

## **CORRO-TECH W.B.**

### Two Component Water-Based Epoxy Anti Corrosive Coating

**Thortex Corro-Tech W.B.** is a high performance anti-corrosive water-borne coating designed to provide long term protection to a wide range of metallic surfaces.

**Thortex Corro-Tech W.B.** is based on water soluble epoxy resins combined with a specially formulated water dispersable polyamine adduct reinforced with a range of fine inorganic pigments and fillers which produces an effective anti-corrosive barrier with excellent adhesion to a wide range of ferrous and non ferrous surfaces.

**Thortex Corro-Tech W.B.** is simple and easy to use and has excellent compatibility with a wide range of topcoats.

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

#### **SURFACE PREPARATION**

**Steel Surfaces:** All rust and millscale must be completely removed. The preferred method for removal of rust and millscale is abrasive blast cleaning to a minimum standard Sa2 $\frac{1}{2}$  to British Standard BS 7079 A1 1989 or equivalent near white finish to give a fine / medium profile (30-45 microns).

Where blast cleaning is not possible, surfaces should be thoroughly cleaned by mechanical grinding to produce a suitable profile, however, adhesion will be reduced compared to an abrasive blast cleaned surface.

**Galvanised Steel:** All oil and grease must be removed by thoroughly degreasing with **Thortex Universal Cleaner**. Any zinc corrosion salts must be removed by abrasion or thorough wire brushing.

**Aluminium Surfaces:** All oil and grease must be removed by thorough degreasing and the metal surface should then be abraded with 120 grade abrasive paper to produce a uniformly etched surface.

Polishing of the surface must be avoided.

#### **MIXING**

**Thortex Corro-Tech W.B.** is a two component product comprising base and activator components which must be mixed together prior to use. The base component should be thoroughly stirred then the total contents of the activator container should be added and stirring continued for at least two minutes until a homogeneous mix is achieved. The use of a variable speed mechanical mixer is beneficial to ensure complete mixing.

The mixed material must be used within 4 hours of mixing at temperatures of 20°C (68°F).

#### **APPLICATION**

Application should not be carried out at temperatures below 5°C nor when relative humidity exceeds 85% or when the surface to be coated is less than 3°C above the dew point.

Ideally, surface and atmosphere temperatures should be above 15°C.

**Thortex Corro-Tech W.B.** is primarily designed to be applied by brush or roller.

**Thortex Corro-Tech W.B.** can also be sprayed, for details on spray application, please consult the **Thortex Technical Department**.

Good quality brushes and mohair rollers are recommended for these methods of application, and **Thortex Corro-Tech W.B.** should be applied to give a uniform coating thickness of 50-60 microns (2 mils) dft.

All equipment must be cleaned IMMEDIATELY after use with water, stubborn deposits may be removed by the use of **Thortex Universal Cleaner**.

**Theoretical Coverage Rate per Coat**

8 m<sup>2</sup>/litre at 50 microns dft. (86 ft<sup>2</sup>/litre at 2 mils dft).

**Recommended Film Thickness**

Wet 110-135 microns (4-5 mils)

Dry 50-60 microns (2-2½ mils)

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

**PHYSICAL CONSTANTS**

**Mixing Ratio** 9 parts base to 1 part activator by volume.

**Appearance** Base Thixotropic Coloured Liquid  
Activator Clear Yellow Liquid

**Drying & Cure Times**

<b>at 20°C (68°F)</b>	Usable Life	4 Hours
	Touch Dry	1 Hour
	Hard Dry	2 Hours
	Minimum Overcoating	2 Hours
	Maximum Overcoating	3 Months
	Full Cure	7 Days

**Volume Solids** 45%

**V.O.C.** 40 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). Protect from frost.

**Fire Performance**

(Applied at recommended dft)

Class 1 Surface Spread of Flame - BS476 Part 7

Class 0 Designation in accordance with UK Building Regulations 1985 - BS476 Part 6 Approvals Document B2/3/4 Appendix A.

**Food Contact** Meets FDA requirements CFR 21.175.300 for food contact.

FOR FURTHER INFORMATION PLEASE CONTACT

**PHYSICAL PROPERTIES**

**Direct Pull Adhesion** 38 kg/cm<sup>2</sup> (550 psi)  
ADTM D4541 (Grit Blasted Steel)

**Dry Heat Resistance** 100°C (212°F)  
ASTMD248

**Impact Resistance** Direct 5 mm/Reverse  
BS 3900 Part E3 2.5 mm

**Tensile Shear Adhesion** 140 kg/cm<sup>2</sup> (2000 psi)  
ASTMD1002

**HEALTH AND SAFETY**

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

Protective gloves should be worn to prevent skin contact.

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 litre packs.

The information provided in this Product Data Sheet is intended as a general guide only and should not be used for specification purposes. The information is given in good faith but we assume no responsibility for the use made of the product or this information because this is outside the control of the company. Users should determine the suitability of the product for their own particular purposes by their own tests.



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