

CORROLESS 'M'

MULTI-METAL PRIMER

DESCRIPTION A general purpose, rust stabilising primer for use on weathered galvanising, steel and other metals.

PRODUCT FEATURES AND RECOMMENDED USES

- Single pack.
- Use as a patch or overall primer on rusted areas of galvanising or steelwork.
- Enables the use of one primer for a variety of substrates.
- No etch primer or barrier coat required on galvanising.
- Excellent adhesion and flexibility.
- Applications include street furniture, piping, mechanical equipment, railings, tank externals and other structural steel.
- Contains Corroless Pigment.

TECHNICAL DATA

Volume Solids (±2%)	34%.
Volatile Organic Content	512 g/litre
Specific Gravity	1.35 kg/litre.
Film Thickness	Wet Film 147 microns. Dry Film 50 microns. (Two coats recommended for best results over rusty steel).
Theoretical Coverage	6.8 m ² /litre at 50 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.
Application	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
Dust Free	2 hours	1 hour	½ hour
Hard Dry	24 hours	16 hours	12 hours
Overcoating Min	24 hours	16 hours	12 hours
Max	Indefinite*	Indefinite*	Indefinite*

Thinners and Cleaning solvent

Corroless Thinners No 3. (Solvent Gun Wash may be used for cleaning only).

Finish

Matt.

Colours

Red/brown.

Storage

Product has a shelf life of 2 years when stored in dry, cool conditions and protect 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: Weathered and partly corroded galvanising and zinc coated metal, weathered aluminium, steel.

Manual preparation: Prepare bare steel areas 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. All corrosion products and zinc salts must be removed, ideally by abrading or scrubbing followed by fresh water washing. Any areas of bright, smooth galvanising or other metal surface should be abraded to provide a key. Wash down with clean fresh water prior to application. Allow to dry.

Mechanical Preparation: Sweep blast to remove loose material, scale and salts and prepare bare steel areas to a minimum Sa1 standard of EN ISO 8501-1:2007 or equivalent, with a surface profile of 75 microns maximum. Wash down with clean fresh water prior to application. Allow to dry.

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

Application

Method	Airless Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2000 psi	Yes – thinning required	Yes	Yes
Tip size	17-19 thou			
Fan angle	30-50°			

Spraying

For conventional spray up to 10% Corroless Thinners No.3 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.3.

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 and recommended topcoat Corroless G3. May also be overcoated with Corroless RF16, when both M and topcoat thicknesses should not exceed 50 microns dft. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water rinse and allow to dry before continuing. *While overcoating time is indefinite, overcoating within 3 to 7 days at 18°C is recommended for best results.

Flash Point

Between 21°C - 32°C. **Volatile Organic Content** 512 g/litre

Health and Safety

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

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