Product Data Sheet

RCC CORROSION CONTROL

COROFLAKE 24C VE
Graphite Flake Filled Vinyl Ester Coating

PRODUCT DESCRIPTION
COROFLAKE 24C VE is a two-component, graphite filled Vinyl Ester resin based coating/lining system. The flake-like structure of the graphite results in a high permeation resistance and good electrical conductivity.

COATING LAYERS COMPOSITION
The coating system consists of a **COROFLAKE PRIMER (N PRIMER U** or the conductive **C PRIMER VE**) normally followed by two coats of **COROFLAKE 24C VE** at a thickness range of 15-20 mils (375-500 µm) DFT, target 18 mils (450 µm) DFT per coat. Total applied thickness is 30-40 mils (750-1000 microns) DFT with a target of 36 mils (900 microns) DFT. **COROFLAKE 24C VE** can be used as a standalone system or as a topcoat over other vinyl ester linings and coatings from RCC Corrosion Control.

FIELDS OF APPLICATION
COROFLAKE 24C VE exhibits excellent resistance to acids, hot caustic and strong bleach solutions. . **COROFLAKE 24C VE** is an ideal corrosion protection material for concrete and steel structures in process and storage areas. Applications include protection in tanks, vessels, trenches, pits, vaults, dikes, secondary containment areas and floors where electrical conductivity is required.

FEATURES
- Excellent resistance to bleach solutions
- Excellent resistance to acids and caustic
- Electrically conductive & non-sparking
- Excellent permeation resistance
- Quick turn-around

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 microns) 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/mm²) and a minimum surface strength of 200 psi (1.4 N/mm²) for coatings and 300 psi (2.1 N/mm²) 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
The primer and coating can be applied by airless or conventional spray, roller or brush.
The target thickness for **COROFLAKE 24C VE** should be 18 mils (450 microns) DFT per coat with a range of 15-20 mils (375-500 microns) DFT. The total coating thickness with two coats should be approximately 36 mils (900 microns) DFT with a range of 30-40 mils (750-1000 microns) DFT.

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
Hardener No. 1 Clear is used for the **Primer** as well as for the **COROFLAKE 24C VE**. The mixing ratio of hardener to resin for primer and coating is 1.5-2.5 oz. per gallon of resin by volume. The primer and coating components are supplied in premeasured units to minimize weighing or measuring of the components.

CONSUMPTION

Layer	Thickness mils (µm)	Coverage
PRIMER on Steel	2-5 (50-125)	250-300 ft²/gal
PRIMER on Concrete	2-5 (50-125)	160-200 ft²/gal
CONDUCTIVE PRIMER	2-5 (50-125)	140-160 ft²/gal
COROFLAKE 24C VE	15-20 (375-500) per coat	50-70 ft²/gal per coat

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 24C 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 N PRIMER U	1, 4, 50 gal kits
COROFLAKE C PRIMER VE	1, 4, 50 gal kits
COROFLAKE 24C 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 N PRIMER U Resin	6 months
COROFLAKE C PRIMER VE Resin	6 months
COROFLAKE 24C VE Resin	4 months
Hardener No. 1 Clear	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)	9.98 ± 0.25 (1.2)
Viscosity (Brookfield)	ASTM D2196	Cps (mPa·s)	3250 ± 250
Modulus of Elasticity (Bend Test)	ASTM D790	psi MPa	507 K – 650 K 3,500 – 4,500
Abrasion Resistance	ASTM D 4060	mg	70
Adhesion Strength - Concrete	ASTM D7234	psi N/mm²	Exceeds concrete strength
Minimum Adhesion Strength - Steel	ASTM D4541	psi N/mm²	500 3.5
Electrical Properties	Megger Reading	ohms	5,000-250,000
Linear Coefficient of Thermal Expansion	ASTM C531	in/in°F cm/cm°C	17 x 10^{-6} 30 x 10^{-6}
Water Vapor Permeability	ASTM E-96, Procedure E	perm-inch	0.0024
Volatile Organic Compounds	EPA Method 24	g/L (lbs/gal)	167 (1.39)
Maximum Operating Temperature*			
Immersion Steel		°F °C	130 54
Immersion Concrete		°F °C	140 60
Splash/Spill Concrete		°F °C	200 93
Continuous Dry		°F °C	300 149

***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.