# CORROLESS SHB

## RUST STABILISING PRIMER

### DESCRIPTION

A single component, high build, general purpose rust stabilising primer.

### PRODUCT FEATURES AND RECOMMENDED USES

- High build.
- Designed to penetrate firmly adherent rust.
- Ideal for general maintenance.
- NATO Stock Number 0474-8030-99-535-3044.
- Applications include pipes, cranes, mechanical equipment, bridges, railings, tank externals and other structural steel.
- Contains Corroless Pigment.

### TECHNICAL DATA

**Volume Solids (±2%)** 49%.

**Volatile Organic Content** 351 g/litre

**Specific Gravity** 1.27 kg/litre.

**Film Thickness** **Wet Film** 184 microns. **Dry Film** 90 microns.

**Theoretical Coverage** 5.44 m²/litre at 90 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 18ºC)** Not applicable.

**Drying Times**
**at recommended dft**

| | 10ºC | 18ºC | 30ºC |
|---|---|---|---|
| **Dust Free** | 4 hours | 2 hours | 1 hour |
| **Hard Dry** | 24 hours | 16 hours | 12 hours |
| **Overcoating Minimum** | 24 hours | 16 hours | 12 hours |
| **Maximum** | 60 hours | 48 hours | 24 hours |

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

**Finish** Low Gloss.

**Colours** 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 SHB 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 | 2800 psi | Yes – thinning required | Yes | Yes |
| Tip size | 17-21 thou | | | |
| Fan angle | 30-50º | | | |

**Spraying**

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

**Brushing/Rollering**

When brushing apply unthinned, lay on, do not over brush. When rollering 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 2ºC - 35ºC.

**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 3ºC above the dew point.

**Overcoating**

Overcoatable with itself, and Corroless RF16. 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 to provide a key, wash down with clean fresh water and allow to dry.

**Flash Point**

21ºC - 32ºC.

**Health and Safety**

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