

Corroless ACO Brush Grade

(formerly Acothane Brush Grade)

Issue Date: Feb 2020

Issue: 4

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Product Description	A highly specialised, high build, solvent free, two pack polyurethane coating for steel and concrete, for brush application.				
Features & Use	- Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance - High build, solvent free - Use for the protection of steel and concrete structures in aggressive environments, such as the internal and external protection of pipelines, offshore splash zones, bridge protection and chemical plants				
Approvals/ Certification	- Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection - BS6920 factory and site application and WRAS water fittings directory (for specific shades) - Meets the performance requirements of BS EN 10290 and AWWA C222 - Malaysian SPAN approved - Some approvals held in the former name of ‘Acothane’				
Finish	Sheen				
Volume Solids	100%				
VOC Content	0 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	1.0 mm	1.0 mm	1.0 m²/litre	
	Typical	1.5 mm	1.5 mm	0.67 m²/litre	
	Corroless ACO Brush Grade should be applied at approximately 0.5mm per coat. Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 1 mm DFT		+10°C	+20°C	+30°C
	Dust Free		4 hr	1½ hr	1 hr
	Hard Dry		12 hr	6 hr	3 hr
	Overcoating	Minimum	4 hr	1½ hr	1 hr
		Maximum	24 hr	24 hr	24 hr
	Drying and recoating times are related to the substrate temperature				
Colours	WRAS shades: RAL5005 (GB861), Light Green (GB206) Other shades: Grey, Black, Cream				
Mix Ratio/ Product Code	10BGR (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight				
Pot Life	25 min at 25°C				
SG	1.29 kg/lit mixed				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	Above 60°C				

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Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		No	No	Yes	Yes
	- This product is specifically designed for brush or roller application. Other Corroless ACO grades are available for spray application - Corroless ACO Brush Grade should be applied at approximately 0.5mm per coat				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - If maximum overcoating times are exceeded, abrading is required to provide adhesion for further coats - In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - Corroless ACO Brush Grade has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights. This product is for professional use only.

Corroless CCI 300M

CORROSION INHIBITOR

Issue Date: June 2020
Code: LC00300M
Page 1 of 2

Product Description	A mineral oil based vapour phase corrosion inhibiting (VCI) additive for lubricating and hydraulic oils.	
Features & Use	• Compatible with most mineral based oils except Transformer Oils • Compatible with most synthetic oils except Glycol based lubricants • Protects areas where the oil has drained away • Protects multi-metal systems for up to two years • Applications include compressors, engines, generators, hydraulic systems, lube oil systems etc.	
Warnings	• Not suitable for treatment of Transformer Oils • Not suitable for treatment of Glycol based lubricants	
Approvals/ Certification	• Sold on customer recommendation and extensive track record	
Finish	Not Applicable	
Volume Solids	Not applicable	
VOC Content	Not applicable	
Film Thickness Range And Coverage	Not Applicable	
Drying Times	Not Applicable does not dry	
Colours	Amber coloured mineral oil	
Mix Ratio	Single Pack: See application for further advice	
Pot Life	Not applicable	
SG	0.97 ± 2%	
Storage Conditions	Store in dry, cool conditions and protect from frost	
Shelf Life	Minimum 24 months if stored as above in unopened containers	
Flash Point	170°C	

Corroless CCI 300M

Issue Date: June 2020
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Surface Preparation	Oil Additive, no special preparation required
Mixing	Stir thoroughly before use
Thinner / Cleaner	Do not thin / Clean with water based degreaser
Application and Product Notes	- CCI 300M should be added to oil sumps or reservoirs at a ratio of 1 part CCI 300M to 10 parts lubricating oil (by volume). It may therefore be necessary to drain 10% of the existing lube oil before adding the CCI 300M - Immediately after treatment, the equipment should be operated sufficiently to circulate the treated oil - In order to retain the VCI vapour over a period of time, all normal machinery case vents, reservoir air pipes, exhausts, breathers and other openings should be sealed - The equipment should then be labelled and dated as having been treated with CCI 300M, together with the added concentration - Prior to recommissioning, there is usually no need for draining or renewing the lubricant but CARE SHOULD BE TAKEN TO REOPEN ALL VENTS, AIR PIPES, EXHAUSTS, BREATHERS AND OTHER OPENINGS that were sealed during the preservation period - CCI 300M may be introduced to the system by: adding to the existing lube oil; by correctly diluting with system's lubricating oil and spraying directly onto components; by spraying onto components undiluted; by fogging into machinery cases with compressed air; or by any combination of the above. Seek advice from your Corroless office for fogging details
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems

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Corroless CCI 350

Corrosion Inhibitor

Issue Date: June 2020
Code: LC00350
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Product Description	A lubricating, anticorrosion grease, consisting of a blend of oils, waxes and vapour phase corrosion inhibitor (VCI).
Features & Use	• Protects by both contact and vapour action • Effective even when moisture, oil and rust are already present • Gives up to 4 years protection in aggressive environments • Easy to apply and to remove • Will protect wire ropes, machinery and equipment both in operation and storage • Applications include chains, wire ropes, conveyors, spindles, open gearing, etc.
Approvals/ Certification	• Sold on track record and customer recommendation
Finish	Matt grease film
Volume Solids	85% $\pm$ 2%
VOC Content	120 g/litre
Film Thickness and Coverage	Not applicable
Drying Times	Dries to a grease film in 72 hours
Colour	Golden Brown
Mix Ratio	Single Pack
Pot Life	Not applicable
SG	0.87 kg/litre
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	32-55°C

Corroless CCI 350

Issue Date: June 2020
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Surface Preparation	- No special surface preparation is required but the cleaner the substrate the more effective will be the protection achieved - For best results, degrease using a water-soluble degreaser and prepare heavily corroded steel surfaces using scrapers, wire brushes, needle guns etc. to St2 standard of EN ISO 8501-1:2007 or equivalent, wash down with clean fresh water and allow to dry before application - For clean surfaces (e.g. production components, machinery casings etc), degrease using a water-soluble degreaser to remove dirt and oil/grease deposits. Wash down and allow to dry prior to application
Mixing	Stir thoroughly before use
Thinner / Cleaner	Corroless Thinners No 2 (Solvent Gun Wash may be used for cleaning only)
Application Conditions	Ideally apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point
Application Method	- CCI 350 is a concentrated corrosion inhibitor that can be applied to equipment either in service, shut down or in preservation situations - Apply by grease gun or by hand using a 'hairy mitt', or brush apply using up to 5% Corroless Thinners No.2. Apply directly to area to be protected - Although CCI 350 does not normally require removal prior to recommissioning equipment, it can be easily removed using conventional solvents such as Thinners No.2, white spirit, or other suitable degreaser
Product Notes	- Application Temperature: Range 5°C-30°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Not normally an issue but damaged areas can be repaired using fresh material. No maximum overcoat time - Note for extreme pressure situations such as load carrying bearings use Corroless CCI 355
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless CCI 400

Corrosion Inhibitor

Issue Date: June 2020
Code: LC00400
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Product Description	A blend of waxes and vapour phase corrosion inhibitor (VCI), developed for outdoor use under aggressive conditions. This product is also available in aerosol cans as CCI 400A, when volume solids, drying times etc. may vary from values given in this data sheet.
Features & Use	- Protects by both contact and vapour action - Effective for application on to damp surfaces - Gives up to 4 years protection in aggressive environments - Easy to apply, recoat and remove - Applications include equipment, void spaces, structural steel, winches, chains, wire ropes, cranes, box sections, etc. - The melting point of the dried film is 120°C, at which temperature the film becomes fluid. A maximum operating temperature of 100°C is therefore recommended. (See Product Notes)
Approvals/ Certification	Sold on track record and customer recommendation
Volume Solids	55% $\pm$ 2%
VOC Content	394 g/litre
Film Thickness and Coverage	Film Thickness: Wet Film 182 microns, Dry Film 100 microns Theoretical Coverage: 5.5 m ² /litre Practical coverage depends on the application method, conditions and the shape and roughness of the surface to be coated
Finish	Dull wax
Drying Times	Dries to a wax finish in 24 hours at 18°C
Colour	Semi-translucent Light Brown
Mix Ratio	Single Pack
Pot Life	Not applicable
SG	0.9 kg/litre
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	32-41°C

Corroless CCI 400

Issue Date: June 2020
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Surface Preparation	- No special surface preparation is required but the cleaner the substrate the more effective will be the protection achieved - For best results degrease using a water-soluble degreaser and prepare heavily corroded steel surfaces using scrapers, wire brushes, needle guns etc. to St2 standard of EN ISO 8501-1:2007 or equivalent, wash down with clean fresh water and allow to dry before application - For clean surfaces (e.g. production components, machinery casings etc), degrease using a water-soluble degreaser to remove dirt and oil/grease deposits. Wash down and allow to dry prior to application
Mixing	Stir thoroughly before use
Thinner / Cleaner	Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)
Application Conditions	Ideally apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point
Application Method	Airless Spray: Fluid Pressure 3000 psi; Tip Size 13-17 Thou Fan Angle 50° Conventional Spray: An addition of up to 10% Thinners No 2 may be required Brush: Apply unthinned, lay on do not over brush Roller: Not recommended
Product Notes	- Application Temperature: Range 2°C-30°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Not normally an issue but damaged areas can be repaired using fresh material, infinitely overcoatable - Available in 500 ml Aerosol Cans. Minimum order 1 box of 12 cans - CCI 400 contains an inorganic thickening agent that increases the drop point of the dried wax film from 120 degrees centigrade to 170 degrees centigrade. It will not stop it giving off fumes and eventually burning, but will prevent it from sagging and dripping into other areas at temperatures below 170 degrees centigrade
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless CCI 450

Corrosion Inhibitor

Issue Date: June 2020
Code: LC00450
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Product Description	A blend of resins and vapour phase corrosion inhibitor (VCI), developed for use where substrate visibility is required.
Features & Use	• Protects by both contact and vapour action • Effective for application onto damp surfaces • Gives up to 4 years protection in aggressive environments • Easy to apply, recoat and to remove • Touch dries to a clear glossy finish, can be safely handled • Applications include switch gear, electrical boxes, navigation equipment, parts storage, protection of structural steel plant and pipe storage • Gives extra protection of painted equipment and plant in transit • Available in aerosol cans as CCI 450A, when volume solids, drying times etc. may vary from values given in this data sheet. (500ml Aerosol Cans, minimum order 1 box of 12 cans)
Approvals/ Certification	• Sold on track record and customer recommendation
Volume Solids	50% $\pm$ 2%
VOC Content	448 g/litre
Film Thickness and Coverage	Film Thickness: Wet Film 100 microns, Dry Film 50 microns Theoretical Coverage: 10.0 m ² /litre Practical coverage depends on the application method, conditions and the shape and roughness of the surface to be coated
Finish	Clear touch dry glossy finish
Drying Times	Touch dry: 2 hours at 18°C at recommended dry film thickness Through dry: 24 hours
Colour	Clear
Mix Ratio	Single Pack
Pot Life	Not applicable
SG	0.97 kg/litre
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	32-55°C

Corroless CCI 450

Issue Date: June 2020
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Surface Preparation	- For best results degrease using a water-soluble degreaser and prepare heavily corroded steel surfaces using scrapers, wire brushes, needle guns etc. to St2 standard of EN ISO 8501-1:2007 or equivalent, wash down with clean fresh water and allow to dry before application - For clean surfaces (example production components, machinery casings etc), degrease using a water-soluble degreaser to remove dirt and oil/grease deposits. Wash down and allow to dry prior to application - Recommended substrates: Steel and most other metallic substrates
Mixing	Stir thoroughly before use
Thinner / Cleaner	Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)
Application Conditions	Ideally apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point
Application Method	Airless Spray: Fluid Pressure 1500-2000 psi; Tip Size 11-13 Thou Fan Angle 50° Conventional Spray: An addition of up to 10% Thinners No.2 may be required Brush: Apply un-thinned, lay on do not over brush Roller: Not recommended
Product Notes	- Application Temperature: Range 2°C-35°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Not normally an issue but damaged areas can be repaired using fresh material. No maximum overcoat time
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless CCI Devices

CORROSION INHIBITORS

Issue Date: June 2020
Code: LC000V1, V12, V100
Page 1 of 2

Product Description	Corroless CCI Devices (V1, V12, and V100) contain Corroless CCI Powder, a vapour phase corrosion inhibitor (VCI). They provide a convenient and effective means of protecting against corrosion in electrical equipment and enclosed areas. The units have self-adhesive backing for secure placement.
Features & Use	• Can be used on all types of electrical and electronic equipment • Does not affect electrical resistance or conductivity • Effective against dissimilar metal corrosion • Does not adversely affect rubbers, polymers, paints or plastics • Applications include navigation equipment, electrical junction boxes, switchgear, fire and safety warning systems, computer equipment etc.
Approvals/ Certification	• Sold on 30 year track record
Finish	Not Applicable
Volume Solids	Not applicable
VOC Content	Not applicable
Film Thickness Range And Coverage	Not Applicable, see application details for treatment rates
Drying Times	Not Applicable, does not dry
Colours	Not applicable - contain a white crystalline powder (Corroless CCI Powder)
Mix Ratio	Not applicable
Pot Life	Not applicable
SG	Not applicable
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	Base Corroless CCI Powder has a Flash Point Greater than 55°C

Corroless CCI Devices

Issue Date: September 2019
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Surface Preparation	- For best results, remove any carbon or oxide deposits, moisture or condensation prior to installation - Ensure the surface onto which the device is fitted is clean and free from dirt, grease, oil or other contamination, so that the self-adhesive strip on the base of the device can adhere firmly to the substrate
Mixing	Not Applicable
Thinners / Cleaner	Not applicable
Application Conditions	Application temperatures 0-35°C. Surfaces should be dry and free from ice. During application the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3° above the Dew Point. Recommended substrate: mild steel and other metallic substrates
Application	- One CCI V1 protects 1 cubic foot of air space (0.028 m³) One CCI V12 protects 12 cubic feet of air space (0.340 m³) One CCI V100 Tape protects 1 cubic foot of air space for each 2" (5.1 cm) of tape used - Active Period Up to two years depending on environmental conditions - For severe applications increase dosage by 50% - Ensure devices are kept in sealed bags and stored in a dry place until ready for use. To apply, remove backing paper from self-adhesive and place centrally and upper most in the closed area (VCI vapour is heavier than air) - For V12 devices, do NOT remove breathable membrane top. Mark the provided adhesive advice label with the date of installation and replacement date and fix securely within the area treated. Vents, doors and other openings should be sealed immediately after fitting the CCI device - Do not open CCI protected enclosures more than is absolutely necessary – devices work by vapour action and opening of enclosures will deplete vapour concentration. If enclosure is left open for more than 12 hours, replacement of the device is advised - The effectiveness of devices of this type will be reduced in enclosures subject to frequent and/or heavy dampness or condensation. Such conditions constitute a severely corrosive environment and these conditions should be first addressed at root cause. Under normal, typical enclosure conditions, Corroless CCI devices have been shown to be highly effective in minimising or eliminating corrosion
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless CCI Fuel Additive

CORROSION INHIBITOR

Issue Date: June 2020
Code: LCMM071
Page 1 of 2

Product Description	A blend of liquid and vapour phase corrosion inhibitors (VCI) in a light mineral oil, developed for the protection of fuel tanks.
Features & Use	• Works by both contact and vapour phase inhibition • Can be used for empty, partially full and full tanks • No adverse effect on the stored fuel
Approvals/ Certification	Please consult Corroless for details
Finish	Not applicable
Volume Solids	Not applicable
VOC Content	Not applicable
Drying Times	Not applicable
Colours	Not applicable
Mix Ratio	Not applicable
Pot Life	Not applicable
SG	0.92 kg/l
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored in unopened containers
Flash Point	170°C

Corroless CCI Fuel Additive

Issue Date: June 2020
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Treatment	The product can be used in several ways depending on the fill level of the tank. <u>Empty fuel tanks:</u> Empty fuel tanks can be protected in one of two ways: 1. The tank may be filled with fuel additive and then drained. The excess fuel additive may be retained for further use. 2. If flooding is not economically practical, the additive may be misted into the tank at the rate of 250 gm per cubic metre (0.025%) <u>Full or partially full fuel tanks:</u> Because the fuel acts as a diluent, and also degreases the walls of the tank, the additive must be used at 12 gm per litre in the fuel, plus 500 gm per cubic metre (0.05%) of void space left in the tank. When misting, it will help if the product is thinned with 5-10% of the fuel in the tank.
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless CCI Powder

CORROSION INHIBITOR

Product Description	A vapour phase corrosion inhibitor (VCI), offering a convenient and effective means of protecting against corrosion in enclosed areas.	
Features & Use	• Subject to normal government restrictions, CCI Powder can be discharged into the marine environment • The powder can be blown into cavities and complex equipment where application of a conventional coating would not be possible • Offers multi metal protection • It is not usually necessary to remove the powder prior to commissioning equipment • Applications include cavity and void space protection, tanks, pipe internals, box sections, valves etc.	
Approvals/ Certification	• Accepted onto the List for Approved Products suitable for use by the North Sea Oil and Gas industry, based on testing for its environmental impact • OCNS Registration Number 1413	
Finish	Not Applicable	
Volume Solids	Not applicable	
VOC Content	Not applicable	
Film Thickness Range And Coverage	Not Applicable, see application details for treatment rates	
Drying Times	Not Applicable, does not dry	
Colours	White crystalline powder	
Mix Ratio	Not applicable	
Pot Life	Not applicable	
SG	Not applicable	
Storage Conditions	Store in dry, cool conditions and protect from frost	
Shelf Life	Minimum 24 months if stored as above in unopened containers	
Flash Point	Greater than 55°C	

Corroless CCI Powder

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Surface Preparation	No surface preparation required. For best results remove any contamination, dirt, moisture or condensation prior to application
Mixing	Not Applicable
Thinners/Cleaner	Not applicable (Water may be used to clean up)
Application Conditions	- Do not apply in temperatures below 0°C. Keep the powder dry and reseal any opened containers. Wet or damp powder will cake and will not disperse correctly - During application the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the Dew Point.
Application	The quantity of CCI Powder required should be estimated from the air space to be protected: 24 months protection 15 g/litre or 525 g/m³ 12 months protection 10 g/litre or 350 g/m³ 6 months protection 7 g/litre or 245 g/m³ - The powder should be blown into the cavity or tank using bellows or low pressure compressed air, until all the powder is thoroughly dispersed within the void space - Immediately after application all vents, doors, or openings should be sealed to create a contained system, to prevent loss of VCI vapour - During application all vessels and plant, together with all application equipment, should be earthed and all possible ignition sources removed
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless CCI 350S Slushing Oil

Corrosion Inhibitor

Issue Date: June 2020
Product Code: LC0350S
Page 1 of 2

Product Description	A lubricating, anticorrosion fluid, consisting of a blend of oils, waxes and vapour phase corrosion inhibitor (VCI).
Features & Use	• Protects by both contact and vapour phase action • Suitable for application onto damp surfaces • Gives up to 4 years protection, depending on environment • Easily applied and removed • Applications include OEM equipment, production components structural steel, winches, wire ropes, cranes, box sections etc.
Approvals/ Certification	• Sold on track record and customer recommendation
Finish	Matt grease film
Volume Solids	28% $\pm$ 2%
VOC Content	557 g/litre
Film Thickness and Coverage	Does not dry - Nominal Wet Film 179 microns, Dry Film 50 microns Practical coverage depends on the application method, conditions and the shape and roughness of the surface to be coated (Nominal 5.6m ² /litre at 50 microns)
Drying Times	Dries to a grease film in 48 hours at 18°C
Colour	Golden Brown
Mix Ratio	Single Pack
Pot Life	Not applicable
SG	0.82 kg/litre
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	32-55°C

Corroless CCI 350S Slushing Oil

Issue Date: June 2020
Page 2 of 2

Surface Preparation	- No special surface preparation is required but the cleaner the substrate the more effective will be the protection achieved - For best results degrease using a water-soluble degreaser and prepare heavily corroded steel surfaces using scrapers, wire brushes, needle guns etc. to St2 standard of EN ISO 8501-1:2007 or equivalent, wash down with clean fresh water and allow to dry before application - For clean surfaces (e.g. production components, machinery casings etc), degrease using a water-soluble degreaser to remove dirt and oil/grease deposits. Wash down and allow to dry prior to application
Mixing	Stir thoroughly before use
Thinner / Cleaner	Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)
Application Conditions	Ideally apply in conditions of good ventilation which must be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.
Application Method	- Airless Spray: Fluid Pressure 3000psi Tip Size 11-13 Thou Fan Angle 50° - Conventional Spray: Thin with up to 5% Thinners No.2 - Brush or roller: apply unthinned - Apply directly to area to be protected and allow to dry - If removal is required use conventional solvents such as Thinners No.2, white spirit, or other suitable degreaser
Product Notes	- CCI 350 Slushing Oil is a cut-back version CCI 350, for ease of application. When dried, the film applied is no different to CCI 350, and can be used as a more controllable version of CCI 350. It can be applied to equipment either in service, during shut down or in preservation situations with greater control. - Application Temperature Range: 5°C-30°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Not normally an issue but damaged areas can be repaired using fresh material. No maximum overcoat time - Note: for extreme pressure situations, such as load carrying bearings, use Corroless CCI 355
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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Corroless EPF Temperate Grade 2022

Rust Stabilising Primer

Issue Date: July 2021
Code: LEPFTN3/4
Page 1 of 2

Product Description	A two pack epoxy, rust stabilising primer formulated using a tar free resin system, with Corroless Pigment and self-leafing glass flake.				
Features & Use	- High Build, solventless product with excellent abrasion resistance - Moisture tolerant - can be applied to damp surfaces - Applications include structural steel, sheet piling, tank linings, jetties, bridges, ballast tanks as well as concrete and other selected substrates				
Approvals/ Certification	NATO stock number 0442-8010-25-150-0972				
Finish	Semi-gloss (when new - chalks on exterior exposure)				
Volume Solids	96% ± 2%				
VOC Content	Black: 41 ± 20 g/litre Buff: 34 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	200 µm	208 µm	4.8 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 208 microns WFT		+10°C	+18°C	+30°C
	Dust Free		8 hr	6 hr	4 hr
	Hard Dry		24 hr	16 hr	12 hr
	Overcoating	Minimum	24 hr	16 hr	12 hr
		Maximum	4 days*	2 days*	2 days
	*For solvented products 7 days is acceptable but for Corroless EPF and RF35(2006) and RF35 White the maximums listed apply. Full cure is a nominal 7 days at 18°C. Drying and recoating times are related to the substrate temperature				
Colours	Black (LEPFTN3) and Buff (LEPFTN4) Note: base is red brown and the hardeners are black and off white respectively				
Mix Ratio	Base 1 part by volume Hardener 1 part by volume				
Pot Life	60 min at 18°C				
SG	1.53 kg/lt mixed				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	Above 60°C				

Corroless EPF Temperate Grade 2022

Issue Date: July 2021

Page 2 of 2

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 EPF can also be applied to concrete and other substrates – advice available on request) Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry New Steel: All mill scale must be removed prior to application - Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination				
Mixing	Mix each component separately prior to use thoroughly mixing together for 2-3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in proportions recommend.				
Thinner / Cleaner	Corroless Thinners No.6 Note: thinning is not allowed when lining potable tanks				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	No	Yes	Yes
	- Airless spray: output fluid pressure 3500-4000 psi, tip size 17-21 thou (0.43-0.53mm). For detailed advice contact Corroless - Brush/roller: apply un-thinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller followed by laying off with a brush. For non-potable situations a maximum addition of 5% Corroless Thinners No.6 is allowed				
Product Notes	Application Temperature: Range 2°C-30°C (Curing will be retarded below 10°C -product will cure down to 2°C but cure will be slow Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with Corroless EPF, Corroless RF31, RF35, RF61, RF65. If overcoating time exceeds and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless M

Multi-metal Primer

Issue Date: June 2020
Code: 2807001
Page 1 of 2

Product Description	A general purpose, single pack, rust stabilising primer for use on weathered galvanising, steel and other metals			
Features & Use	• Use as a patch or overall primer on rusted areas of galvanising or steelwork • Enables the use of one primer for a variety of substrates • No etch primer or barrier coat required on galvanised steel • Excellent adhesion and flexibility • Contains Corroless Pigment • Applications include street furniture, piping, mechanical equipment, railings structural steel, tank exteriors, bridges, and other galvanised structures			
Approvals/ Certification	• Sold on track record and customer recommendation			
Finish	Matt finish			
Volume Solids	34% ± 2%			
VOC Content	512 ± 20 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	50 µm	147 µm	6.8 m ² /litre
	Two coats recommended for best results over rusty steel			
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 50 microns DFT		+10°C	+18°C
	Dust Free		2 hr	1 hr
	Hard Dry		24 hr	16 hr
	Overcoating	Minimum	24 hr	16 hr
		Maximum	Indefinite	Indefinite
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation			
Colours	Red Brown			
Mix Ratio	Single Pack			
Pot Life	Not applicable			
SG	1.35 kg/lt			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	23-60°C			

Corroless M

Issue Date: June 2020
Page 2 of 2

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: Weathered and partly corroded galvanised steel and zinc coated metal, weathered aluminium and steel Manual Preparation Prepare bare steel areas using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Ensure all scale is removed. All corrosion products and zinc salts must be removed, ideally by abrading or scrubbing followed by fresh water washing. Any areas of bright smooth galvanising or other metal surfaces should be abraded to provide a key. Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Sweep blast to remove loose material, scale and salts and prepare bare steel areas to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 75 microns maximum. Wash down with clean fresh water and allow to dry - All surfaces when coated should be firm, clean, dry and from all oil, grease, powdery flash rusting corrosion salts and other contamination				
Mixing	Stir thoroughly before use				
Thinner / Cleaner	Corroless Thinners No.3 (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes - thinning required	Yes	Yes
	Airless spray: output fluid pressure 2000 psi, tip size 17-19 thou Fan Angle 30-50°. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.3 will be required Brush: apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.3. Lay off with a brush to complete the finish				
Product Notes	Application Temperature: Range 2°C-35°C. Curing will be retarded below 10°C - product will cure down to 2°C but cure will be slow Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself recommended topcoat Corroless G3, or Corroless RF16 when both Corroless M and topcoat thickness should not exceed 50µm DFT. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution / fresh water rinse and allow to dry before continuing - While overcoating time is indefinite overcoating within 3-7 days at 18°C is recommended for best results				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless QDR

Rust Stabilising Primer

Issue Date: June 2020
Code: LQDR1/2/3
Page 1 of 2

Product Description	A quick drying, single pack, rust stabilising primer reinforced with self-leafig glass flake.				
Features & Use	- Over 30 years track record in corrosion control - Fast overcoating – from only 30 minutes - Designed for fast patch repair of localised damage, offering enhanced short- term repair where turn around times do not allow for normal recoating intervals - Contains glass flake for improved impermeability and abrasion resistance - Contains Corroless Pigment - Applications include pipes, cranes, tank exteriors, jetties, bridges, mechanical equipment, railings and other structural steel - NOT suitable for application onto galvanised steel				
Approvals/ Certification	- Sold on track record and customer recommendation - QDR 1: NATO Stock Number 0442 8010 99 915 4034				
Finish	Low gloss				
Volume Solids	QDR1 & 2: 45% ± 2% QDR3: 41% ± 2%				
VOC Content	QDR1 444g/litre, QDR2 435g/litre. QDR3 514 g/litre ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	QDR1 & 2	50 µm	111 µm	9.0 m²/litre	
	QDR3	50 µm	122 µm	8.2 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated Always apply two coats				
Drying Times	Applied to recommended DFT		+10°C	+18°C	+30°C
	Dust Free		30 minutes	20 minutes	15 minutes
	Hard Dry		6 hr	4 hr	2 hr
	Overcoating	Minimum	6 hr	4 hr	2 hr
		Maximum	9 days	7days	3 days
Colours	QDR1 - Red Brown QDR2 - Buff QDR3 - Black				
Mix Ratio	Single Pack				
Pot Life	Not applicable				
SG	QDR1 & 2 1.45 kg/litre QDR3 1.28 kg/litre				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	21-32°C				

Corroless QDR

Issue Date: June 2020
Page 2 of 2

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 Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry before coating New Steel: All mill scale must be removed prior to application - Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination				
Mixing	Stir thoroughly before use				
Thinner / Cleaner	Corroless Thinners No.3 (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes- Thinning required	Yes	Yes
	Airless spray: output fluid pressure 3000 psi, tip size 13-15 thou, Fan angle 30-65°. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.3 will be required Brush: apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.2. Lay off with a brush to complete the finish				
Product Notes	Application Temperature: Range 2°C-35°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself or Corroless RF16. If overcoating time is exceeded and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RF16

High Build Reinforced Gloss Topcoat

Issue Date: June 2020
Code: 2004
Page 1 of 2

Product Description	A single pack general purpose, glass reinforced high build alkyd topcoat				
Features & Use	- Contains glass flake for improved impermeability and abrasion resistance - High build – reduces application costs and saves time - Good application properties - Fast drying compared to other high build alkyds, to help reduce the possibility of dust contamination shortly after application - Applications include pipes, mechanical equipment, bridges, fire escapes, storage tank externals and structural steel				
Approvals/ Certification	Sold on track record and customer recommendation				
Finish	Gloss				
Volume Solids	42% ± 2%				
VOC Content	500 g/litre (average)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	50 µm	119 µm	8.4 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 50 microns DFT		+10°C	+18°C	+30°C
	Dust Free		2 hr	1½ hrs	45 mins
	Hard Dry		8 hr	6 hr	3 hr
	Overcoating	Minimum	24 hr	16 hr	10 hr
		Maximum	Indefinite	Indefinite	Indefinite
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Available in a wide range of colours				
Mix Ratio	Single Pack				
Pot Life	Not applicable				
SG	0.9-1.1 depending on colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	21-32°C				

Corroless RF16

Issue Date: June 2020
Page 2 of 2

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 application - This is a finish coat and should be applied over a Corroless Primer Recommended Primers: Corroless S, SHB, and QDR				
Mixing	Stir thoroughly before use				
Thinner / Cleaner	Corroless Thinners No.3 (Spray) or No.2 (Brush). Solvent Gun Wash may be used for cleaning only				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes-Thinning required	Yes	Yes
	Airless spray: output fluid pressure 1800-2500 psi, tip size 11-19 thou Fan Angle 30-50°C. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.3 will be required Brush: apply unthinned, lay on, do not over brush When rollerling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.2. Lay off with a brush to complete the finish				
Product Notes	Application Temperature: Range 5°C-30°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself. If overcoating time is exceeded and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - No maximum overcoat time, but if contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RF 31

Two Pack Epoxy Reinforced Intermediate/Finish

Issue Date: June 2020

Code: 4835

Page 1 of 2

Product Description	A high solids, glass reinforced, chemically resistant, two pack epoxy intermediate/finish.				
Features & Use	- Excellent chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts - Cures down to 2°C - Withstands splashes of oxidising acids or bleaching agents - Withstands most greases and immersion in oil - Withstands immersion in aliphatic solvents and splashes of aromatic solvents - Durable finish used for long-term performance both on and offshore - Gives excellent protection in urban, marine and industrial environments				
Approvals/ Certification	Please consult Corroless				
Finish	Gloss (will chalk on exterior exposure)				
Volume Solids	82% ± 2%				
VOC Content	173 ± 20g /litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	125 µm	152 µm	6.6 m²/litre	
	Maximum	200 µm	244 µm	4.1 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied at 125 microns DFT		+5°C	+10°C	+23°C
	Dust Free		9 hrs	6 hrs	3 hrs
	Hard Dry		15hrs	7 hrs	2 hrs
	Overcoating	Minimum	24 hrs	16 hrs	10 hrs
		Maximum	7 days	7 days	3 days
	Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Available in a wide range of colours				
Mix Ratio	1:1 by volume (base to hardener)				
Pot Life	3½ hours at 23°C				
SG	1.46 -1.50 kg/litre (mixed material) varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

Corroless RF 31

Issue Date: June 2020
Page 2 of 2

Surface Preparation	- All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination - This is an intermediate or finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF				
Mixing	Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.				
Thinner / Cleaner	Corroless Thinners No.4. (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes-Thinning required	Yes	No
	Airless spray: output fluid pressure 2500-3000 psi, tip size 19-27 thou, Fan Angle 30-65°. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.4 will be required Brush: apply unthinned, lay on, do not over brush				
Product Notes	Application Temperature: Range 2°C (10°C preferred) to 30°C. Do not apply below 2°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself, Corroless RF61 and RF65. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoating times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RF35 (2022)

Two Pack Epoxy Tank Lining

Issue Date: July 2021

Code: L8RF45N

Page 1 of 2

Product Description	A two-component high build solvent-less epoxy coating.				
Features & Use	• Good chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts - seek advice from Corroless • Withstands most greases and immersion in oil • Withstands immersion in aliphatic solvents and splashes of aromatic solvents • NOT suitable for contact with petrol • Glass reinforced for increased impermeability • Applications include water tanks, pipes and fittings, cargo holds and ballast tanks, sewage works, reservoir tunnels and shafts etc.				
Approvals/ Certification	• NATO stock number 0442 8010 99 337 0778				
Finish	Gloss (will chalk on exterior exposure)				
Volume Solids	96% ± 2%				
VOC Content	Base 24 g/litre Hardener 0 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	200 µm	208 µm	4.8 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied at 200 microns DFT		10°C	18°C	30°C
	Dust Free		12 hrs	8 hrs	6 hrs
	Hard Dry		24 hrs	16 hrs	12 hrs
	Overcoating	Minimum	24 hrs	16 hrs	12 hrs
		Maximum	3 days	3 days	2 days
	Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Grey (approximately BS 18B21)				
Mix Ratio	3:1 by volume (base to hardener)				
Pot Life	45 minutes at 18°C				
SG	1.36 ±0.05 kg/litre (mixed material)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

Corroless RF35 (2022)

Issue Date: July 2021

Page 2 of 2

Surface Preparation	- All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination - This is an intermediate or finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF				
Mixing	Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.				
Thinner / Cleaner	Corroless Thinners No.4. Solvent Gun wash can be used for cleaning only				
Application Conditions	High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	No	Yes	Yes
	Airless spray: Plural component feed systems such as 'Graco Hydra-Cat' are recommended. Output fluid pressure 4000 psi, Tip Size 19 thou, Fan Angle 50°. For detailed advice contact Corroless Technical. Brush: apply un-thinned, lay on, do not over brush				
Product Notes	- Application Temperature: Range 8°C -35°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Overcoat with itself. To overcoat with other Corroless products consult Corroless Technical - If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoating times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RF 35 WHITE

Two Pack Epoxy Tank Lining

Issue Date: June 2020

Code: L7RF35W

Page 1 of 2

Product Description	A two-component high build solvent-less epoxy coating.				
Features & Use	- Approved in conjunction with Corroless EPF for the interior of bulk fuel tanks - NOT suitable for contact with petrol - Good chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts. Consult Corroless for detailed advice - Withstands most greases and immersion in oil - Withstands immersion in aliphatic solvents and splashes of aromatic solvents - Glass reinforced for increased impermeability - Applications include fuel tanks, non-potable water tanks, pipes and fittings, cargo holds and ballast tanks, sewage works				
Approvals	- Approved in conjunction with Corroless EPF for the interior of fuel tanks, including aviation - MIL-PRF-4556F - DEF STAN 80/97 - NATO STOCK Number 0442 8010 99 337 0778				
Finish	Gloss (will chalk on exterior exposure)				
Volume Solids	96% ± 2%				
VOC Content	Base 42 g/litre Hardener 19 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	200 µm	208 µm	4.8 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied at 200 microns DFT		10°C	18°C	30°C
	Dust Free		12 hrs	8 hrs	6 hrs
	Hard Dry		24 hrs	16 hrs	12 hrs
	Overcoating	Minimum	24 hrs	16 hrs	12 hrs
		Maximum	3 days	3 days	2 days
	Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Off White				
Mix Ratio	2:1 by volume (base to hardener)				
Pot Life	45 minutes at 18°C				
SG	1.33 ±0.05 kg/litre (mixed material)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

Corroless RF 35 WHITE

Issue Date: June 2020
Page 2 of 2

Surface Preparation	- All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination - This is an intermediate or finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF				
Mixing	Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended				
Thinner / Cleaner	Corroless Thinners No 4. Solvent Gun wash can be used for cleaning only				
Application Conditions	High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	No	Yes	Yes
	- Airless spray: Plural component feed systems such as 'Graco Hydra-Cat' are recommended. Output fluid pressure 4000 psi, Tip Size 19 thou, Fan Angle 50°. - Conventional Spray: Not recommended - Brush: apply un-thinned, lay on, do not over brush				
Product Notes	- Application Temperature: Range 8°C - 35°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: overcoat with itself. To overcoat with other Corroless products consult Corroless - If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoating times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RF61

Two Pack Polyurethane Reinforced Gloss Finish

Issue Date: June 2020

Code: 4836

Page 1 of 2

Product Description	A two component, glass reinforced, aliphatic polyurethane gloss finish.				
Features & Use	• Excellent gloss retention • Tough durable finish, good anti-abrasion resistance and weathering characteristics • Glass reinforced for increased impermeability • Excellent chemical resistance • Infinitely recoatable • Durable finish used for long-term performance both on and offshore • Gives excellent protection in urban, marine and industrial environments • Applications include piping, cranes, mechanical equipment, storage tank exteriors, bridges chemical plant and other structural steel				
Approvals/ Certification	• Sold on track record				
Finish	High Gloss				
Volume Solids	53% ± 2%				
VOC Content	Base 428 g/litre (average), Hardener 379 g/litre ± 20g /litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	30 µm	56 µm	17.7 m²/litre	
	Maximum	60 µm	113 µm	8.8 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied at 40 microns DFT		+10°C	+18°C	+30°C
	Dust Free		2 hrs	1½ hrs	45 minutes
	Hard Dry		6hrs	4 hrs	2 hrs
	Overcoating	Minimum	24 hrs	16 hrs	12 hrs
		Maximum	Indefinite	Indefinite	Indefinite
	Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Available in a wide range of colours				
Mix Ratio	5:1 by volume (base to hardener)				
Pot Life	4 hours at 18°C				
SG	1.1 1.3 kg/litre (mixed material) varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

Corroless RF61

Issue Date: June 2020
Page 2 of 2

Surface Preparation	- All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination - This is a finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF Intermediate coat: Corroless RF31				
Mixing	Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.				
Thinner / Cleaner	Corroless Thinners No.5. (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes-Thinning required	Yes	Yes
	Airless spray: output fluid pressure 2200-2500 psi, tip size 13-18 thou, Fan Angle 30-65°. Caution contains isocyanate. Ensure adequate ventilation and wear air fed hood when spraying. An addition of 5-10% of Corroless Thinners No.5 is recommended for best results when airless spraying. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.5 will be required Brush: apply unthinned, lay on, do not over brush				
Product Notes	Caution contains isocyanate - Application Temperature: Range 5°C (10°C preferred) to 25°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Overcoat with itself, or RF65 - If overcoating time exceeds 24 hrs and contamination has occurred clean using a detergent solution/fresh water to remove contamination rinse and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RF65

Two Pack Polyurethane Reinforced Finish

Issue Date: June 2020
Code: 4837
Page 1 of 2

Product Description	A two component, glass reinforced, acrylic urethane semi-gloss finish.				
Features & Use	• Excellent colour and UV resistance • Tough durable semi-gloss finish, good anti-abrasion resistance and weathering characteristics both onshore and offshore • Glass reinforced for increased impermeability • Excellent chemical resistance • Indefinitely recoatable • Gives excellent protection in urban, marine and industrial environments • Applications include piping, cranes, mechanical equipment, storage tank exteriors, bridges chemical plant and other structural steel				
Approvals/ Certification	• Approved for use by Network Rail with Corroless EPF as primer. Systems for blast prepared surfaces: XM92 M21,085 and XN90 N2,054 System for hand prepared surfaces: XM92 M24,084 • For full details and a copy of the certificate contact Corroless Technical				
Finish	Semi-Gloss				
Volume Solids	58% ± 2%				
VOC Content	Base 431 g/litre (average) Hardener 112 g/litre ± 20g /litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	30 µm	52 µm	19.3 m²/litre	
	Maximum	50 µm	86 µm	11.6 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied at 50 microns DFT		+10°C	+18°C	+30°C
	Dust Free		2 hrs	1½ hrs	45 minutes
	Hard Dry		6hrs	4 hrs	2 hrs
	Overcoating	Minimum	24 hrs	16 hrs	12 hrs
		Maximum	Indefinite	Indefinite	Indefinite
	Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Available in a wide range of colours				
Mix Ratio	9:1 by volume (base to hardener)				
Pot Life	4 hours at 18°C				
SG	1.4-1.6 kg/litre (mixed material) varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

Corroless RF65

Issue Date: June 2020
Page 2 of 2

Surface Preparation	- All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination - This is a finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF Intermediate coat: Corroless RF31				
Mixing	Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.				
Thinner / Cleaner	Corroless Thinners No.5. (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes-Thinning required	Yes	Yes
	Airless spray: output fluid pressure 2200-2500 psi, tip size 13-18 thou, Fan Angle 30-65°. Caution contains isocyanate. Ensure adequate ventilation and wear air fed hood when spraying. An addition of 5-10% of Corroless Thinners No.5 is recommended for best results when airless spraying. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.5 will be required Brush: apply unthinned, lay on, do not over brush				
Product Notes	Caution contains isocyanate - Application Temperature: Range 5°C (10°C preferred) to 25°C - Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. - Overcoating: Overcoat with itself - If overcoating time exceeds 24 hrs and contamination has occurred clean using a detergent solution/fresh water to remove contamination, rinse and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless RUSTKILLER

Acrylic Safe Rust Stabilising Primer

Issue Date: June 2020

Code: LK00200

Page 1 of 2

Product Description	A single pack, rust stabilising primer, designed for the DIY and automotive restoration markets.				
Features & Use	- Over 30 years track record in corrosion control - Excellent wetting properties - Designed to penetrate firmly adhered rust - Glass reinforced for extra abrasion resistance and toughness - Will withstand operating temperatures up to 200°C - Ideal for general maintenance - Contains Corroless Pigment - Available in Aerosols and cans - Applications include DIY and Automotive restoration markets, structural steel, sheet piling, tank linings, jetties, and bridges - NOT suitable for application to galvanised steel				
Approvals/ Certification	Sold on track record and customer recommendation				
Finish	Low gloss				
Volume Solids	44% ± 2%				
VOC Content	310 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	35 µm	80 µm	12.6 m²/litre	
	Always apply two coats				
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 35 microns DFT		+10°C	+18°C	+30°C
	Dust Free		4 hr	2 hr	1 hr
	Hard Dry		6 hr	4 hr	2 hr
	Overcoating	Minimum	6 hr	4 hr	2 hr
		Maximum	9 days	7days	3 days
Colours	Red Brown				
Mix Ratio	Single Pack				
Pot Life	Not applicable				
SG	1.26 kg/lt				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	21 °C-32°C				

Corroless RUSTKILLER

Issue Date: June 2020
Page 2 of 2

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 S can also be applied to other substrates – advice available on request) Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry New Steel: All mill scale must be removed prior to application - Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination				
Mixing	Stir thoroughly before use				
Thinner / Cleaner	Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes-thinning required	Yes	Yes
	Airless spray: output fluid pressure 2000 psi, tip size 17-19 thou Fan Angle 30-50°. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.2 will be required Brush: apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.2. Lay off with a brush to complete the finish				
Product Notes	Application Temperature: Range 2°C-35°C (Curing will be retarded below 10°C - product will cure down to 2°C but cure will be slow) Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: If overcoating time is exceeded and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless S

Rust Stabilising Primer

Issue Date: June 2020
Code: LS00001/2
Page 1 of 2

Product Description	A general purpose, single pack, rust stabilising primer.				
Features & Use	- Over 30 years track record in corrosion control - Excellent wetting properties - Designed to penetrate firmly adhered rust - Will withstand operating temperatures up to 200°C - Ideal for general maintenance - Contains Corroless Pigment - Applications include, tank exteriors, jetties, bridges, street furniture and other structural steel - NOT suitable for application onto galvanised steel				
Approvals/ Certification	- NATO Stock Numbers: Corroless S1 H1 9010 99 220 3622 Corroless S2 H1 8010 99 220 3621 - Sold on track record and customer recommendation				
Finish	Low gloss				
Volume Solids	44% ± 2%				
VOC Content	S1: 310 ± 20 g/litre S2: 411 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	35 µm	80 µm	12.6 m²/litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 35 microns DFT		+10°C	+18°C	+30°C
	Dust Free		4 hr	2 hr	1 hr
	Hard Dry		6 hr	4 hr	2 hr
	Overcoating	Minimum	6 hr	4 hr	2 hr
		Maximum	9 days	7days	3 days
Colours	S1 - Red Brown S2 - Buff				
Mix Ratio	Single Pack				
Pot Life	Not applicable				
SG	1.26				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	Above 60°C				

Corroless S

Issue Date: June 2020
Page 2 of 2

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 Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry New Steel: All mill scale must be removed prior to application - Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination				
Mixing	Stir thoroughly before use				
Thinner / Cleaner	Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)				
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 90% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		Yes	Yes- thinning required	Yes	Yes
	Airless spray: output fluid pressure 3500-4000 psi, tip size 17-21 thou (0.43-0.53mm). For detailed advice contact Corroless Conventional Spray An addition of up to 10% Corroless Thinners No.2 will be required Brush: apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.2. Lay off with a brush to complete the finish				
Product Notes	Application Temperature: Range 2°C-35°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself Corroless SHB, or Corroless RF16. If overcoating time is exceeded and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing - If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO LV Sealer

(formerly Acothane LV Sealer)

Issue Date: Apr 2020
Issue: 3
Page 1 of 2

Product Description	A solvent free, two pack polyurethane sealer for concrete , for use with specified Corroless ACO products.			
Features & Use	Use for the priming of concrete, plaster etc. prior to application of a Corroless ACO finishing system, or as a saturation coating for concrete			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Sheen			
Volume Solids	100%			
VOC Content	0 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	100µm	100µm	5.0 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 100µm DFT		+10°C	+23°C
	Dust Free		4 hr	2 hr
	Hard Dry		12 hr	6 hr
	Overcoating	Minimum	4 hr	2 hr
		Maximum	24 hr	24 hr
	Drying and recoating times are related to the substrate temperature			
Colours	Clear			
Mix Ratio/ Product Code	10LVS (base) and 10ACT (activator) Base 2.5 parts by volume Hardener 1 part by volume			
Pot Life	35 min at 20°C – do not apply after this time even if material appears fluid			
SG	1.07 kg/lit mixed			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	Above 60°C			

Corroless ACO LV Sealer

Issue Date: Apr 2020
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts or other contamination - Remove all laitance and other contaminants by the most appropriate methods, such as blast cleaning. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		No	No	Yes	Yes
	Use immediately after mixing and work well into the substrate				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - If maximum overcoating times are exceeded, abrading is required to provide adhesion for further coats - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO Mastic Rapid Grade

(Formerly Acothane Mastic Rapid Grade)

Issue Date: Aug 2020
Issue: 5
Page 1 of 2

Product Description	A solvent free, fast curing, two pack polyurethane repair mastic for pipe coatings.			
Features & Use	- Use for the coating of field joints, repair of damaged coatings, filling of holes and cracks, on steel pipelines and other steel structures - This Rapid grade is specifically developed for use at lower ambient temperatures. For temperatures above 25°C the Mastic Standard Grade should be used, as this Rapid grade will be too fast curing			
Approvals/ Certification	- Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection - Meets the performance requirements of BS EN 10290 and AWWA C222 - Malaysian SPAN approved - Some approvals held in the former name of 'Acothane'			
Finish	Sheen			
Volume Solids	100%			
VOC Content	0 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	1 mm	1 mm	1.0 m ² /litre
	Typical	5 mm	5 mm	0.2 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 1.0 mm DFT		+10°C	+20°C
	Dust Free		40 min	15 min
	Hard Dry		1½ hr	40 min
	Overcoating		40 min	15 min
	Full Cure		7 days	6 days
	Drying and recoating times are related to the surface temperature			
Colours	Grey and a limited range of other shades to order			
Mix Ratio/ Product Code	10AMR (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight			
Pot Life	approx. 5 min at 25°C			
SG	1.29 kg/lit mixed			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	Above 60°C			

Corroless ACO Mastic Rapid Grade

Issue Date: Aug 2020
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Overlap onto existing pipeline coating: remove any loose material to establish a firm edge. Feather sound coating and abrade surface to provide a key. Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disk etc.) Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		No	No	Yes	No
	Designed for application by brush, roller, putty knife, trowel or spatula				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - Overcoating - abrading will be required if overcoating after 24 hours - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - Corroless ACO Mastic Rapid has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice - Can be used in operations requiring fast cure, e.g. lay barge, weld coating and encapsulation of anode connectors, coating repair prior to trenching/backfilling. Corroless ACO Standard Mastic should be used for less speed-critical coating operations and at temperatures above 25°C				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO Mastic Standard Grade

(formerly Acothane Mastic Standard Grade)

Issue Date: Apr 2020
Issue: 4
Page 1 of 2

Product Description	A solvent free, high build, two pack polyurethane mastic for steel, for the repair of pipe coatings and the coating of field joints.			
Features & Use	- Use for the coating of field joints, repair of damaged coatings, filling of holes and cracks, on steel pipelines and other steel structures - For faster-cure repairs use Corroless ACO Mastic Rapid grade, and for higher temperatures and hot surfaces, use Corroless ACO Mastic TG grade			
Approvals/ Certification	- Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection - BS6920 factory and site application and WRAS water fittings directory (Blue only) - Meets the performance requirements of BS EN 10290 and AWWA C222 - Malaysian SPAN approved - Some approvals held in the former name of 'Acothane'			
Finish	Sheen			
Volume Solids	100%			
VOC Content	0 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	1 mm	1 mm	1.0 m ² /litre
	Typical	5 mm	5 mm	0.2 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 1 mm DFT		+10°C	+20°C
	Dust Free		2 hr	1 hr
	Hard Dry		6 hr	4 hr
	Overcoating		2 hr	1 hr
	Full Cure		7 days	7 days
	Drying and recoating times are related to the surface temperature			
Colours	WRAS shade: Blue Other shades: Grey, Cream			
Mix Ratio/ Product Code	10AMS (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight			
Pot Life	approx. 12 min at 25°C, 8 min at 30°C			
SG	1.29 kg/lit mixed			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	Above 60°C			

Corroless ACO Mastic Standard Grade

Issue Date: Apr 2020
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Overlap onto existing pipeline coating: remove any loose material to establish a firm edge. Feather sound coating and abrade surface to provide a key. Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disk etc.) Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		No	No	Yes	No
	Designed for application by brush, roller, putty knife, trowel or spatula				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - Overcoating - normally after 1 hour and within 24 hours of initial application. Abrading will be required if overcoating after 24 hours - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water - Corroless ACO Mastic Standard has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO Pour and Roll Grade

(formerly Acothane Pour and Roll Grade)

Issue Date: Mar 2019
Issue: 2
Page 1 of 2

Product Description	A solvent free, two pack polyurethane for floor, wall and steel coating.			
Features & Use	- Designed for application to steel and concrete, for heavy duty flooring, tank coating, grouting and encapsulation - Rapid drying and curing characteristics			
Approvals/ Certification	Consult Axalta Coating Systems			
Finish	Sheen			
Volume Solids	100%			
VOC Content	0 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	0.5 mm	0.5 mm	2.0 m ² /litre
	Typical	2 mm	2 mm	0.5 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 1 mm DFT		+10°C	+20°C
	Dust Free		4 hr	2 hr
	Hard Dry		16 hr	12 hr
	Foot Traffic		16 hr	12 hr
	Heavy Traffic		24 hr	24 hr
	Drying and recoating times are related to the surface temperature			
Colours	Cream, Grey and a limited range of other shades			
Mix Ratio/ Product Code	10PAR (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight			
Pot Life	approx. 25 min at 20°C			
SG	1.29 kg/lit mixed			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	Above 60°C			

Corroless ACO Pour and Roll Grade

Issue Date: Mar 2019
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		See below			
	Apply using trowel or squeegee. De-aerate thickly applied floor coating whilst still wet using a spiked roller				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - Not normally overcoated – consult Axalta Coating Systems for advice if overcoating is required - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO Spray Grade

(formerly Acothane Spray Grade)

Product Description	A high build, solvent free, two pack polyurethane coating for spray application onto steel pipes and field joints.					
Features & Use	- Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance - Use for the protection of steel and concrete structures in aggressive environments e.g. internal and external protection of pipelines, field joints, offshore splash zones, bridge protection, chemical plants					
Approvals/ Certification	- Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection - Meets the performance requirements of BS EN 10290 and AWWA C222 - Malaysian SPAN approved - Approvals held in the former name of ‘Acothane’					
Finish	Sheen					
Volume Solids	100%					
VOC Content	0 g/litre					
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage		
	Typical	0.5 mm	0.5 mm	2.0 m²/litre		
	Typical	5 mm	5 mm	0.2 m²/litre		
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 1 mm DFT		+10°C	+20°C	+30°C	+40°C
	Dust Free		50 min	30 min	15 min	10 min
	Hard Dry		8 hr	4 hr	3 hr	2 hr
	Stackable		16 hr	8 hr	7 hr	7 hr
	Full Cure		7 days	7 days	6 days	5 days
	Drying and recoating times are related to the surface temperature					
Colours	Cream, Grey and a limited range of other shades					
Mix Ratio/ Product Code	10SGR (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight					
Pot Life	5 min at 20°C					
SG	1.29 kg/lt mixed					
Storage Conditions	Store in dry, cool conditions and protect from frost					
Shelf Life	Minimum 24 months if stored as above in unopened containers					
Flash Point	Above 60°C					

Corroless ACO Spray Grade

Issue Date: Aug 2020
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Twin feed equipment required				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		See below			
	- Twin component hot airless spray required with instant purge capability due to very short pot life – please consult Axalta Coating Systems for advice - Note that the use of the Sulzer cartridge spraying system or other low-pressure spraying systems is not permitted for Drinking water applications requiring WRAS approvals				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - Overcoating - normally after 1 hour and within 24 hours of initial application. Abrading will be required if overcoating after 24 hours - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - Curing rate will be retarded below 10°C - Backfilling or immersion can normally be carried out as soon as the coating is Hard Dry - Spark/Holiday testing: maximum 5KV after the coating is hard dry - Corroless ACO Spray Grade has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO Twin Pack Repair Kit

(formerly Acothane Twin Pack Repair Kit)

Product Description	A solvent free, two pack polyurethane mastic repair kit for the repair of small defects in pipeline coatings.					
Features & Use	• Packaged in a polythene bag, divided by a plastic clip, and sealed in an aluminium foil pack • For small area repairs to most types of pipe coatings, including FBE, 3LPE, 3LPP and polyurethanes • Outstanding mechanical properties and rapid cure characteristics together with excellent adhesion to most pipe coating materials.					
Approvals/ Certification	• Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection • Meets the performance requirements of BS EN 10290 and AWWA C222 • Malaysian SPAN approved • Approvals held in the former name of ‘Acothane’					
Finish	Sheen					
Volume Solids	100%					
VOC Content	0 g/litre					
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage		
	Typical	0.5 mm	0.5 mm	0.07 m²/pack		
	Typical	5 mm	5 mm	0.007 m²/pack		
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 1 mm DFT		+10°C	+20°C	+30°C	+40°C
	Dust Free		40 min	15 min	5 min	3 min
	Hard Dry		1½ hr	40 min	20 min	5 min
	Overcoating		40 min	15 min	5 min	3 min
	Full Cure		7 days	6 days	5 days	4 days
	Drying and recoating times are related to the surface temperature					
Colours	Beige					
Mix Ratio/ Product Code	10ATP Base 3 parts by volume Hardener 1 part by volume					
Pot Life	approx. 5 min at 25°C					
SG	1.31 kg/lit mixed					
Storage Conditions	Store in dry, cool conditions and protect from frost					
Shelf Life	Minimum 48 months if stored as above in unopened containers					
Flash Point	Above 60°C					

Corroless ACO Twin Pack Repair Kit

Issue Date: Aug 2020
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Overlap onto existing Corroless ACO coating: remove any loose material to establish a firm edge. Feather sound coating and abrade surface to provide a key. Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disk grinding etc.) Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Remove outer foil wrapper. Remove plastic clip. Mix the contents of the pack by thoroughly working the components in the plastic bag together for at least 2 minutes. Remove corner of bag and dispense. See Corroless ACO Twin Pack Mixing Instructions				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		See below			
	Use plastic divider or spatula to apply				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - Overcoating - abrading will be required if overcoating after 24 hours - Corroless ACO Twin Pack has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless ACO Weldcoat

(formerly Acothane Weldcoat)

Issue Date: Aug 2020
Issue: 5
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Product Description	A highly specialised, high build, solvent free, two pack polyurethane coating designed for brush application to pipe girth welds.			
Features & Use	• Use for complete corrosion protection in water immersion, soil burial or atmospheric exposure conditions for pipe girth welds • Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance • High build, solvent free • Rapid drying and curing characteristics, allowing early completion of coating to recommended film thicknesses			
Approvals/ Certification	• Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection • Meets the performance requirements of BS EN 10290 and AWWA C222 • Malaysian SPAN approved • Approvals held in the former name of 'Acothane'			
Finish	Sheen			
Volume Solids	100%			
VOC Content	0 g/litre			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	1.0 mm	1.0 mm	1.0 m ² /litre
	Typical	1.5 mm	1.5 mm	0.67 m ² /litre
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated			
Drying Times	Applied to 1 mm DFT		+10°C	+20°C
	Dust Free		1 hr	30-45 min
	Hard Dry		4 hr	3 hr
	Overcoating	Minimum	1 hr	30 min
		Maximum	24 hr	24 hr
	Drying and recoating times are related to the substrate temperature			
Colours	Grey, Cream and special shades to order			
Mix Ratio/ Product Code	10WCT (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight			
Pot Life	Approx. 8 min at 25°C			
SG	1.29 kg/lit mixed			
Storage Conditions	Store in dry, cool conditions and protect from frost			
Shelf Life	Minimum 24 months if stored as above in unopened containers			
Flash Point	Above 60°C			

Corroless ACO Weldcoat

Issue Date: Aug 2020
Page 2 of 2

Surface Preparation	- All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		No	No	Yes	No
	This product is specifically designed for brush. Other Corroless ACO grades are available for spray application				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - Overcoating: normally after 1 hour and within 24 hours of initial application. Abrading will be required after 24 hours for adhesion - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - Corroless ACO Weldcoat has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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Corroless CCI 355

Corrosion Inhibitor

Issue Date: June 2020

Code: LC00355

Page 1 of 2

Product Description	A vapour phase corrosion inhibiting (VCI), extreme pressure, lithium grease which can be applied directly onto surfaces requiring continuous lubrication, in areas subject to heavy or shock loading.
Features & Use	• Protects by both contact and vapour action • Effective even when moisture, oil and rust are already present • Highly resistant to water and steam • Gives up to 3 years protection in aggressive environments • Contains molybdenum disulphide for improved load carrying properties • Will protect wire ropes, machinery and equipment both in operation and storage • Applications include chains, wire ropes, bearings, conveyors, spindles, open gearings, etc.
Approvals/ Certification	• NLG Classification 2 • Worked Penetration 265/295 • Operating Temperature -30°C to +130°C • Drop Point 180°C minimum
Finish	Matt Grease film
Volume Solids	Not Applicable. Grease Product
VOC Content	Not Applicable
Film Thickness and Coverage	Not Applicable
Drying Times	Not Applicable: Does not dry
Colour	Black
Mix Ratio	Single Pack
Pot Life	Not applicable
SG	0.97 kg/litre
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 24 months if stored as above in unopened containers
Flash Point	250°C

Corroless CCI 355

Issue Date: June 2020
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Surface Preparation	- No special surface preparation is required but the cleaner the substrate the more effective will be the protection achieved - For best results remove any dirt, grease, moisture or condensation prior to application. Where appropriate prepare heavily corroded steel surfaces using scrapers, wire brushes, needle guns etc. to St2 standard of EN ISO 8501-1:2007 or equivalent, wash down with clean fresh water and allow to dry before application
Mixing	Apply as supplied
Thinner / Cleaner	Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)
Application Conditions	Apply in good weather conditions. During application and drying the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.
Application Method	- CCI 355 is a corrosion inhibiting grease that can be applied to equipment either in service, shut down or in preservation situations - Apply as supplied by grease gun, by hand using a 'hairy mitt', or brush apply
Product Notes	- Application Temperature: Range 2°C-35°C - Overcoating: Not normally an issue but damaged areas can be repaired using fresh material. No maximum re-application time - Recommended substrates are steel and most other metallic substrates - Although CCI 355 does not normally require removal prior to recommissioning equipment, it can be easily removed by scraping and using conventional solvents such as Thinners No 2, white spirit or other suitable degreaser
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.

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