

## CORROLESS 'S'

### RUST STABILISING PRIMER (SINGLE PACK)

#### DESCRIPTION

A general purpose, single pack, rust stabilising primer.

#### PRODUCT FEATURES AND RECOMMENDED USES

- Over 30 years track record in corrosion control.
- Excellent wetting properties.
- Designed to penetrate firmly adherent rust.
- Will withstand operating temperatures up to 200°C.
- Ideal for general maintenance.
- Applications include pipes, cranes, mechanical equipment, bridges, railings, tank externals and other structural steel.
- Contains Corroless Pigment.

#### TECHNICAL DATA

##### Volume Solids (±2%)

44%.

##### Specific Gravity

1.26 kg/litre.

##### Film Thickness

**Wet Film** 80 microns. **Dry Film** 35 microns. (Always apply two coats).

##### Theoretical Coverage

12.6 m<sup>2</sup>/litre at 35 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.

##### Application

Airless spray, brush or roller.

##### Mixing Ratio

Single pack.

##### Pot Life (at 18°C)

Not applicable.

##### Drying Times at recommended dft

|                        | 10°C    | 18°C    | 30°C    |
|------------------------|---------|---------|---------|
| <b>Dust Free</b>       | 4 hours | 2 hours | 1 hour  |
| <b>Hard Dry</b>        | 6 hours | 4 hours | 2 hours |
| <b>Overcoating Min</b> | 6 hours | 4 hours | 2 hours |
| <b>Max</b>             | 9 days  | 7 days  | 3 days  |

##### Thinners and Cleaning solvent

Corroless Thinners No 2. (Solvent Gun Wash may be used for cleaning only).

##### Finish

Low Gloss.

##### Colours

S1 – Red/brown S2 - Buff.

##### Storage

Product has a shelf life of 2 years when stored in dry, cool conditions and protected from frost.

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### APPLICATION DETAILS

#### Surface Preparation

If required, due to obvious dirt/grease contamination or suspected salt or chemical contamination, clean all surfaces with a water soluble degreaser, wash down with clean, fresh water and allow to dry, before commencing main preparation.

**Recommended substrate:** Steel. (Corroless 'S' can also be applied to other substrates – further advice available on request).

**Manual preparation:** Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of EN ISO 8501-1:2007 or equivalent. Ensure all scale is removed. Wash down with clean fresh water prior to application. Allow to dry.

**Mechanical Preparation:** Blast clean to minimum Sa1 standard of EN ISO 8501-1:2007 or equivalent, with a surface profile of 50 to 75 microns. Wash down with clean fresh water prior to application. Allow to dry.

**New steel:** All mill scale must be removed prior to application.

All surfaces when coated should be firm, clean, dry and free from all oil, grease, powdery flash rusting and other contamination.

#### Application

| Method                | Airless Spray | Conventional Spray      | Brush | Roller |
|-----------------------|---------------|-------------------------|-------|--------|
| Output Fluid Pressure | 2400 psi      | Yes – thinning required | Yes   | Yes    |
| Tip size              | 11-13 thou    |                         |       |        |
| Fan angle             | 30-50°        |                         |       |        |

#### Spraying

For conventional spray up to 10% Corroless Thinners No.2 should be added.

#### Brushing/Rolling

When brushing, apply unthinned, lay on, do not over brush. When rolling, use a lambs wool roller and a maximum addition of 5% Corroless Thinners No.2.

#### Mixing

Stir thoroughly before use.

#### Stripe coating

Stripe coat all edges, nuts, bolts, welds etc.

#### Application Temperature

Range 2°C - 35°C.

#### Ambient Conditions

Only apply in conditions of good ventilation, which should be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.

#### Overcoating

Overcoatable with itself, Corroless SHB and Corroless RF16. If overcoat time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water rinse and allow to dry before continuing. If maximum overcoating times are exceeded, abrade the surface to provide a key, wash down with clean fresh water and allow to dry.

#### Flash Point

32°C - 55°C.

#### Volatile Organic Content (g/litre)

**S1** - 310      **S2**- 411

#### Health and Safety

At all times observe precautionary notices on containers. Refer to Material Safety Data Sheets available from Corroless on request.