

- TYPE:** A three-pack cold cured vinyl ester - urethane copolymer to be used in conjunction with glass or similar fibre reinforcement.
- SUGGESTED USE:** As a laminating resin for fibre reinforcement in environments where good chemical and temperature resistance is required.
- LIMITATIONS:** This product is very moisture sensitive and may foam if mixed or applied in moisture condensing conditions, or at relative humidities above 75%. Tins are nitrogen filled, **do not open before use.** It is recommended that where possible de-humidification equipment is used during the application of this product.
- HEALTH & SAFETY:** Before handling or using this product the material safety data sheet should be read and all precautions observed. Particular attention is drawn to Hardener B which contains Isocyanate.
- APPLICATION EQUIPMENT:** Fluid bath, spray, roller or brush.
- APPLICATION:** Ensure fibres of reinforcement are fully soaked, preferably prior to application. Ensure any air pockets are removed by using a spiked or ridged roller. Area fully wetted should be uniform in colour with no white or light coloured areas.
- MIXING RATIOS:**
88.55 parts Base
01.58 parts Hardener A (organic peroxide)
09.87 parts Hardener B (Isocyanate)
(All ratios by weight)
- MIXING INSTRUCTIONS:** Product should be at ambient temperature before mixing. Mix the base with a good mechanical stirrer until it is uniformly mixed. Add Hardener A (organic peroxide) to the Base and mix thoroughly. Allow mix to stand for a minimum period of 10 minutes. Thoroughly stir the Base/peroxide mix again and leave to stand for a further minimum period of 10 minutes (NB. The Base/peroxide blend is relatively stable and will not react significantly until Hardener B is added). Add Hardener B (Isocyanate) and mix thoroughly before applying.
- POT LIFE:** 25-30 Minutes at 20°C. Will vary dependent upon temperature. Refer to Corrocoat technical services for instructions regarding application in hot climatic conditions.
- THINNERS:** The performance of Corrothane XT Laminating Resin will be adversely affected by the addition of solvent thinners and their use is **prohibited.**
- PACKAGING:** 1, 5, 10 composite kits. Due to the hygroscopic nature of this product the use of part tins is not recommended, suitable kit sizes should be purchased to meet usage requirements.

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| STORAGE LIFE: | 4 Months stored and away from heat sources and direct sunlight and below 20°C . Frequent temperature cycling will shorten storage life and affect pot life. Beyond 4 months this product becomes increasingly susceptible to moisture uptake and gassing and therefore out of shelf-life material must not be used . (Some discolouration of the hardener B will occur with time, this has no detrimental effects on the material, all materials must be used within their designated shelf lives). |
| COLOUR AVAILABILITY: | Unpigmented (translucent brown) only. |
| VOLUME SOLIDS: | This material contains volatile liquid convertible to solids. Volume solids obtained will vary dependent upon polymerisation conditions. Nominally 99% of the contents are convertible to solid. |
| FLASH POINT: | 31°C |
| TEMPERATURE LIMITS: | 150°C Immersed. No known lower limit. 250°C Non-immersed (provisional figures) |
| OVERCOATING: | It is recommended that over coating takes place within a maximum of 12 hours at 20°C. Although longer over coating times may be acceptable this will depend upon climatic conditions and the level of ultraviolet light that can significantly accelerate speed of cure. |
| CURING TIME: | Full cure circa 4 days at 20°C. For best results a short post cure of 4 to 12 hours at 80°C is recommended. However, post cure is not necessary for many environments. |
| SPARK TESTING: | This product is subject to dielectric fatigue and repeated testing should be avoided, refer to data sheet 7/30 |
| CLEANING FLUID: | Methyl Ethyl Ketone, Methyl Iso Butyl Ketone - before gelation. |

These materials are fire hazardous. Observe safety regulations.

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

THIS DATA IS UNDER CONSTANT REVIEW AND MAY CHANGE

Reviewed 08/2011
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