Corroless M

Multi-metal Primer

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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	+30°C
Dust Free		2 hr	1 hr	½ hr
Hard Dry		24 hr	16 hr	12 hr
Overcoating	Minimum	24 hr	16 hr	12 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	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 Protective Coatings, Kelvin Way, West Bromwich, West Midlands B70 7JZ, United Kingdom

Telephone: +44 (0)121 524 2235
Fax: +44 (0)121 553 2787
Web: www.corroless.com
e-mail: info-corroless@axalta.com

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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 3ºC above the dew point. Paint temperature should ideally be at a minimum of 15ºC
Application Methods	<table><tr><th>Method</th><th>Airless Spray</th><th>Conventional Spray</th><th>Brush</th><th>Roller</th></tr><tr><td></td><td>Yes</td><td>Yes - thinning required</td><td>Yes</td><td>Yes</td></tr></table> • **Airless spray**: output fluid pressure 2000 psi, tip size 17-19 thou Fan Angle 30-50º. 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 rollering**, 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 2ºC-35ºC. Curing will be retarded below 10ºC - product will cure down to 2ºC 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 18ºC 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.