PRODUCT INFORMATION
COROFLAKE 300

PRODUCT DESCRIPTION
COROFLAKE 300 is a two-component, solvent-free, filled polymer coating based on a chemically highly resistant Novolac epoxy resin.

COATING BUILD-UP
The coating consists of at least three layers of the two-component **COROFLAKE 300**, each with a dry film thickness of approx. 400 - 600 µm. A dry film thickness of ≥ 1.5 mm is required for storage tanks for concentrated sulphuric acid.

FIELDS OF APPLICATION
COROFLAKE 300 is mainly used for the protection of storage tanks or steel components against concentrated sulphuric acid up to +40°C.

FEATURES
- Excellent chemical resistance to sulphuric acid (70-98%) up to +40°C
- Solvent-free
- Very good adhesion to steel
- Application by airless-spraying
- Easy to apply

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.

Top coat	Weight parts	Volume parts
COROFLAKE 300 COMP. A	100	100
COROFLAKE 300 COMP. B	40	43.5

APPLICATION METHOD | CONSUMPTION
Always observe the current application instruction before using the products. During coating work, direct or indirect sunlight must be avoided absolutely. When exposed to the weather, the tendency of epoxy resin coatings to chalk should be noted, especially with light colours. Exposure to sulphuric acid will cause discolouration of the coating. The terra colour should therefore always be used for the final top coat.

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Product	Application	Thickness	Consumption
COROFLAKE 300	Airless spray / roll / brush	400 - 600 µm	ca. 500 - 750 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 300	50 min	35 min	20 min	12 h	7 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

The spark test is carried out in accordance with EN 14879-2 using a high-voltage tester. The previously measured average dry film thickness is the basis for the test voltage. The test is carried out at the earliest 24 hours after finishing the top coat at a curing temperature of +20°C.

Product	Test voltage
COROFLAKE 300	0,5 kV / 100 µm DFT

DELIVERY FORM | MINIMUM SHELF LIFE

Product	Packaging	Article No.	Storage temperature	Min. shelf life
COROFLAKE 300 COMP. A - BEIGE	18 kg	590 2320	5 - 25°C	12 Mon
COROFLAKE 300 COMP. A - TERRA	18 kg	590 2300	5 - 25°C	12 Mon
COROFLAKE 300 COMP. B	7.2 kg	590 2340	5 - 25°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
Max. Temperature dry (flue gases)	-	°C	+95
Max. Temperature for liquids	-	°C	+60
Shore hardness	ISO 48-4 (ASTM D2240)	Shore D	≥ 82

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

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Information given in the fact sheet above corresponds to the current knowledge available to us regarding our products at the time of its drafting and is intended as a guideline for informational purposes. However, because of the multiple possibilities regarding possible applications, processing and on site conditions, any information given in the fact sheet above is not legally binding, in particular, without being limited to, such information shall not be interpreted as a warranty of merchantability or of fitness for a particular purpose. Customer therefore is advised to conduct its own testing or make an inquiry with our technical department before ordering. We reserve the right to change the product at any time, in particular, without being limited to, minor changes because of advancements in technology. If by way of exception, the information given in the fact sheet above is incorporated by reference into any contract concluded with us under German Law, such information, shall only be interpreted as determining the specific requirements of the contractual products as set out in § 434 BGB (German Civil Code) and shall not be interpreted as constituting a guarantee of condition.