

DULUX TRADE CORROCOTE 3 METAL ETCH PRIMER

TECHNICAL DATA SHEET

Version 3 – 2024 MARCH

THIS ISSUE SUPERSEDES ALL PREVIOUS PUBLICATIONS

PRODUCT DESCRIPTION

Water-based primer for galvanised iron and mild steel.

PRODUCT USES

- An excellent primer, being both quick drying and abrasion resistant.
- Provides excellent adhesion and a good base for top coating.

FEATURES AND BENEFITS

- Best available primer for galvanised iron surfaces, with excellent adhesion properties.
- An excellent anti-corrosive primer for use over correctly prepared mild steel & iron.
- Can be over coated with most conventional paints, both solvent and water-based and **Dulux Trade Tuffcote Epoxy Enamel**.
- Water-based
- Non-toxic and non-flammable.
- Quick drying.
- Low odour.
- Low VOC.

PRODUCT INFORMATION

Appearance	Low Sheen
Colour	Red Oxide
Binder Type	Vinyl Chloride Co-polymer
Density at 23°C	Approx. 1.35Kg/L
Solids Content	By weight: Approx. 51%
	By volume: Approx. 33%
Packaged Viscosity	Viscosity at 23°C: Approx. 80 KU.
Spreading Rate	Approx. 10m ² per litre. Spreading rate depends on surface porosity, profile and application method.
Recommended DFT per coat	35µm
Recommended WFT per coat	100µm
Volatile Organic Compound	26g/L – VOC level complies with Green Building Council SA.
Flash Point	Water-based material – not normally flammable.
	Not a fire hazard, but must be stored above 5°C.

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APPLICATION INFORMATION

Mixing	Stir until homogeneous with a flat paddle.
Application Surface conditions	Surface Temperature between 10 - 35°C. Relative Humidity between 10 - 85 % OR 2°C above dew point minimum.
Application methods	<p><u>Airless spray</u>. Thin up to 5% by volume with potable water in hot windy weather, otherwise use as supplied after thorough stirring. Use a 0,32mm orifice with angle to suit the work piece.</p> <p><u>Air (conventional) spray</u>. Thin up to 10% by volume with potable water.</p> <p><u>Brush and Roller</u> - Two coats are recommended</p>
Thinner	<p>Thinning not recommended. Ready for use after thorough stirring. Potable water if required for spraying to maximum of 5% of product volume.</p> <p>*Note if diluted multiple coats will be required to achieve the required 35µm total dry film thickness.</p>
Drying Time	Touch dry 1 hour at 23°C.
Recoating Time	<p><u>4 Hours</u> for water-based top coats.</p> <p><u>24 hours</u> for conventional solvent-based top coats.</p> <p><u>48 Hours</u> for Dulux Trade Tuffcote Epoxy Enamel</p>
Cleaning of equipment	After use, remove as much product as possible, and then clean immediately with water.
Substrates	Suitable for correctly prepared galvanised iron, mild steel & iron, and non-ferrous metals.
Precautions:	<p>Do not apply during cold (below 5°C) or if the temperature is liable to fall below 5°C during the 4 hours following application, or wet weather.</p> <p>Do not apply over rusty unprepared metal surfaces.</p> <p>Quick drying - avoid application to very hot surfaces.</p> <p>Not suitable for use where surface temperatures exceed 65°C. Thus may not be used as a primer under Dulux Roofguard, Rockgrip Acrylic Roof or Maxicover Roof Cover.</p> <p>Not designed to withstand natural weathering. Overcoat within one week particularly in a marine atmosphere.</p>
Coats Required	Apply one or two coats Dulux Trade Corrocote 3 Metal Etch Primer , depending on the severity of the conditions to achieve a continuous closed film and solid colour. Two coats are recommended for brush and roller application.

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Top Coating	<p>Can be over coated with most conventional used topcoats - Solvent and Water-Based paints and Dulux Trade Tuffcote Epoxy Enamel. *See Recoating Time for curing period before over-coating with the respective topcoats.</p> <p>Suitable as a tie coat between otherwise incompatible primers and topcoats, e.g.: between Inorganic Zinc primers and alkyd or vinyl topcoats.</p>
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SURFACE PREPARATION

Ensure that surfaces are sound and free from contaminants such as rust, mill scale, salt, algae, dust, oil, grease, dirt, and debris. Surfaces must be thoroughly dry.

NEW SURFACES

Mild Steel and Iron (Finishing with Conventional Coatings)

- Inspect shop-primer thoroughly for damage by installation. Abrade new surfaces lightly and remove rust, mill scale by sanding, scraping or with steel wire brushes back to sound mild steel and iron or sandblast to SA 2½.
- Ensure that the sanded areas are dry and free of grease and dust. A solvent wash (rags dipped in lacquer thinner) may be used. Change the rags frequently. Allow drying, OR clean with **Dulux Galvanised Iron Cleaner** according to technical data sheet.
- Apply one or two coats **Dulux Trade Corrocote 3 Metal Etch Primer**, depending on the severity of the conditions. Two coats are preferred for coastal conditions.
- For best paint system performance follow primer with **Dulux Trade Universal Undercoat** or **Dulux Universal Undercoat** before applying the selected finishing coat.

Mild Steel and Iron - Interior (Finishing with Dulux Trade Tuffcote Water-Based Epoxy Enamel)

- Remove all shop-primer and corrosion mill scale and rust by abrasion blasting cleaning to Sa2½ minimum standard. Hand cleaning is not recommended.
- Wet grit blasting may be used but should be followed by a light dry blast unless an inhibitor is added to the water.
- Ensure that the blasted areas are dry and free of grease and dust. A solvent wash (rags dipped in lacquer thinner) may be used. Change the rags frequently and allow drying.
- Apply one or two coats **Dulux Trade Corrocote 3 Metal Etch Primer**, depending on the severity of the conditions. Two coats are preferred for coastal conditions.
- Allow 48 hour curing time before over coating with **Dulux Trade Tuffcote Epoxy Enamel**.

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SURFACE PREPARATION

NEW SURFACES

Galvanised Iron, Aluminium and all Non-ferrous Metals

- Remove all traces of temporary protective coating, dirt and grease from the surface with **Dulux Galvanised Iron Cleaner**. Ensure complete removal of **Dulux Galvanised Iron Cleaner** by rinsing with running water. A water-break free surface indicates thorough cleaning - running water should not form droplets. If a water-break free surface was not achieved, repeat the cleaning process.
- Prime immediately after cleaning with one to two coats **Dulux Trade Corrocote 3 Metal Etch Primer**, depending on the severity of the conditions. Two coats recommended for coastal conditions.
- For best paint system performance when over coating non-roof sheeting surfaces with conventional coatings follow primer with **Dulux Trade Universal Undercoat** or **Dulux Universal Undercoat** before applying the selected finishing coat.

HEALTH AND SAFETY INFORMATION

Warning: Corrocote 3 contains oththilnone (ISO)-C(M)IT/MIT (3:1) methylisothiazolinone-1,2-benzisothiazol-3(2H)-one. Toxic to aquatic life with long lasting effects.

Dulux Trade™ paints contain no added lead. Avoid contact with skin or eyes. Keep out of reach of children. If accidentally swallowed, seek medical advice and show this container to the doctor. Dry sanding, flame cutting, and/or welding of the dry paint film will give rise to dust and/or hazardous fumes. Wet sanding should be used wherever possible. If exposure cannot be avoided by the provision of local exhaust ventilation, suitable respiratory protective equipment should be used. Do not empty into drains or watercourses. Ensure good ventilation during application and drying.

Safety and Technical datasheets available on request. Call a POISON CENTRE or doctor/physician if you feel unwell. Dispose of contents and container in accordance with all local, regional, national or international regulations.

To avoid the risk of spillage, transport containers in a secure upright position. Always store under ambient conditions.

ADDITIONAL INFORMATION

Packaging	5Lt
Storage Conditions	Store under cool dry conditions above 5°C away from direct sunlight, heat and extreme cold.
Disclaimers	Colour swatch references are as accurate as modern printing will allow.

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TDS STANDARD DISCLAIMER

The recommendations contained herein are given in good faith and meant to guide the specifier or user in accordance with good painting practices. They are gained from our tests and experiences and are believed to be accurate and reliable. No warranty/guarantee is implied by the recommendations contained herein since the conditions of use; application method, substrate and cleanliness of the substrate are beyond Dulux control.

Important Note; Technology may change with time, necessitating changes to this Technical Data Sheet (TDS).

It is the responsibility of the user to ensure that the latest TDS is being used for reference. Dulux Technical Data Sheets are available on our website www.duluxtrade.co.za or please contact: Dulux On-Line on 0860 330 111. Email ZA.Helpline@akzonobel.com

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