

Product reference: 1/14

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Product title: 600 Laminating Resin

Valid from: 27th November 1997

Last reviewed: 31 May 2019

Type

A two-pack cold cured Vinyl Ester Laminating Resin.

Suggested use

Use in conjunction with multi-directional roving to construct glass reinforced laminate and repair severely corroded and pitted areas or to offer additional protection in the corners of tankage prior to spray application. See Corrocoat Data Sheets TC1.

Limitations

Not suitable as a protective coating without glass reinforcement and at films less than 3mm. It is suggested that where this product is used for lamination protection systems a top layer of Polyglass VE at 500 microns is applied to reduce permeation.

Health & safety

Before handling this product the material Health & Safety Data Sheet for 600 Series should be consulted and all precautions observed. Only to be applied by competent, adequately trained personnel.

Surface preparation

Metal Surfaces: Grit blast to ISO 8501-1 Sa 2½ or near 3 standard or equivalent. For full details refer to Corrocoat Data Sheet SP1. The laminate will typically be applied over a primed surface.

Application equipment

Brush or roller.

Mix ratio

98:2 Base:Hardener.

Pot life

Variable with temperature.
At 20°C approximately 20-30 minutes.

Thinners

The performance of 600 Laminating Resin may be adversely affected by the addition of solvent thinners (e.g. Xylene) and their use is prohibited. Should thinning be necessary use only styrene monomer to an absolute maximum of 5% by volume concentration.

Packaging

20 Litre and 5 Litre pails.

Storage life

6 Months stored at temperatures below 24°C and away from direct light and sources of heat.

Colour

Translucent brown.

Recommended DFT

Dependent upon application and quantity of roving used.

Volume solids

99.5% solvent free.

Practical spreading rate

Dependent on roving used.

CORROGLASS

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Specific gravity

600 Laminating base 1.065 gms/cc.

Catalyst type

Methyl Ethyl Ketone Peroxide: Corrocoat Type P2.

Overcoating

May take place as soon as the previous coat has gelled and whilst still tacky. Maximum overcoating time 72 hours.

Please note: Maximum levels refer to ambient temperature of approximately 20°C. At higher temperatures the maximum overcoating time will reduce significantly.

Once the maximum overcoating time has been reached, the adhesion values attained by any subsequent coat will reduce dramatically. It is important to observe maximum overcoating times and note these will vary with climatic conditions. Any further application of coating at this juncture should be treated as a repair, with the surface flashed over to provide a physical key. Styrene cannot be used to reactivate the surface and may in some cases impair adhesion.

Cure time

Full cure will be obtained in 4-6 days.

Cleaning solvent

Acetone, Methyl Ethyl Ketone and Methyl Iso Butyl Ketone prior to gelation.

Physical properties

Property	Unreinforced Castings	Glass Mat Reinforced Laminates
Tensile Strength	73 MPa	111 MPa
Tensile Modulus	3.5 MPa	10100 MPa
Tensile Elongation	4%	1.3%
Flexural Modulus	3.8 MPa	9800 MPa
Flexural Strength	133 MPa	205 MPa
Average Coefficient of Linear Expansion	$53 \times 10^{-6} \text{ } ^\circ\text{C}^{-1}$	

Note

(1) All test results shown at 20°C/

Results will vary depending upon temperature, degree of cure, percentage of glass and quality of workmanship.

Reviewed 10/2007 (No changes)

Reviewed 02/2014 (No changes)

Reviewed 02/2016

Revised 05/2019

All values are approximate. Physical data is based on the product being in good condition before polymerisation, correctly catalysed and full cure being attained. Unless otherwise stated, physical data is based on a test temperature of 20°C, test results may vary with temperature. Information regarding application of the product is available in the Corrocoat manual. Should further information be required, please consult Corrocoat Technical Services.