

## DULUX TRADE CORROCOTE 1 METAL ETCH PRIMER

### TECHNICAL DATA SHEET

Version 1 – 2018 MARCH

THIS ISSUE SUPERSEDES ALL PREVIOUS PUBLICATIONS

### PRODUCT DESCRIPTION

Versatile primer for Galvanised Iron, all Non-Ferrous Metals, rigid PVC and Mild Steel & Iron.

### PRODUCT USES

- Versatile primer for galvanised iron and non-ferrous metals.
- May be used as a primer on new mild steel and iron surfaces which have been hand prepared for over-coatings with conventional coatings and sand-blasted to Sa2½. minimum for over-coating with **Dulux Trade Hi-Chem Epoxy Enamel**

### FEATURES AND BENEFITS

- Suitable for interior and exterior use.
- Provides excellent adhesion.
- Fast recoating properties - recoat in 4 hours with conventional coatings.
- Provides an excellent primed surface for over-coating with conventional paint and **Dulux Trade Hi-Chem Epoxy Enamel**
- A quick drying acid-hardening pre-treatment primer.
- Upgrades corrosion resistance.

### PRODUCT INFORMATION

<b>Appearance</b>	Matt
<b>Colour</b>	Red Oxide
<b>Binder Type</b>	Polyvinyl Butyral/Phenolic
<b>Density at 23°C</b>	Approx. 0.96Kg/L
<b>Solids Content</b>	By weight: Approx. 30% By volume: Approx. 17%
<b>Packaged Viscosity</b>	Viscosity at 23°C: Approx. 70 KU.
<b>Spreading Rate</b>	Approx. 8m <sup>2</sup> per litre depending on surface porosity, profile and application method.
<b>Recommended DFT per coat</b>	Min. 25µm. Max. 35µm.
<b>Recommended WFT per coat</b>	Min. 145µm. Max. 200µm
<b>Flash Point</b>	12°C

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### APPLICATION INFORMATION

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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	Brush or spray. Roller application is not recommended. Brush application preferred to ensure wetting of the surface.
Thinner	Thinning not recommended. Brush - Ready for use after thorough stirring. <b>Etch Primer Thinner</b> if required for spraying to maximum of 10% of product volume.
Drying Time	Touch dry 1 hour at 23°C.
Recoating Time	<u>4 Hours</u> for Conventional Coatings, <u>48 Hours</u> for <b>Dulux Trade Hi-Chem Epoxy Enamel</b> . (Drying times will be extended during cold, wet or humid conditions). Maximum over-coating time is 14 days.
Cleaning of equipment	After use, remove as much product as possible, and then clean immediately with <b>Etch Primer Thinner</b> .
Substrates	Suitable for application to correctly prepared galvanised iron, all non-ferrous metals, mild steel and iron, and rigid PVC.
Precautions:	Do not apply during cold (below 10°C) or wet weather. Not suitable for direct application to powdery or friable surfaces whether previously painted or not. Do not apply over rusty, unprepared metal surfaces. Quick drying - avoid application to very hot surfaces. Not designed to withstand natural weathering. Overcoat as soon as possible after the applicable recoating time, particular in coastal conditions.
Coats Required	Apply one or two coats <b>Dulux Trade Corrocote 1 Metal Etch Primer</b> , depending on the severity of the conditions to achieve a continuous closed film and solid colour. Two coats are preferred for coastal conditions.
Top Coating	Over-coat with two coats of selected Dulux/ Dulux Trade topcoat. See Surface preparation for more detail.

## DULUX TRADE CORROCOTE 1 METAL ETCH PRIMER

### SURFACE PREPARATION

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Ensure that surfaces are sound and free from rust, dust, oil, grease, dirt, and debris. Surfaces must be thoroughly dry - no more than 12% moisture content.

### 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.
- Prime with one to two coats **Dulux Trade Corrocote 1 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.

#### Mild Steel and Iron (Finishing with Conventional Coatings)

- Inspect shop-primer thoroughly for damage by installation. All rust, scale and dirt must be removed by scraping or with steel wire brushes, and then thoroughly sanded with medium grit sandpaper, finishing with fine grit sandpaper - down to a bright metal finish.
- 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.
- Apply one or two coats **Dulux Trade Corrocote 1 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 Hi-Chem Epoxy Enamel)

- Hand cleaning is not recommended.
- Surfaces must be clean and rust-free. Remove mill scale and rust by abrasion blasting to Sa2½ minimum standard.
- 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.
- Allow drying.
- Apply one or two coats **Dulux Trade Corrocote 1 Metal Etch Primer**, depending on the severity of the conditions. Two coats are preferred for coastal conditions.

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### SURFACE PREPARATION

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#### NEW SURFACES

##### **Rigid PVC**

- Lightly sand surface to improve adhesion.
- Clean and degrease with **Dulux Pre-Paint Brush Cleaner/Degreaser**.
- Rinse thoroughly with water and allow drying.
- Apply one coat directly.

#### PREVIOUSLY PAINTED SURFACES

- The existing coating system should be dry and free of rust, contaminants such as oil, grease and loose paint.
- Abrade damaged or failed areas back to a sound substrate.
- Aged or weathered epoxies or urethanes must be well sanded to a matt finish to provide a profile for adhesion
- Test that the prepared painted surface will accept over coating with **Dulux Trade Corrocote 1 Metal Etch Primer** by allowing a cloth soaked with **Dulux Trade HD Thinners** to rest on it for 15 minutes - it must not lift or wrinkle. If lifting or wrinkling occurs, all paint must be removed with most suitable means back to the bare metal surface
- Spot prime only the exposed substrate as per new surfaces
- Build up spot-primed areas with **Dulux Trade Universal Undercoat or Dulux Universal Undercoat** to the same level as the rest of the paintwork only when finishing with a conventional coating

### HEALTH AND SAFETY INFORMATION

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Solvent based paints are flammable.

This product contains no added lead. Avoid contact with skin or eyes. Keep out of reach of children. If accidentally swallowed, seek medical advice immediately 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. It is recommended to use suitable protective clothing and equipment. To avoid the risk of spillage, always store and transport containers in a secure upright position. Refer to Material Safety Data Sheet for complete information.

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## DULUX TRADE CORROCOTE 1 METAL ETCH PRIMER

### ADDITIONAL INFORMATION

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Packaging	5Lt
Storage Conditions	Store under cool dry conditions away from direct sunlight, heat and extreme cold.
Disclaimers	N/A product specific

### TDS STANDARD DISCLAIMER

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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](http://www.duluxtrade.co.za) or please contact: Dulux On-Line on 0860 330 111. Email [ZA.Helpline@akzonobel.com](mailto:ZA.Helpline@akzonobel.com)

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