

CORROLESS EPF (Temperate Grade) RUST STABILISING PRIMER

DESCRIPTION

A two pack epoxy, rust stabilising primer, formulated using a tar-free resin system, with Corroless pigment and self-leaving glass flake.

PRODUCT FEATURES AND RECOMMENDED USES

- High build, solvent-less product with excellent abrasion resistance.
- Moisture tolerant - can be applied to damp surfaces.
- Approved as a primer for Corroless RF35 (2006) for use in contact with potable water (BS 6920:2000).
- Approved with Corroless RF35 White, for lining bulk fuel tanks (DEF-STAN 80/97 and MIL-PRF-4556F).
- NATO stock Number 0442-8010-25-150-0972.
- Approved for use by Network Rail (Approved systems list available on request)
- Applications include structural steel, sheet piling, tank linings, jetties, bridges and ballast tanks as well as concrete and other selected substrates.

TECHNICAL DATA

Volume Solids (±2%)

96%.

VOC Content

Black: 41 ± 10 g/litre **Buff:** 34 ± 10 g/litre

Specific Gravity

1.53 kg/litre (mixed material).

Film Thickness

Wet Film 208 microns. **Dry Film** 200 microns.

Mixing Ratio

1:1 by volume (base to hardener).

Theoretical Coverage

4.80 m²/litre at 200 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.

Pot Life (at 18°C)

60 minutes.

Drying Times at recommended dft

	10°C	18°C	30°C
Dust Free	8 hours	6 hours	4 hours
Hard Dry	24 hours	16 hours	12 hours
Overcoating Minimum	24 hours	16 hours	12 hours
Maximum	4 days **	3 days **	2 days

** note for solvent based products 7 days is acceptable but for solvent free products the maximums listed apply.

Thinners and Cleaning Solvent

Corroless Thinners No.6. (Note - thinning is not allowed when lining potable water tanks). Solvent Gun Wash may be used for cleaning only.

Finish

Semi Gloss (will chalk on exterior exposure).

Colours

Black (LEPFTN1) or Buff (LEPFTN2). (Note - Corroless EPF base is red brown, with the hardeners being black and off-white respectively, giving mixed colours of black (base plus black hardener) and buff (base plus off-white hardener)).

Flash Point

Greater than 55°C (mixed material).

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 EPF can also be applied to Concrete and 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	3500-4000 psi	No	Yes	Yes
Tip size	17-21 thou			
Fan Angle	50°			

Airless Spray:

For detailed information on airless spraying contact the Corroless Technical department.

Brushing/Rolling

When brushing, apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller followed by laying off with a brush, (For non-potable situations a maximum addition of 5% Corroless Thinners No.6 is allowed but thinning is not allowed for potable water projects).

Mixing

Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.

Application Temperature

Range 2°C - 30°C. (Curing will be retarded below 10°C – product will cure down to 2°C but cure will be slow).

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 90% and the steel temperature should remain at least 3°C above the dew point.

Stripe Coating

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

Overcoating

Overcoatable with Corroless EPF, Corroless RF31, RF35, RF61 and RF65. If overcoating 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 and wash down with fresh water to remove contamination and allow to dry.

Health and Safety

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