes increasingly susceptible to moisture uptake and foaming and out of shelf-life material must not be used . (Discolouration of Hardener B will occur with time, this has no detrimental effect on the product. All components must be used within their designated shelf life).
COLOUR AVAILABILITY:	Unpigmented (translucent brown) and off white only. Other colours are not available and it should be noted that the addition of dyes will adversely affect performance and in particular chemical resistance.
RECOMMENDED DFT:	Between 500 microns and 3mm dependent upon environment.
THEORETICAL SPREADING RATE:	1.33m ² /litre at 750 microns.
VOLUME SOLIDS:	This material contains volatile liquid convertible to solids. Volume solids obtained will vary dependent upon polymerisation conditions. Nominally 99% of the contents are convertible to solid.
PRACTICAL SPREADING RATE:	1.06m ² /litre at 750 microns. Note: This information is given in good faith but consumption 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.
FLASH POINT:	31°C
TEMPERATURE LIMITS:	150°C Immersed. No known lower limit. 250°C Non-immersed (provisional figures) Note: These temperatures are maximums and are variable dependent upon environment.
OVERCOATING:	It is recommended that over coating takes place within a maximum of 12 hours at 20°C. Although longer over coating times may be acceptable this will depend upon climatic conditions and the level of ultraviolet light that can significantly accelerate speed of cure.
CURING TIME:	Full cure circa 4 days at 20°C. For best results a short post cure of 4 to 6 hours at 80°C is recommended. However, post cure is not necessary for many environments.
SPARK TESTING:	This product is subject to dielectric fatigue and repeated testing should be avoided, refer to data sheet 7/30.
CLEANING FLUID:	Acetone, Methyl Ethyl Ketone, Methyl Iso Butyl Ketone - before gelation.

These materials are flammable. Observe safety regulations.

Note. All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

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Corrocoat Limited, Forster Street, Leeds LS10 1PW. Tel: (0113) 276 0760. Fax: (0113) 2760700

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