

DESCRIPTION:	A SOLVENT-FREE, TWO PACK EPOXY COATING FOR USE WITH E SERIES MATERIALS AS A VEIL COAT OR ON ITS OWN FOR CAVITATION RESISTANCE.
SUGGESTED USES:	Corrocoat EC is the surface veil coating for use with Corrocoat EB and Corrocoat EA. The coating possesses good chemical resistance and when applied to a thickness over 1.5mm good cavitation resistance.
LIMITATIONS:	This material should not be applied at temperatures below 5deg C. Thixotropic properties are such that multiple coats will be required to achieve thicknesses over 300mm. Keep over-coating times short.
HEALTH & SAFETY:	Health and Safety information should be read and observed before handling this material. Avoid contact with skin or eyes. Do not ingest. Wear protective clothing and goggles. Ventilate confined spaces. The base and activator materials are not particularly hazardous and are safe to use provided good hygiene and working practices are followed.
SURFACE PREPARATION:	For optimum performance under immersed conditions this product should be applied to surfaces, grit blasted to SIS 055900 SA 2.5 Standard or applied over EA/EB. For full details refer to Corrocoat Surface Preparation SP1 or SP2.
APPLICATION EQUIPMENT:	Brush. Or Air assisted spray gun and pressure pot.
MIXING RATIO:	2 parts hardener / 1 part base by weight.
MIXING PROCEDURE:	The material is supplied in kits consisting of the base component (large tin) together with an appropriate amount of activator. An additional component (Adhesion Promoter); can also be supplied. Mix the base and activator components thoroughly, until the material is homogenous in colour and consistency. Then immediately prior to application the Adhesion Promoter should be added and mixed well.
POT LIFE:	180 mins at 20°C. 1 hour 14 mins at 20°C. 40 mins at 25°C.
APPLICATION:	Apply at approximately 300 microns DFT over the E series material, or in multiple coats to achieve the required thickness.
VOC LEVEL:	4.54g per litre.
THEORETICAL SPREADING RATE:	1.95m ² per litre at 500 microns.

MINIMUM OVER-COATING TIME:

As this product contains no solvent, minimum over-coating time is not important except in avoiding disruption and drag of the previous coating.

Short overcoating times as opposed to long overcoating times, are recommended for optimum intercoat adhesion properties. In order to check that surface drag is not likely to occur, a finger or thumb can be used, to pull the surface and where movement is observed, a longer period should be allowed before overcoating. As a guide only, the minimum overcoating times will generally be as follows:

<u>Temperature</u>	<u>Time</u>
12°C	12 hours
20°C	10 hours
30°C	8 hours

MAXIMUM OVERCOATING:

It is essential, to achieve intercoat adhesion that the maximum overcoat times are strictly adhered to. These maximum overcoating times are as follows:

<u>Temperature</u>	<u>Time</u>
12°C	72 hours
20°C	48 hours
30°C	24 hours

CURING TIMES:

In order to achieve the full properties of this material a period of 3 days at 20°C in ventilated conditions, should be allowed before service. Where chemical or erosive forces are likely to be encountered a period of 7 days should be allowed. However, due to the cure action of this product, the coating can be put to light aqueous service as soon as the product has gelled. This should generally be in accordance with the minimum overcoating time. Product will then continue to cure in service.

TIME TO ACHIEVE FULL CURE: 7 days at 20°C

or 4 days at 30°C

Note: Cure below 10°C will be slow, exposure to higher temperatures (15°C-35°C); will improve the rapidity and degree of cure achieved. High humidity will extend cure times.

THINNERS:

The product should not require thinning. The use of solvent thinners can lead to solvent entrapment in the film, which will adversely affect performance of the coating.

CLEAN-UP SOLVENT:

A blend of xylene/n-Butanol at 4:1 v/v may be used. Alternatively, any proprietary epoxy clean-up solvent may be used.

All values are approximate. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

Reviewed 12/2007