Product Data Sheet

RCC CORROSION CONTROL

COROFLAKE 24AR VE
Abrasion Resistant Vinyl Ester Topcoat

PRODUCT DESCRIPTION
COROFLAKE 24AR VE is a two-component, abrasion resistant coating based on Vinyl Ester resin. **COROFLAKE 24AR VE** is applied as a topcoat/finish coat to protect steel and concrete structures against a wide range of acids, alkalis and bleach solutions, in abrasive environments.

COATING LAYERS COMPOSITION
The coating system consists of the two-component **COROFLAKE 24AR VE**. It is typically applied at 15-20 mils (375-500 µm) DFT per coat as a topcoat or finish coat over a wide range of compatible vinyl ester lining and coating systems from RCC Corrosion Control. Higher single coat thickness up to 40 mils (1000 µm) DFT can be achieved by spray application when required. Consult RCC Corrosion Control for specific recommendations. Standard coating colors are white and grey.

FIELDS OF APPLICATION
COROFLAKE 24AR VE provides corrosion and abrasion resistant protection for concrete and steel structures in process and storage areas. Applications include protection in tanks, vessels, trenches, pits, process floors and secondary containment at chemical plants, power plants and other industries where abrasive chemical processes exist.

FEATURES
- High abrasion resistance
- Excellent chemical resistance
- Easy to apply
- Incorporates FDA compliant resin
- Can be exposed to process conditions shortly after application

CHEMICAL RESISTANCE
Information on the chemical resistance properties is available upon request.

SURFACE PRE-TREATMENT
Prior to the application of **COROFLAKE 24AR VE**, the base lining/coating system application shall have been completed and quality control tested. The surface to receive **COROFLAKE 24AR VE** must be clean, dry and have not set longer than the recommended recoat interval for the last applied layer of the base lining/coating. The surface can be tested for styrene sensitivity to confirm it is suitable for recoating. Rub a small area of the base lining/coating surface with a clean rag or finger dampened with styrene. If the surface becomes tacky it is deemed styrene sensitive and suitable for recoating. If the surface does not become tacky it must be uniformly prepared for recoating by mechanical abrading or abrasive blasting prior to application of **COROFLAKE 24AR VE**.

APPLICATION
Refer to the individual product information sheets for the application of the primer and base lining or coating system being used. **COROFLAKE 24AR VE** is applied by airless or conventional spray, by brush or roller.

The typical target thickness of **COROFLAKE 24AR VE** should be 18 mils (450 µm) per coat with a range of 15-20 mils (375-500 µm). When a higher single coat thickness by spray application is required, consult RCC Corrosion Control for specific recommendations.

Application by roller or brush may require additional coats to achieve the total recommended thickness.

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

MIX RATIO
The mixing ratio of **Hardener No. 1 Clear or Red** to **COROFLAKE 24AR VE Resin** is 1.5-2.5 oz. per gallon by volume.

The coating components are supplied in premeasured units so that weighing or measuring of the components is kept to a minimum.

CONSUMPTION

Layer	Thickness mils (µm)	Coverage
COROFLAKE 24AR VE	15-20 (375-500)	50-70 ft^2/gal

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 24AR VE** 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.

PACKING UNITS

The products are supplied in the following standard package sizes:

Description	Package Size
COROFLAKE 24AR 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:

COROFLAKE 24AR VE Resin 6 months
Hardener No. 1 Clear & Red 12 months

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.

Technical Data	Testing Standard	Unit	Value
Density	ASTM D1475	lbs/gal kg/l	10.22±0.25 1.22
Viscosity (Brookfield)	ASTM D2196	cps mPa·s	3250 ± 250
Modulus of Elasticity (Bend Test)	ASTM D790	Psi MPa	435,000 2,500 – 3,500
Tensile Strength	ASTM D638	Psi MPa	2900 20
Abrasion	ASTM D4060	mg	20
Linear Coefficient of Thermal Expansion	ASTM C531	in/in°F cm/cm°C	15-17 x 10^{-6} 27-30 x 10^{-6}
Volatile Organic Compounds	EPA Method 24	g/L (lbs/gal)	213 (1.78)
Maximum Operating Temperature* Immersion-Steel and Concrete (Dependent on the Base Coating or Lining System) Continuous Dry Splash/Spill Concrete		F °C F °C F °C	130-180 54-82 (Typical) 300 149 200 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.