

## PRODUCT DATA SHEET

**CORROBLOCK**
**Fast drying anti-corrosion undercoat**
**PRODUCT DESCRIPTION**

Paint with rust inhibiting effect ideal for preventing the corrosion of ferrous metal surfaces in interior and exterior. Its main features are the high penetration of the substrate, flexibility, excellent adhesion on galvanized, aluminium and ferrous surfaces. Primer based on particular resins passivating pigments and zinc phosphate which have particularly good adhesion properties on metal and barrier effect so as to ensure high impermeability to water and an antioxidant effect; It is characterized by fast drying and resistance to the recoat with quick-drying, alkyd and polyurethane enamels

**RECOMMENDED USE**

It is ideal for the protection of steel manufactures, new or undergoing maintenance, such as carpentry, fixtures, railings, barges, tanks, agricultural equipment, industrial body, subjected to the action of corrosive agents in rural, urban, industrial environments.

The thickness recommended for effective protection is established depending on the aggressiveness of the environment. The preheating of the product to about 30 °C gave good results by improving the drying, the coverage of the edges and allowing application of greater thickness for single layer. Sanding dust and / or spraying and dry paint residue should not be accumulated since they can cause spontaneous combustion.

**PROPERTY OF THE PRODUCT**

	<b>VALUE</b>	<b>METHOD</b>
Application temperature	<+120 °C	
Flash point	27°C	
Solids (volume)	60% ±2	
VOC	425 g/l	
Gloss 60°	<15	
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**

	<b>VALUE</b>	<b>METHOD</b>
Specific weight	1250-1350 g/l	Internal PF3
Drying Time	Fully 12 h	Internal PF2

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FILM THICKNESS AND SPREADING RATE		Minimum	Maximum	Typical
	Film thickness, dry, $\mu\text{m}$	40	80	60
	Film thickness, wet, $\mu\text{m}$	67	135	100
	Theoretical spreading rate, $\text{m}^2/\text{l}$	14,9	7,4	10
	Theoretical spreading rate, $\text{m}^2/\text{kg}$	11	5,5	7.4

**STORAGE** Product is stable till one year as long as it is kept in original and unopened buckets at temperature between  $+5^{\circ}\text{C}$  e  $+30^{\circ}\text{C}$ .

**COLOUR** The range of colors 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 pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or

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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.
Conditions during application	+5°C +40°C >3°C at dew point Relative humidity:<70%
Guiding data airless spray	Pressure at nozzle:15 MPa (150 kp/cm <sup>2</sup> , 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 <sup>2</sup> )
Application by conventional spray	Nozzle: 1,6 – 1,8mm Spray angle; 40 - 80° Air pressure: 3,5-4 kg/cm <sup>2</sup>
Washing thinner	Acetone per lavaggio

**DRYING TIME** Dry time 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	10°C	23°C
Surface dry	45'	15'
Through dry	3h	45'
Cured	24h	12h
Dry to recoat, minimum	90'	45'

**RECOMMENDED TOPCOAT** Fast drying enamels: Supersinteol Rapido, RE30;  
Synthetic enamels: Gladium, Eno, Sinto 26

Micaceous iron enamels FER RE GG16, FER GG11.  
Polyurethane enamels PUR TOP

**TYPICAL SYSTEM** Industrial atmosphere

Product	Layer	Wet Thickness	Dry thickness
Corrobloc	1	100	60
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RE 30	1	90	50
<b>Totale</b>	<b>3</b>	<b>290</b>	<b>170</b>

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ALTERNATIVE SYSTEM	Product	Layer	Wet Thickness	Dry thickness
	Corrobloc	1	125	75
	Fer RE GG 16	1	90	50
	Totale	2	215	125

## 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.