PRODUCT INFORMATION
COROFLAKE 29 C

PRODUCT DESCRIPTION
COROFLAKE 29 C is a two-component, vapour diffusion resistant polymer coating filled with graphite flakes based on a chemically and thermally highly resistant modified Novolac vinyl ester resin. **COROFLAKE 29 C** achieves good electrical conductivity through the use of a graphite filler.

COATING BUILD-UP
The coating consists of the two-component primer **COROFLAKE T PRIMER** and at least one, usually two coats of the two-component topcoat **COROFLAKE 29 C**, each with a dry film thickness of approx. 400 - 600 µm. The total dry film thickness to be applied depends on the existing chemical and thermal stress and can be up to 2.0 mm.

FIELDS OF APPLICATION
Due to the special fillers, **COROFLAKE 29 C** is electrically conductive and can therefore be used in explosion-protected areas. **COROFLAKE 29 C** does not contain any silicate fillers and can be used under strong alkaline loads, e.g. in storage tanks for caustic soda. **COROFLAKE 29 C** is also used as a conductive layer under fluoroplastic fix point linings as well as conductive top layer for the **COROFLAKE 29**.

FEATURES
- Very high temperature resistance
- Electrically conductive
- Very good adhesion to steel
- Application by airless-spraying, rolling or brushing

CHEMICAL RESISTANCE
Requests for chemical resistance can be sent to awt@tiptop-elbe.de.

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 and coating 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

Coating / topcoat	Weight parts	Volume parts
COROFLAKE 29 C	100	100
HARDENER No. 1 CLEAR / RED	2	2.3

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APPLICATION METHOD | CONSUMPTION

Always observe the current application instruction before using the products. During coating work, direct or indirect sunlight must be avoided absolutely. If **COROFLAKE 29 C** is applied by rolling or brushing, at least the double number of top coats are required to achieve the specified total dry film thickness. Ground surfaces must be generally cleaned with **SOLVENT F12**.

Product	Application	Thickness	Consumption
COROFLAKE T PRIMER	Roll / brush / airless spray	covering	ca. 150 g/m²
COROFLAKE 29 C	Airless spray / roll / brush	400 - 600 µm	ca. 800 - 1000 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
COROFLAKE 29 C	90 min	60 min	30 min	4 h	3 d

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.

SPARK TEST

Due to its electrostatic properties (electrically conductive), the lining material cannot be tested for the absence of pores and cracks using high-voltage testers. The lining material is tested for pores and cracks by 100% visual inspection with optimum illumination.

Product	Test voltage
COROFLAKE 29 C	-

DELIVERY FORM | MINIMUM SHELF LIFE

Product	Packaging	Article No.	Storage temperature	Min. shelf life
COROFLAKE 29 C	5 kg	590 2100	5 - 20°C	3 Mon
COROFLAKE 29 C	20 kg	590 2110	5 - 20°C	3 Mon
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
HARDENER No. 1 RED	0.1 kg	590 0356	5 - 20°C	12 Mon
HARDENER No. 1 RED	0.4 kg	590 0112	5 - 20°C	12 Mon
SOLVENT F12	4 kg	590 0095	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

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SAFETY MEASURES
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	≥ 4
Bleeder resistance (to earth)	EN 1081	Ω	< 10^6
Density (mixture)	EN ISO 2811 (ASTM D1475)	g/cm³	1.21 ± 0.02
Max. Temperature dry (flue gases)	-	°C	+230
Max. Temperature for liquids	-	°C	+75
Polymer base	-	-	Vinyl ester
Shore hardness	ISO 48-4 (ASTM D2240)	Shore D	≥ 75
Viscosity	EN ISO 2555 (ASTM D2196)	mPa·s	3200 ± 250

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