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| TYPE: | A MEDIUM VISCOSITY, PRE-ACCELERATED BISPHENOL 'A' POLYESTER GLASSFLAKE COMPOUND, CURED BY THE ADDITION OF ORGANIC PEROXIDE. |
| SUGGESTED USE: | Corroglass 232 is predominantly used for coating intricate components by brush application, where ease of application and contour following are required. The material can also be spray applied using specialist equipment with 'at gun catalysation' to such items as pipework, tankage and flooring. Corroglass 232 is often used as a primer in specifications containing Corroglass 202 as the main build material. |
| LIMITATIONS: | Not suitable for demineralised water. Resistance to polar solvents is poor and alkaline resistance at temperatures above 60°C is limited. |
| HEALTH & SAFETY: | Before handling or using this product the material safety data sheet should be read and all precautions observed. |
| SURFACE PREPARATION: | The surface to be coated should be free from grease etc. Metal should be grit blasted to ISO Standard 8501-1 Sa 2½, SSPC-SP 10, with a surface profile of at least 75 microns, 100-125 microns being the ideal key. All blast residues should be removed by sweeping clean and vacuuming where necessary. Coating of the substrate should then take place as soon as possible. For full Surface Preparation details see relevant Surface Preparation Specification Sheets. |
| APPLICATION EQUIPMENT: | Brush, Roller, Trowel or Spray (with 'at gun catalysation'). |
| APPLICATION: | The material should be brush applied, vigorously working the coating into the blast profile and ensuring that all the surface is wetted out. When used as a primer, thickness is unimportant provided that if the surface is to be left for any time the thickness should be sufficient to prevent through film corrosion until overcoated. |

APPLICATION CONTINUED:

When used on its own 232 should be applied in multiple layers to the specified DFT for the environment of use. Care should be taken to avoid runs or sags, which although seldom detrimental to the coating performance, may affect fluid flow in pump impellers etc. Usual WFT applications are between 150 and 350 microns for brush applications and 500 to 600 microns sprayed.

In common with other materials within the range, dyes may be added to effect a colour change, but care should be taken to keep addition of dye to a minimum. It is usual to overcoat this product with 252 to obtain a smoother, more easily cleaned and cosmetically superior surface finish, although this is not necessary on purely corrosion protection grounds.

MIXING RATIO:

Corroglass 232 can be catalysed within the ratios of 100:1 parts Base to Catalyst by weight to 100:2 parts Base to Catalyst by weight. The ratio should always be within these limits, 2% addition of catalyst being the norm with a reduction being made for high ambient temperatures.

MIXING:

Weigh out only the proportion of material which can be used within the pot life and place into a suitable mixing container. Measure the correct proportion of catalyst for the amount of base and carefully add this to the base using a suitably clean implement. Mix thoroughly then add dye where necessary and mix to an even colour. After mixing in the original container it is advisable to remove the contents from the mixing container into another container and remix.

POT LIFE:

40 to 50 minutes at 20°C. Pot life will be shorter at higher temperatures and longer at lower temperatures. Where temperatures are below 10°C the use of catalyst P4 will reduce pot life and cure time. Where higher temperatures are encountered, refrigerate material before use or seek the advice of Corrocoat UK for availability of inhibitor or material with longer pot life.

THINNERS:

This material can be thinned by the addition of not more than 5 parts of Styrene Monomer to 100 parts base before catalysation.

NO OTHER DILUTENT OR THINNER SHOULD BE USED. THE USE OF ACETONE OR SIMILAR THINNERS IN CORROGLASS WILL SEVERELY AFFECT PRODUCT PERFORMANCE.

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| PACKAGING: | 10 and 20 Litre composites |
| STORAGE LIFE: | 12 months stored at temperatures below 20°C and away from radiating heat sources or direct sunlight (see Shelf Life Information Sheet) |
| COLOUR AVAILABILITY: | Off White. Dyes can be used to effect colour change. |
| RECOMMENDED DFT: | 0.5 to 1.5 mm in multiple coats or as advised |
| THEORETICAL SPREADING RATE: | 1.25 kg/m ² at 1 mm thickness. |
| VOLUME SOLIDS: | This material contains volatile liquid convertible to solids. Volume solids obtained will vary dependent upon polymerisation conditions. Nominally greater than 99% of the contents are convertible to solid. |
| PRACTICAL SPREADING RATE: | Regular surfaces e.g. new steel - 1.8 kg/m ² at 1 mm thickness minimum. Irregular surfaces e.g. badly pitted steel - 2.8 kg/m ² at 1 mm. Note: This information is given in good faith but may increase dependent upon environmental conditions, the geometry and nature of work undertaken and the skill and care of application. Corrocoat accept no responsibility for any deviation from these values. |
| DENSITY: | 1.16 g/cm ³ for Base. |
| FLASH POINT: | 30 °C |
| CATALYST TYPE: | Methyl Ethyl Ketone Peroxide Corrocoat Type P2 (for ambient temperatures of 10 °C or above) or Catalyst P4 (for ambient temperatures below 10 °C). |
| MIXING RATIO: | 100:1 to 100:2 base to catalyst. |
| HARDNESS: | 40 Barcol (approximate) |

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| TENSILE STRENGTH: | 26.8 N/mm ² (3900 psi) |
| COHESIVE STRENGTH: | 15.1 N/mm ² (2195 psi) |
| ELONGATION: | 0.4% |
| THERMAL COEFFICIENT OF LINEAR EXPANSION: | 19.3 x 10 ⁻⁶ /°K |
| MOISTURE VAPOUR TRANSMISSION RATE: | Approximately 1.095 x 10 ⁻² g/hr/m ² (0.0007 perm inches) |
| THERMAL CONDUCTIVITY: | 0.410 W/m°K |
| DIELECTRIC STRENGTH: | 16 to 25 x 10 ³ V/mm. Arc resistance 40 seconds minimum. |
| TEMPERATURE LIMITS: | 90°C immersed. 160°C non-immersed. No known lower limit. |
| OVERCOATING: | May take place as soon as previous coat has gelled sufficiently to resist movement of next application and whilst still tacky. Maximum overcoating without treatment 5 days. Shorter at ambient temperatures above 30°C. |
| CLEANING FLUID: | Acetone or Methyl Ethyl Ketone before gel. Trichloroethane after gel. |
| MACHINING: | Use carbide tool or tip with good radius and neutral rake. Material has similar machining characteristics to those of grey cast iron. Tool must be kept sharp. Run out will occur due to tool wear over relatively short distances. Clean water may be used as a coating lubricant or dust suppressant. |
| CURE TIME: | At 20°C product will be hard within 3 hours and 90% cure will be attained within 12 hours. Full cure for chemical resistance will be between 7-10 days. Full cure times will be shorter at higher temperatures and longer at lower temperatures. Although not fully cured, after gel has occurred this product may be immersed in many environments without detriment to the coating, the cure process continuing even when immersed. |

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.

**Reviewed 10/2007
Revised 10 /2010**