

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 another foreign materials accordance with SSPC-SP-1. When high pressure water jetting is not practical, surface should be chipped, clean 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. Galvanizing 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: 40°F (4.5°C) minimum,
 120°F (49°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
Reduction	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
Reduction	As needed up to 5% by volume
Brush	
Brush	Natural Bristle
Reduction	Not Recommended
Roller	
Cover	1/4" woven
Reduction	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.

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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 (21)	1.25 (35)

Theoretical Coverage

sq. ft./gal (m²/l) @ 1 mil /25 microns DFT	1080 (20)	1160 (33)
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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 / 20-28km/h use brush or Roll only.

Drying time @ 2 mils wet (50 microns):

@	50°F/ 10°C	77°F/ 25°C	100°F/ 38°C	120°F/ 49°C
To Touch	1 hour	30 minutes	15 minutes	10 minutes
Top coat	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 holidays, bare areas, 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 reduction 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 rolling this product, always maintain a wet edge to avoid roller marks. Roll as close to any cut-in areas as possible to eliminate visual imperfections. Roller application must be from a roller tray, not by pouring the material onto the surface.
- In can case of rain or humidity the coat might appears white. This phenomenon is not affect the activity of the coat in any stage.
- In case of insufficient surface preparation, black spots can appear over top coat. It might happen as a result of reaction between Corrizon base active materials and residues of rust over the surface. While 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 a pilot for a future reference and lab. Testing.

Refer to Product Information sheet for additional performance characteristics and properties

Safety Precautions:

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

Warranty:

The Green-ICPS company 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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