PRODUCT INFORMATION
COROFLAKE T PRIMER

PRODUCT DESCRIPTION
COROFLAKE T PRIMER is a two-component, low-viscosity primer based on a highly temperature resistant modified Novolac vinyl ester resin, that protects blasted surfaces from rust formation and corrosion creep.

FIELDS OF APPLICATION
COROFLAKE T PRIMER is used as a primer on properly pre-treated steel surfaces for the vinyl ester resin coating **COROFLAKE 29**.

FEATURES
- Easy to apply
- High temperature resistance
- Very good adhesion to steel
- Application by rolling, brushing or airless-spraying

SUBSTRATE
Substrates are components made of non-ferrous metals, cast materials, unalloyed or austenitic steel. The components must be designed and manufactured in accordance with EN 14879-1. The substrate must remain dry during application.

SURFACE PRE-TREATMENT
EN14879-1 and the TIP TOP specification "Corrosion protection of metallic components" must be observed. Unalloyed steel must be blasted to "Near White Metal" in accordance with EN ISO 12944-4. A surface preparation degree of SA 2½ according EN ISO 8501-1 and a roughness degree "Medium (G)" according EN ISO 8503-2 must be achieved. A minimum roughness depth of Rz ≥ 70 µm is required. After blasting, the formation of new rust should be prevented by suitable measures (e.g. priming).

CLIMATIC CONDITIONS
During application, direct or indirect sunlight must be avoided and the climatic conditions specified in the application instruction must be observed. To avoid condensation, a dew point difference of at least 3K must be maintained. During application, the materials must never be colder than the ambient temperature at the workplace.

MIXING RATIO
The primer materials are delivered to the construction site in mixing units so that there is no need to weigh or measure the individual components. After mixing a unit, it must be applied within the specified pot life.

Primer	Weight parts	Volume parts
COROFLAKE T PRIMER	100	100
HARDENER No. 1 CLEAR	2	2.1

APPLICATION METHOD | CONSUMPTION
Always observe the current application instruction before using the products. During priming work, direct or indirect sunlight must be avoided absolutely. The primer must be applied in a covering layer. The subsequent coating work can be carried out after the primer has hardened, according to the times in the "Recoat Time" table.

Product	Application	Thickness	Consumption
COROFLAKE T PRIMER	Roll / brush / airless spray	covering	ca. 150 g/m²

The consumption indicated is an average value. The actual consumption depends on the object geometry and the application method. It can therefore vary.

POT LIFE | RECOAT TIME

Product	Working time			Recoat time (20°C)	
	15°C	20°C	30°C	Min.	Max.
COROFLAKE T PRIMER	60 min	50 min	30 min	4 h	3 d

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CLEANING

All equipment should be cleaned with **SOLVENT T-200** immediately after use. The equipment should be cleaned in a well-ventilated area. It is recommended to flush the spraying equipment several times during the working day. The frequency of cleaning depends on the spray volume, temperature and elapsed time, including possible delays.

DELIVERY FORM | MINIMUM SHELF LIFE

Product	Packaging	Article No.	Storage temperature	Min. shelf life
COROFLAKE T PRIMER	5 kg	590 3035	5 - 20°C	4 Mon
COROFLAKE T PRIMER	20 kg	590 3033	5 - 20°C	4 Mon
HARDENER No. 1 CLEAR	0.1 kg	590 0181	5 - 20°C	12 Mon
HARDENER No. 1 CLEAR	0.4 kg	590 0019	5 - 20°C	12 Mon
SOLVENT T-200	4 kg	590 0610	5 - 25°C	60 Mon
SOLVENT T-200	8 kg	590 0611	5 - 25°C	60 Mon

SAFETY MEASURES

The safety data sheets for the individual components and the legal regulations for handling hazardous substances must be observed. The prescribed personal protective equipment must be worn. Information on disposal can be found in the safety data sheets for the individual products. The safety data sheets can be downloaded from our homepage in the download area.

PHYSICAL DATA

Properties	Standard	Unit	Value
Adhesive strength steel	EN ISO 4624 (ASTM D4541)	N/mm²	≥ 7
Density (mixture)	EN ISO 2811 (ASTM D1475)	g/cm³	1.06 ± 0.03
Polymer base	-	-	Vinyl ester
Viscosity	EN ISO 2555 (ASTM D2196)	mPa·s	350 ± 50

The specified temperatures depend on the existing load and can therefore vary.