

A764

Corroless E - Rust Stabilising Primer (D96)

Corroless E is a two component epoxy rust stabilising primer providing the ultimate in priming protection.

PRODUCT BENEFITS

- Excellent adhesion characteristics
- Good chemical resistance
- Good working life
- Nato Stock Number: 0442-8030-99-021-4716
- Applications include piping, cranes, mechanical equipment, bridges, railings, tank externals, aluminium hulls, and other structural steel.

SURFACE PREPARATION

Recommended substrate: Steel

Manual preparation

Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc to St3 as per the Swedish International Standard SIS055900 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 as per the Swedish International Standard SIS055900 (SSPC SP-7) or equivalent. High pressure water jetting may also be utilised. Wash down with clean fresh water prior to application. Allow to dry.

New steel:

All mill scale must be removed prior to application.

Maximum surface profile: 75 microns (3 mils).

Grit type: Silica free sand or expendable grit (copper slag).

PROPERTIES

Colour Availability	E1 = Red Brown E2 = Buff
Finish	Low gloss
Mix Ratio	4:1 Base to Hardener (by volume)
Working life (hours) at 18°C	6 hours
Drying times (at 18°C)	Touch Dry: 4 hours Hard Dry: 16 hours
Overcoating	Minimum: 16 hours Maximum: 7 days
Wet film thickness microns (μ)	90
Dry film thickness microns (μ)	50
% Volume Solids	54% (mixed)
Theoretical coverage rate	10.8m ² /litre. Practical rates can vary depending on application method, temperature, profile of substrate etc.

Flash point (mixed material)	Below 21°C mixed
Storage life	12 months when stored in original sealed containers between 10°C - 20°C

APPLICATION RECOMMENDATIONS

Min. Application Temperature	8°C (maximum 40°C)
Max. Relative Humidity	85%
Substrate Temperature	3°C above dew point
Thinning	Brush application: Apply unthinned, lay on, do not over brush Roller application: Lambswool roller. Max. 10% Thinners No. 4
Airless Spray Application	Apply unthinned Tip size 0.017" - 0.021" Fan angle 30° - 50° Nozzle pressure: 2800 psi
Cleaning Solvent	Thinners No. 4
Pack Sizes	1 litre and 4 litre packs

NOTES

Mix thoroughly before use using a power mixer (drill + paddle attachment) for two to three minutes at a medium speed until an even colour is obtained.

Best results are obtained by pre-stirring base and hardener separately prior to mixing.

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

Overcoatable with Corroless RF35, RF60, RF60S and RF15.

If overcoating time exceeds 24 hours, cleaning prior to recoating using a detergent solution/clean water rinse is recommended. To overcoat after 7 days, abrade the surface to provide a key and wash down with clean fresh water to remove contamination.

HEALTH AND SAFETY

Irritant	Avoid contact with skin and eyes. Avoid breathing vapour or sanding dust. When using this product it is recommended that full overalls, gloves, face mask and goggles be worn. Store container in a safe place when not in use. Do not burn container.
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FIRST AID

EYES	Flush with water for at least 15 minutes and seek medical advice.
SKIN	Wash contact areas with soap and water. Remove all contaminated clothing, and seek medical advice. Do not scrub.
INHALATION	Remove patient from further exposure, and keep patient warm and comfortable.
INGESTION	Do not induce vomiting. Rinse mouth with water. Seek medical advice as soon as possible.

USE ONLY WITH ADEQUATE VENTILATION
KEEP OUT OF REACH OF CHILDREN

TRANSPORTATION AND DISPOSAL

Class	3
Hazchem Code	•3YE; •3Y
UN No	1263
Packing Group No	II
Fire Extinguishing Media	CO ² , Foam, Dry Chemical
Fire Fighting Procedure	Fire fighters should wear self contained breathing apparatus. Fight fire from a protected location as product may explode on heating. The vapours are heavier than air, so may travel along the ground to accumulate in low areas. Fire may flash back along vapour trail, and can also react with oxidising agents. Spills should be cleaned up immediately by using sand or other non-flammable absorbent materials. Ensure material does not enter waterways. Dispose of empty containers in accordance with local by laws.

OTHER INFORMATION

This product may be used for a wide variety of surfaces. If the surface you propose to paint is not referred to, contact Protective Paints Technical Department for classification.

For further technical information please phone 0800 724 684.

RELIABILITY OF INFORMATION

All statements and technical information contained herein are based on tests we believe to be reliable but the accuracy thereof is not guaranteed. Since Protective Paints Ltd has no control over product application, purchasers and users must confirm the suitability of our products under their conditions to meet their own requirements.

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