

PRODUCT DATA SHEET

CORROBLOCK

Fast drying anti-corrosion undercoat

DESCRIPTION Fast-drying paint with an anti-rust effect suitable for preventing corrosion of ferrous products. Excellent as a primer for over-spraying with fast-drying enamels, with alkyd enamels and with polyurethane enamels. Formulated with special resins in the solvent phase and passivating pigments based on zinc phosphate, it is suitable for the prevention of corrosion of iron and galvanized iron supports, and due to its excellent adhesion it is suitable as a primer for the adhesion of aluminum and light alloys supports. Characterized by excellent substrate wetting, excellent adhesion, hardness and flexibility, it resists unaltered to natural stresses due to the dimensional variation of the substrate with varying climatic conditions. Easy to apply, it offers a solid anchoring to the enamels and enhances its covering power as it has an excellent filling power, excellent distension and coverage.

USE It is suitable for the protection of steel structures, such as carpentry, fixtures, railings, barges, tanks, agricultural equipment, new or undergoing iron maintenance, subjected to the action of particularly aggressive and corrosive agents in a rural, marine and industrial atmosphere. The recommended thickness for good protection and to be established according to the aggressiveness of the environment and the application should always be performed on a perfectly clean support. The preheating of the product at about 30 ° C gave good results by improving drying, covering the edges and allowing applications of greater thicknesses for each layer.

PROPERTY OF THE PRODUCT	VALUE	METHOD
Application temperature	<+120 °C	
Flash point	27°C	
Solids (volume)	60% ±2	
VOC	425 g/l	
Gloss 60°	<15	Internal PF6
Adhesion: ISO 2409	0	
Impact resistance: UNI 8901	>1 Kg/20cm	UNI EN ISO 2409
Bending resistance: UNI 1519	unchanged with spindle 10mm	UNI EN ISO 1519

SPECIFICATION DATA	VALUE	METHOD
Specific weight	1250-1350 g/l	Internal PF3
Drying Time	Overcoatable 24 h Complete 5 days	Internal PF2

FILM THICKNESS AND SPREADING RATE	Minimum	Maximum	Typical
Film thickness, dry, µm	40	80	60
Film thickness, wet, µm	70	135	100
Theoretical spreading rate, m ² /l	14,3	7,4	10
Theoretical spreading rate, m ² /kg	11	5,7	7.7

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STORAGE Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

COLOUR RANGE The range of colours can be chosen in shades of RAL. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.

SURFACE PREPARATION The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.
A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself.

HOT GALVANIZED STEEL

It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then proceed with a light sanding to remove the superficial oxidation patina formed and degrease the surfaces with Nitro NV 5000 thinner. Alternatively, a light silica sandblasting is recommended.

ALUMINUM AND LIGHT ALLOYS

Perform a light sanding with P180 P220 sanding paper. Clean the surface to be treated with Nitro NV 5000 thinner and make sure it is dry and free from silicone, waxes, greases and foreign substances in general.

NEW STEEL

The surface must be clean and dry, free of greasy oils and other contaminants. Sa2,5 sandblasting ensures the best anticorrosive performance;

SURFACES TREATED WITH SHOP PRIMER

If intact, clean and free from dirt, oil, grease, salts and dry it can be painted otherwise perform the preparation as for coated surfaces.

COATED SURFACE

With primer: it can be painted if the substrate is clean and free of dirt, oil, grease, and the application falls within the maximum re-coat time of the primer. If cleaning is required, perform pressure washing grade Wa 2 (surface free of oil, grease, salt, dirt).

With complete finishing coat: if undamaged compatible and non-chalky perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts.

Rusty coating: perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then restore the thickness of primer.

Localized maintenance: perform mechanical preparation St2 or St3 followed by

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pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.

TOOLS

Conventional or airless spray: Nitro NV 5000 (with high temperature and humidity <40% it is possible the formation of "dusting"); in this case use Diluente fast drying, roller, brush with Diluente S 800.

APPLICATION DATA

Thinning	Conventional spray, airless: 5-10% with Diluente Nitro NV5000. Brush, Roller: 5-10% Diluente S800
Conditions during application	+5°C +30°C >3°C at dew point Relative humidity:< 65%
Guiding data airless spray	Pressure at nozzle:15 MPa (150 kp/cm ² , 2100 psi). Nozzle tip: 0,28 - 0,38mm (0,011 - 0,018") Spray angle: 40 - 80° Air pressure: compression ratio 30:1 (pressure 150-180 kg/cm ²)
Application by conventional spray	Nozzle: 1,6 - 1,8mm Spray angle; 40 - 80° Air pressure: 3,5-4 kg/cm ²
Washing thinner	Diluente Nitro NV 5000

DRYING TIME

Drying times are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. High thicknesses per coat and unfavorable environmental conditions slow down the drying and hardening depth.

DTF 50 µm	
Substrate temperature	23°C
Surface dry	30'
Through dry	1h
Cured	5 days
Dry to recoat, minimum	24h

RECOMMENDED TOPCOAT

Fast drying enamels: Supersinteol Rapido, RE30, RE IND;
 Synthetic enamels: Gladium, Eno, Sinto 26
 Micaceous iron enamels FER RE GG16, FER GG11.
 Polyurethane enamels PUR TOP

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TYPICAL SYSTEM

Product	Layer	Wet Thickness	Dry thickness
Corrobblock	1	100	60
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RE 30	1	90	50
Totale	3	290	170

ALTERNATIVE SYSTEM

Product	Layer	Wet Thickness	Dry thickness
Corrobblock	1	100	60
Fer RE GG 16	1	90	50
Totale	2	190	110

INSTRUCTIONS

To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23°C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary.

This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.