COR-COTE® HP FF FLAKE FILLED EPOXY

**PRODUCT DESCRIPTION**

COR-COTE HP FF FLAKE FILLED EPOXY is a 100% solids, epoxy coating. The outstanding, broad spectrum of chemical resistance of this product provides protection in chemical environments while maintaining properties such as gloss and stain resistance. Overlapping glass flakes reduce permeability, providing excellent performance in immersion service.

- Stain resistant, high gloss finish
- Chemical resistant
- No VOCs and low odor
- Low viscosity for ease of workability
- Low permeation rate
- Improved edge protection
- Film reinforcement

**PRODUCT CHARACTERISTICS**

**Finish:** Gloss

**Color:** Haze Gray, Tile Red

**Volume Solids:** 100%, calculated, mixed

**VOC (calculated):** <100 g/L; .83 lb/gal, mixed

**Mix Ratio:** 2:1

**Recommended Spreading Rate per coat:**

<table>
<thead>
<tr>
<th>Wet mils (microns)</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>10.0</td>
<td>250</td>
<td>15.0</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Dry mils (microns)</th>
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<tr>
<td>10.0</td>
<td>250</td>
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</tr>
</tbody>
</table>

| Coverage sq ft/gal (m²/L) | 100 (2.45) | 160 (3.9) |
| Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft | 1600 (39.2) |

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

**Drying Schedule @ 10.0 mils wet (250 microns):**

- **To touch:** 6 hours
- **To recoat:**
  - minimum: 8 hours
  - maximum: 16 hours
- **Light traffic:** 16 hours
- **To cure:** 7 days

If maximum recoat time is exceeded, abrade surface before recoating.

Drying time is temperature, humidity, and film thickness dependent.

**Abrasion Resistance**

- **Test Method:** ASTM D4060
- **Results:** CS-17: 70 mgs loss

**Adhesion**

- **Concrete:** 350 psi
- **Steel:** 1200 psi

**Durometer Hardness**

- **Test Method:** ASTM D2240
- **Results:** Shore D - 80

**Flammability**

- **Test Method:** ASTM D635
- **Results:** Self-extinguishing over concrete

**Water Vapor Transmission**

- **Test Method:** ASTM E96
- **Results:** .0032 perm in

**Performance Characteristics**

**Recommended Uses**

Cor-Cote HP FF Flake Filled Epoxy is used as a coating/lining and as a topcoat for self-leveling, mortar, and mortar laminate applications.

Protects concrete and steel surfaces in immersion and atmospheric exposure in tank linings, secondary containment, and process flooring applications in various facilities including:

- Automotive
- Electronics
- Metal & mining
- Power
- Water & wastewater
- Chemical processing
- Food & beverage
- Pharmaceutical
- Pulp & paper
- Petrochemical
- Acceptable for use in USDA inspected facilities

**Test Name**

**Test Method**

<table>
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<tr>
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<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Abrasion Resistance</td>
<td>ASTM D4060</td>
<td>CS-17: 70 mgs loss</td>
</tr>
<tr>
<td>Adhesion</td>
<td>ASTM D4541</td>
<td>Concrete: 350 psi; Steel: 1200 psi</td>
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<tr>
<td>Durometer Hardness</td>
<td>ASTM D2240</td>
<td>Shore D - 80</td>
</tr>
<tr>
<td>Flammability</td>
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# COR-COTE® HP FF FLAKE FILLED EPOXY

## PRODUCT INFORMATION

### RECOMMENDED SYSTEMS

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<tbody>
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<tr>
<td>Near White Metal</td>
</tr>
<tr>
<td>Commercial Blast</td>
</tr>
<tr>
<td>Brush-Off Blast</td>
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<tr>
<td></td>
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<tr>
<td>Power Tool Cleaning</td>
</tr>
</tbody>
</table>

### CONCRETE OR STEEL (LINING, CONTAINMENT, FLOORING): Medium Film Lining

- **For Steel:** Dura-Plate UHS Primer
  - 1 ct. Macropoxy 240: 1.0-1.5 (25-40)
  - 1 ct. Steel-Seam FT910 as required for filling pits and transitioning sharp edges, weld seams, etc.
- **For Concrete:** Corobond 100 Epoxy
  - 1 ct. Corobond 100 Epoxy Primer/Sealer: 4.0-6.0 (100-150)
  - 1 ct. Corobond 100 Epoxy (clear) with 1 oz glass mat: 20.0-30.0 (500-750)
- **For Steel:** Dura-Plate UHS Primer
  - 1 ct. Corobond 100 Epoxy Primer/Sealer: 4.0-6.0 (100-150)

### MORTAR LAMINATE

- **For Steel:** Dura-Plate UHS Primer
  - 1 ct. Macropoxy 240: 1.0-1.5 (25-40)
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### SELF-LEVELING MORTAR BROADCAST

- **For Steel:** Dura-Plate UHS Primer/Sealer
  - 1 ct. Corobond 100 Epoxy Primer/Sealer: 4.0-6.0 (100-150)
- **For Concrete:** Corobond 100 Epoxy Coating with 22 lbs of Type S Aggregate per 1.5 gallons (5.7L) plus 40-60 mesh aggregate broadcast yields 50-60 sq. ft. (1.3-1.5 m²/L)
  - 1 ct. Corobond 100 Epoxy (to fill): 15.0-20.0 (375-500)
- **For Steel:** Dura-Plate UHS Primer/Sealer
  - 1 ct. Corobond 100 Epoxy Primer/Sealer: 4.0-6.0 (100-150)

### CONCRETE OR STEEL (LINING, CONTAINMENT, FLOORING): Medium Film Lining

- **For Steel:** Dura-Plate UHS Primer
  - 1 ct. Steel-Seam FT910 as required for filling pits and transitioning sharp edges, weld seams, etc. on steel or for filling voids and bugholes on concrete
  - 2 cts. Cor-Cote HP FF Flake Filled Epoxy 10.0-15.0 (250-375)
- **For Concrete:** Corobond 100 Epoxy
  - 1 ct. Corobond 100 Epoxy Primer/Sealer: 4.0-6.0 (100-150)
  - 1 ct. Corobond 100 Epoxy (clear) with 1 oz glass mat: 20.0-30.0 (500-750)
- **For Steel:** Dura-Plate UHS Primer
  - 1 ct. Macropoxy 240: 1.0-1.5 (25-40)
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### CONCRETE OR STEEL (LINING, CONTAINMENT, FLOORING): Mortar Laminate

- **For Steel:** Dura-Plate UHS Primer
  - 1 ct. Steel-Seam FT910 as required for filling pits and transitioning sharp edges, weld seams, etc. on steel or for filling voids and bugholes on concrete
  - 2 cts. Cor-Cote HP FF Flake Filled Epoxy 10.0-15.0 (250-375)
- **For Concrete:** Corobond 100 Epoxy
  - 1 ct. Corobond 100 Epoxy Primer/Sealer: 4.0-6.0 (100-150)
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  - 1 ct. Corobond 100 Epoxy (to fill): 15.0-20.0 (375-500)
  - 1 ct. Cor-Cote HP FF Flake Filled Epoxy 10.0-15.0 (250-375)

### TINTING

Do not tint.

### APPLICATION CONDITIONS

- **Temperature:** 50°F (10°C) minimum, 90°F (32°C) maximum (air, surface, material)
  - At least 5°F (2.8°C) above dew point
- **Relative humidity:** 85% maximum
  - Refer to product Application Bulletin for detailed application information.

### ORDERING INFORMATION

- **Packaging:**
  - **Part A:** 2 gallons (7.56L) in a 3 gallon (11.7L) container and 5 gallons (18.9L)
  - **Part B:** 1 gallon (3.78L) and 5 gallons (18.9L)

### SAFETY PRECAUTIONS

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

### WARRANTY

The Sherwin-Williams Company warrants its products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

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**DISCLAIMER**

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www.sherwin-williams.com/protective
Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

**Iron & Steel (immersion service)**
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2-3 mils / 50-75 microns). Remove all weld spatter and round all sharp edges. Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

**Iron & Steel (atmospheric service)**
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (2 mils / 50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

**Concrete and Masonry**
For surface preparation, refer to SSPC-SP13/NACE 6, or ICRI No. 310.2R, CSP 3-5. Surfaces should be thoroughly clean and dry. Concrete and mortar must be cured at least 28 days @ 75°F (24°C). Remove all lose mortar and foreign material. Surface must be free of laitance, concrete dust, dirt, form release agents, moisture curing membranes, loose cement and hardeners. Fill bug holes, air pockets and other voids with Steel-Seam FT910. Primer required.

**Concrete, Immersion Service:**
For surface preparation, refer to SSPC-SP13/NACE 6, Section 4.3.1 or 1.3.2 or ICRI No. 310.2R, CSP 3-5.

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**Surface Preparation Standards**

<table>
<thead>
<tr>
<th>Condition of Surface</th>
<th>ISO BS7097/A1</th>
<th>Swedish Std.</th>
<th>SSPC</th>
<th>NACE</th>
</tr>
</thead>
<tbody>
<tr>
<td>White Metal</td>
<td>Sa 3</td>
<td>Sa 3</td>
<td>Sa 3</td>
<td>1</td>
</tr>
<tr>
<td>Near White Metal</td>
<td>Sa 2.5</td>
<td>Sa 2.5</td>
<td>Sa 2.5</td>
<td>2</td>
</tr>
<tr>
<td>Commercial Blast</td>
<td>Sa 2</td>
<td>Sa 2</td>
<td>Sa 2</td>
<td>3</td>
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<tr>
<td>Brush-Off Blast</td>
<td>Sa 3</td>
<td>Sa 1</td>
<td>Sa 1</td>
<td>4</td>
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<td>D St 2</td>
<td>6</td>
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<tr>
<td>Rusted</td>
<td>C St 3</td>
<td>C St 3</td>
<td>C St 3</td>
<td>7</td>
</tr>
<tr>
<td>Pitted &amp; Rusted</td>
<td>D St 4</td>
<td>D St 4</td>
<td>D St 4</td>
<td>8</td>
</tr>
</tbody>
</table>

**Application Conditions**

- **Temperature:** 50°F (10°C) minimum, 90°F (32°C) maximum (air, surface, material)
- **Relative humidity:** 85% maximum

**Application Equipment**

- The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.
- **Reduction:** Not recommended
- **Cleanup:** Xylene, R2K4
- **Airless Spray:**
  - Pump: Graco Extreme, 68:1
  - Gun: Graco XTR
  - Fluid Hose: 3/8” - 1/2” ID
  - Tip Orifice: .027” - .031”
  - Fan Width: 12”
  - Fluid Pressure: 3000 - 3800 psi
  - Filter Screen: Must be removed
- **Brush:** Natural bristle for applications in small areas
- **Roller:** 3/8” nap
- **Squeegee:** Acceptable for horizontal applications followed by back roll with 3/8” nap roller

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

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For more information, visit [www.sherwin-williams.com/protective](http://www.sherwin-williams.com/protective)
Surface preparation must be completed as indicated.

Mixing Instructions: Premix individual components separately, using a low-speed drill and Jiffy Blade model ES mixer. Make certain no pigment or glass flake remains on the bottom or sides of the can. Combine one part by volume of Part B to two parts by volume of Part A. Mix with low-speed drill and Jiffy Blade model ES mixer for three minutes and until uniform. To insure that no unmixed material remains on the sides and bottom of the cans after mixing, visually observe the container by pouring the material into a separate container. Marbled or streaky appearance is an indication of improper mixing.

Apply paint at the recommended film thickness and spreading rate as indicated below:

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

Drying Schedule @ 10.0 mils wet (250 microns):
- @ 73°F/23°C
- 50% RH
- To touch: 6 hours
- To recoat:
  - minimum: 8 hours
  - maximum: 16 hours
- Light traffic: 16 hours
- To cure: 7 days
- If maximum recoat time is exceeded, abrade surface before recoating. Drying time is temperature, humidity, and film thickness dependent.
- Pot Life: 25 minutes
- Sweat-in-Time: None required

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

Clean up Instructions
Clean spills and spatters immediately with Xylene, R2K4. Clean tools immediately after use with Xylene, R2K4. Follow manufacturer's safety recommendations when using any solvent.

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Performance Tips
- For concrete, always perform Calcium Chloride test as per ASTM F1869. Do not proceed with MVE >3 lbs.
- For steel, stripe coat all chine, welds, bolted connections, and sharp angles to prevent early failure in these areas.
- Pot life of this material is moderately short. Working time can be extended by mixing small batches and by getting material out of mixing containers and on to the working surface in desired film thickness as quickly as possible.
- 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.

For Immersion Service: (if required) Holiday test in accordance with ASTM D5162 for steel, or ASTM D4787 for concrete.

Use of Corobond Conductive Epoxy Primer on concrete is recommended in order to provide a uniform conductive underlayment. Repair holidays found prior to application of final coat Do not apply material beyond recommended pot life. Do not mix previously catalyzed material with new. Consult your Sherwin-Williams representative for specific application and performance recommendations.

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

Safety Precautions
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Warranty
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