TECHNICAL DATASHEET

www.thortex.co.uk

CORRO-TECH G.P.

Two Component Solvent Based Epoxy Coating

Thortex Corro-Tech G.P. is a high performance anti-corrosive coating, designed for use as a long term protection system of new and existing steel structures where surface preparation is restricted.

Thortex Corro-Tech G.P. is based on a complex blend of epoxy resins and a specially formulated polyamine curing system, reinforced with a unique combination of anti-corrosive pigments and rust penetrants to produce a system which provides the optimum adhesion, weather and corrosion resistance in virtually any environment.

Thortex Corro-Tech G.P. is easy to apply by brush, roller or spray and has excellent adhesion to blast cleaned or manually prepared surfaces with good compatability with existing coatings which cannot be removed.

Before proceeding, please read the following information carefully to ensure that the correct application procedure is fully understood.

SURFACE PREPARATION

All loose rust, millscale and loosely adherent coatings must be removed. Surfaces that can be abrasive blast cleaned should be prepared to a minimum standard Sa2 (BS 7079 or equivalent).

Where blast cleaning is not possible then the following methods of surface preparation should be used: high pressure water jetting, mechanical wire brushing, needle gun, mechanical grinders etc. to achieve minimum standard St2.

In coastal environments and on badly pitted steel work, high pressure water blasting is the preferred method of preparation in order to ensure complete removal of salts and corrosion products from pitted areas.

When mechanical cleaning and wire brushing is used, special attention must be paid to pitted areas to remove all loosely adherent rust and corrosion products and expose a sound substrate.

All oil and grease must be removed by the use of **Thortex Universal Cleaner** prior to carrying out surface preparation.

MIXING

Thortex Corro-Tech G.P. is a two component material which must be mixed together prior to use.

The base and activator components should be thoroughly stirred to incorporate any slight separation, whilst stirring the activator unit, the contents of the base unit should be added. Continue stirring until a homogeneous mix is obtained.

The mixed material must be used within $1^{1}/_{2}$ hours of mixing at 20°C (68°F).

APPLICATION

Do not apply when temperatures are below 7°C or when the relative humidity exceeds 90% or the surface temperature is less than 3°C above the dew point.

Thortex Corro-Tech G.P. can be applied by brush, roller or spray. When application is carried out by brush, two coats may be required to achieve the correct film build.

When airless spray application is used, a tip size of 15-18 thou is recommended with a tip pressure of approximately 2,500 psi.

Only sufficient material should be mixed that can be applied within the usable life of the product.

All equipment should be cleaned IMMEDIATELY after use with **Thortex Universal Cleaner.**

Theoretical Coverage Rate
7 m²/litre at 125 microns dft (75 ft²/litre at 5 mils dft)

Recommended Film Thickness
Wet 140 microns (5.5 mils)
Dry 125 microns (5 mils)

Detailed working recommendations are available from the Technical Centre on request.

PHYSICAL CONSTANTS

Mixing Ratio 1 part base to 1 part activator by volume.

Appearance Base - Thixotropic Metallic Liquid
Activator - Thixotropic Light Brown Liquid

Drying & Cure Times at 20°C (68°F)

Usable Life	1½ hours
Touch Dry	6 hours
Minimum Overcoating	16 hours
Maximum Overcoating	24 hours
Full Cure	7 days

Volume Solids 90%

V.O.C. 78 gms/litre

Shelf Life Use within 2 years of purchase. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F).

Food Contact Meets FDA requirements CFR 21.175.300 for food contact.
Meets USDA requirements for incidental food contact.
Canadian Food Inspection Agency - Accepted product

FOR FURTHER INFORMATION PLEASE CONTACT

PHYSICAL PROPERTIES

Direct Pull Adhesion ASTM D4541	63 kg/cm² steel (900 psi)
Humidity Resistance BS3900 Part F2	Unaffected 5,000 hours exposure
Salt Fog Resistance ASTM B117	Excellent, unaffected after 10,000 hours exposure
Impact Resistance BS3900 Part E3	Direct, Pass 0.2" (5 mm) Reverse Pass 0.2" (5 mm)
Tensile Shear Adhesion ASTM D1002	175 kg/cm² (2500 psi)

HEALTH AND SAFETY

As long as normal good practice is observed **Thortex Corro-Tech G.P.** can be safely used.

Vapour masks should be worn for spray application.

A fully detailed **Material Safety Data Sheet** is either included with the material or is available on request.

PACKAGING

Supplied in 5 and 20 litre units

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