

Corroless S

Rust Stabilising Primer

 Issue Date: June 2020
 Code: LS00001/2
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Product Description	A general purpose, single pack, rust stabilising primer.				
Features & Use	<ul style="list-style-type: none"> • Over 30 years track record in corrosion control • Excellent wetting properties • Designed to penetrate firmly adhered rust • Will withstand operating temperatures up to 200°C • Ideal for general maintenance • Contains Corroless Pigment • Applications include, tank exteriors, jetties, bridges, street furniture and other structural steel • NOT suitable for application onto galvanised steel 				
Approvals/ Certification	<ul style="list-style-type: none"> • NATO Stock Numbers: Corroless S1 H1 9010 99 220 3622 Corroless S2 H1 8010 99 220 3621 • Sold on track record and customer recommendation 				
Finish	Low gloss				
Volume Solids	44% ± 2%				
VOC Content	S1: 310 ± 20 g/litre S2: 411 ± 20 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	35 µm	80 µm	12.6 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 35 microns DFT	+10°C	+18°C	+30°C	
	Dust Free	4 hr	2 hr	1 hr	
	Hard Dry	6 hr	4 hr	2 hr	
	Overcoating	Minimum	6 hr	4 hr	2 hr
		Maximum	9 days	7days	3 days
Colours	S1 - Red Brown S2 - Buff				
Mix Ratio	Single Pack				
Pot Life	Not applicable				
SG	1.26				
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	Above 60°C				

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<p>Surface Preparation</p>	<ul style="list-style-type: none"> 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: Steel Manual Preparation: Prepare using rust scrapers, chipping hammers, needle guns, wire brushes etc. to St2 standard of ISO 8501-1:2007 or equivalent. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams. Wash down with clean fresh water and allow to dry before coating Mechanical preparation: Blast clean to minimum Sa1 standard of EN ISO8501-1:2007 or equivalent with a surface profile of 50 to 75 microns. Wash down with clean fresh water and allow to dry New Steel: All mill scale must be removed prior to application Before coating all surfaces should be firm, clean dry and free from oil, grease, powdery flash rusting and other contamination 										
<p>Mixing</p>	<p>Stir thoroughly before use</p>										
<p>Thinner / Cleaner</p>	<p>Corroless Thinners No.2 (Solvent Gun Wash may be used for cleaning only)</p>										
<p>Application Conditions</p>	<p>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 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>										
<p>Application Methods</p>	<table border="1" data-bbox="443 1037 1493 1176"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes- thinning required</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless spray: output fluid pressure 3500-4000 psi, tip size 17-21 thou (0.43-0.53mm). For detailed advice contact Corroless Conventional Spray An addition of up to 10% Corroless Thinners No.2 will be required Brush: apply unthinned, lay on, do not over brush. When rolling, use a short nap lamb's wool roller and a maximum addition of 5% Corroless Thinners No.2. Lay off with a brush to complete the finish 	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes- thinning required	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	Yes- thinning required	Yes	Yes							
<p>Product Notes</p>	<ul style="list-style-type: none"> Application Temperature: Range 2°C-35°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself Corroless SHB, or Corroless RF16. If overcoating time is exceeded and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing If maximum overcoat times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing 										
<p>Health & Safety</p>	<p>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.</p>										

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