

## COROFLAKE 24 MR Mat Reinforced Flake Filled Vinyl Ester Lining

### PRODUCT DESCRIPTION

**COROFLAKE 24 MR** is a fiberglass mat reinforced, chemical resistant lining based on Vinyl Ester resin and incorporating an inert flake filled topcoat.

### LINING LAYERS COMPOSITION

The lining system consists of a primer, trowel applied basecoat, one layer of 1.5 oz. fiberglass mat as reinforcement and a flake filled topcoat. The applied thickness range of the lining system is 80-120 mils (2.0-3.0 mm) DFT.

### FIELDS OF APPLICATION

**COROFLAKE 24 MR** has excellent resistance to acids, alkalis and bleach solutions. It is an ideal protective lining for concrete and steel structures in process and storage areas including tanks, vessels, trenches, pits, vaults, dikes, process floors and secondary containment.

**Note:** For secondary containment applications the troweled basecoat may not be necessary. Consult RCC Corrosion Control for specific recommendations.

### FEATURES

- Meets compliance requirements of **FDA 21 CFR 175.300** for repeated direct food contact
- Excellent chemical & permeation resistance
- Mat reinforcement provides structural support
- Outstanding adhesion to steel and concrete
- Long term service

### CHEMICAL RESISTANCE

Information on the chemical resistance properties is available upon request.

### SURFACE PRE-TREATMENT

#### Carbon steel

For immersion or frequent spillage conditions, abrasive blast to "White Metal" in accordance with SSPC SP-5, NACE Specification #1 or SA 3. For fumes or occasional spill exposure and dry environments, abrasive blast to "Near White" in accordance with SP-10, NACE #2 or SA 2 1/2. A minimum surface profile of 3 mils (75 µm) is required. Refer to specification, RCC TT-14. After blast cleaning the steel surface shall be primed before the formation of any rust bloom.

#### Concrete

The concrete shall have a minimum compressive strength of 3500 psi (25 N/mm<sup>2</sup>) and a minimum surface strength of 200 psi (1.4 N/mm<sup>2</sup>) for coatings and 300 psi (2.1 N/mm<sup>2</sup>) for linings. The concrete must be thoroughly

cured and dry at the time of application. The residual moisture content should not exceed 4%. ASTM D 4263 plastic sheet test method is recommended to ensure concrete is moisture free. If moisture is detected, repeat test until dry.

Abrasive blast or mechanically abrade surface to remove the weak laitance and surface contaminants. Refer to specification, RCC TT-3 for details.

### APPLICATION

- Prime the substrate with **COROFLAKE N PRIMER U** and allow the primer to cure.
- Trowel apply the Basecoat mixture of **TOPLINE 664 VE Resin, Hardener No. 1 Clear** and **F-1 Filler** in a uniform layer at 60 mils (1500 µm) WFT.
- Immediately upon placement of the Basecoat (while it is still wet), the 1.5 oz. fiberglass mat is pressed onto the surface, then saturated and rolled with the mixed **TOPLINE 664 VE Resin** and **Hardener No. 1 Clear**. A ribbed roller is used to remove entrapped air. Allow the mat/cloth layer to cure.
- Spray or roller apply the topcoat mixture of **COROFLAKE 24 VE Resin** and **Hardener No.1 Clear**. One or two topcoats may be specified.

**Note:** During application the lined surface should be shaded from direct or indirect sunlight when possible.

### MIX RATIO

**Hardener No. 1 Clear** is used with each resin component at 1.5-2.5 oz. hardener per gallon of resin by volume.

### CONSUMPTION

Layer	Thickness mils (µm)	Coverage (Mix Ratio)
PRIMER on steel	2-5 (50-125)	250-300 ft <sup>2</sup> /gal
PRIMER on concrete	2-5 (50-125)	160-200 ft <sup>2</sup> /gal
BASECOAT		
TOPLINE 664 VE Resin & Hardener No.1 Clear	60	45-50 ft <sup>2</sup> /gal
F-1 Filler	(1500)	(1.5-2.5 oz/gal of resin) 100ft <sup>2</sup> /50 lb bag (20-25 lb/gal of mixed resin)
REINFORCEMENT		
TOPLINE 664 VE Resin & Hardener No.1 Clear	35	34-38 ft <sup>2</sup> /gal
1½ oz. Mat	(875)	(1.5-2.5 oz/gal of resin) 1.1 x surface area
TOPCOAT		
COROFLAKE 24 VE Resin & Hardener No.1 Clear	18	50-70 ft <sup>2</sup> /gal
	(450)	(1.5-2.5 oz/gal of resin)

## WORKING TIME & RECOAT TIME

Temperature	Working Time	Min Recoat	Max Recoat
50°F (10°C)	approx. 90 min	12 hrs	14 days*
70°F (21°C)	approx. 60 min	6 hrs	14 days*
90°F (32°C)	approx. 30 min	3 hrs	7 days*

\* Maximum when area is shaded. If exposed to direct or indirect sunlight, maximum recoat time is 7 days @ 70°F (21°C).

## CURE TIME (to place in service)

Temperature	Minimum Cure time
50°F (10°C)	72 hrs
70°F (21°C)	48 hrs
90°F (32°C)	24 hrs

Generally **COROFLAKE 24 MR** can be placed in service after the final cure time intervals have been achieved. Shorter or longer intervals may apply depending on service conditions. Consult RCC Corrosion Control for specific recommendations.

## CLEANING: Cleaning Agent T-100

## SAFETY MEASURES

The material safety data sheets of the individual components as well as the legal requirements for handling hazardous materials must be observed.

Technical Data	Testing Standard	Unit	Value
Density - Basecoat	ASTM D1475	lbs/gal (kg/l)	8.74±0.25 (1.05)
Density - Topcoat	ASTM D1475	lbs/gal (kg/l)	9.57±0.25 (1.15)
Viscosity (Brookfield) - Topcoat	ASTM D2196	Cps (mPa·s)	3250 ± 250
Modulus of Elasticity (Bend Test)	ASTM D790	psi MPa	500K – 551K 3500 – 3800
Tensile Strength – Reinforcement Layer	ASTM D638	psi MPa	10,875 75
Abrasion	ASTM D4060	mg	90
Compressive Strength	ASTM C579	psi	7800
Adhesion Strength - Concrete	ASTM D7234	psi N/mm <sup>2</sup>	Exceeds concrete strength
Minimum Adhesion Strength - Steel	ASTM D4541	psi N/mm <sup>2</sup>	1000 7
Linear Coefficient of Thermal Expansion	ASTM C531	in/in°F cm/cm°C	14-17 x 10 <sup>-6</sup> 25-30 x 10 <sup>-6</sup>
Volatile Organic Compounds (Basecoat – TOPLINE 664 VE)	EPA Method 24	g/L (lbs/gal)	110 (0.92)
Volatile Organic Compounds (Basecoat – COROFLAKE 24 VE)	EPA Method 24	g/L (lbs/gal)	152 (1.27)
Maximum Operating Temperature*	Immersion Steel Immersion Concrete Splash/Spill Concrete	°F °C °F °C °F °C	150 65 180 82 200 93

\*Maximum operating temperature limits may vary depending on actual service conditions

We warrant that our goods will conform to the description contained in the order and that we have good title to all goods sold. This Product Data Sheet is considered accurate and reliable to the best of our knowledge at the date of its publication, but are used as guides only. The user assumes all risks and liabilities in connection therewith regardless of any suggestion, we may give. We assume no liability for performance of the product or for any loss or damage resulting from its use. Our liability, in law and equity, shall be expressly limited to the replacement of non-conforming goods at our factory, or at our sole discretion, to repayment of the purchase price of the non-conforming goods.

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## PACKING UNITS

The products are supplied in the following standard package sizes:

Description	Package Size
COROFLAKE N PRIMER U	1, 4, 50 gal kits
TOPLINE 664 VE	1, 4, 50 gal kits
1.5 oz. Fiberglass Mat	Sq. ft.
F-1 Filler	50 # bag
COROFLAKE 24 VE	1, 4, 25 gal kits

## STORAGE

The materials must be stored in a cool and dry place. At storage temperature of 70°F (21°C) the shelf life is as follows:

<b>COROFLAKE N PRIMER U Resin</b>	6 months
<b>TOPLINE 664 VE Resin</b>	6 months
<b>COROFLAKE 24 VE Resin</b>	6 months
<b>Hardener No. 1 Clear</b>	12 months
<b>F-1 Filler, 1.5 oz. Mat</b>	Indefinite, if kept dry

If the storage time is exceeded, the materials must be tested before use. Higher storage and transport temperatures will reduce the shelf life. The containers must be kept tightly closed. Liquid products must be stored frost-proof.