

Application Bulletin

Surface Preparations:

Coating performance is proportional to the degree of surface preparation. Remove all loose paint, mill scale and rust. The surface to be coated must be dimensionally stable, clean and free of grease, oil and other foreign materials accordance with SSPC-SP-1. When high pressure water jetting is not practical, surface should be chipped, cleaned and wire brushed to clean material.

Steel:

Remove oil or soap film with water-based detergent or emulsion cleaner. For atmospheric service use, high-pressure water cleaning to SSPC SP WJ-4 (L) / NACE WJ-2 (L) [over 7500 psi], power tool cleaned to ISO-St3 (SSPC SP-3) or hand tool cleaned to ISO-St2 (SSPC SP-2) or abrasive blast to ISO-Sa2.5.

Galvanized Steel:

Remove oil or soap film with water-based detergent or emulsion cleaner.

Lightly abrasive blast with a fine abrasive in accordance with SSPC SP-16 guidelines to achieve profile of 15-30µm for Corrizon® Base.

Galvanized steel that has had at least 12 months of exterior weathering may be coated after power washing to remove all contaminations and white rust.

Aluminum:

Remove oil or soap film with water-based detergent or emulsion cleaner.

Lightly abrasive blast with a fine abrasive in accordance with SSPC SP-16 guidelines to achieve profile of 15-30µm for Corrizon® Base.

Previously Painted Surfaces and Repairs:

If in sound condition, clean the surface of all foreign material as mentioned above.

Application Conditions:

Temperature:	5°C minimum 80°C Maximum. Dew point is not relevant.
Relative Humidity:	85% maximum.

Application Equipment:

The following is a guide. Changes in pressures and Nozzle sizes may be needed for proper spray characteristics. Always purge spray equipment before use with water only.

Reducer/Clean up	Water
Airless Spray	
Pressure	2500-3000 psi
Hose	3/8" ID
Nozzle orifice	0.013"-0.017"
Filter	60 mesh
Dilution	As needed up to 5% by volume
Conventional Spray	
Gun	Binks 95 / Devilbiss
Fluid Nozzle	66SS
Nozzle orifice	0.07" (1.8mm)
Atomization Pressure	40-60 psi
Fluid Pressure	20-30 psi
Dilution	As needed up to 5% by volume
Brush	
Brush	Natural Bristle
Dilution	Not Recommended
Roller	
Cover	1/4" woven
Dilution	Not Recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.

Application Procedures:

Surface preparation must be completed as indicated.

Mixing Instructions:

Mix Corrizon® Base thoroughly to a uniform consistency, with low speed power agitation (up to 500rpm) prior to use.

Apply Corrizon® Base at the recommended film thickness and spreading rate as below:

Recommended Spreading Rate per Coat:

	Minimum	Maximum
Wet mils (Microns)	1.2 (30)	2 (50)
Dry mils (Microns)	0.75 (19)	1.26 (31)

Theoretical Coverage

sq. ft./gal (m²/l) @ 1 mil 950 (25)
/(25 microns) DFT

NOTE: Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

In case of wind speed over 11-16knots / 20-29km/h use brush or roll only.

Drying time @ 2 mils wet (50 microns):

@	10°C	25°C	38°C	49°C
To touch	1 hour	30 min.	15 min.	10 min.
Top paint	24 hours	24 hours	24 hours	24 hours
To cure	7 days	7 days	7 days	7 days

Clean up instructions:

Clean spills and spatters immediately with water.
Clean tools immediately after use with water.

Performance Tips:

- Stripe coat all crevices, welds, and sharp angles to prevent early failure in these areas.
- When using spray application, try not to overlap with each pass of the gun. Be aware to avoid bare areas, voids and pinholes. If necessary, cross spray at a right angle.
- Spreading rates are calculated on volume solids and do not include an application loss factor due to surface profile, roughness or porosity of the surface, skill and technique of the applicator, method of application, various surface irregularities, material lost during mixing, spillage, overthinning, climatic conditions and excessive film build.
- Excessive dilution of material can affect film build, appearance and adhesion.
- In order to avoid blockage of spray equipment, clean equipment before use or before periods of extended downtime with water.

- When using a roller, always maintain a wet edge to avoid roller marks. roll as close as possible to any cut-in areas, to eliminate visual imperfections. roller application must be from a roller tray, not by pouring the material onto the surface.
- After Corrizon® Base application:
 - Wait 6-24 hours.
 - Wash the residual carrier with a medium pressure water jet (~100bar) and only then apply the top paint.
 - Waiting more than 24 hours before applying the top paint means the residual carrier might become too hard and too difficult to remove.
 - Do not wash off residuals when not applying top paints.
 - Wait 24 hours before applying top paint.
- Where top paint is not required, after the first layer is dry to touch, apply an additional layer of Corrizon® Base. If used under water or under ground let dry for at least 24 hours.
- In case of rain or humidity the coat might appear white. This phenomenon does not affect the activity of the coat in any stage.
- In case of insufficient surface preparation, black spots can appear over top paint. It might happen as a result of reaction between Corrizon® Base active materials and residues of rust over the surface. If it occurs, wash it with water or wet cloth to remove it.
- We strongly recommend to coat few coupons (at least 3) 10X15cm² (4"X6") to escort every job or pilot for future reference and lab. testing.

Refer to Product Information sheet for additional performance characteristics and properties.

Recommended systems:

After washing off residuals, apply a top paint of your selection in accordance with the manufacturer's instructions. The top paint may be of Direct-to-Metal (DTM) nature or use a primer before applying a top coat

Safety Precautions:

Refer to Safety Data sheet (SDS) before use. Published technical data and instructions are subject to change without notice. Contact your local Green-ICPS distributor for additional technical data and instructions.

Warranty:

Green-ICPS warrants our products to be free of manufacturing defects in accord with applicable Green-ICPS quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product as determined by Green-ICPS. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY GREEN-ICPS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

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