

Product Data Sheet

Max Cor CF



Intended Uses

Max Cor CF is a high solids two component anti-corrosive, chromate-free epoxy primer for aluminum and steel with excellent chemical and solvent resistance. Max Cor CF is based on 'Controlled Fusion' (CF) technology, a unique chemical system that allows extended re-coat times, removes the need for sanding prior to applying the next coat and also gives excellent substrate adhesion. The technology eliminates the requirement for high hazard chemicals and ensures a tightly fused intercoat layer between the CF-based coating and the next applied coat. For above the waterline only.

Specification Data

Volume Solids	56%
Specific Gravity	1.20
Available Packs	Base available in a 1 gallon pack, converter in a ½ gallon pack. Typical Shelf Life - 2 years
Base	OR4330
Converter	OR3330
Reducer	Do not thin/reduce
Equipment Cleaning	T0006, T0176 (NA only), Acetone or M.E.K.

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Air Atomized	1	34 µm 1.3 mil	25 µm 1 mil	25 µm 1 mil	26.45 m²/lit 1077.6 ft²/Gal

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size and application environment.



VOC

OR4330 – 2.12 lbs/gallon (254 g/l), OR3330 – 5.54 lbs/gallon (628 g/l)
Mixed (OR4330:OR3330) – 3.15 lbs/gallon (378 g/l).

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch and when tested via standard test methodology.

Product	As Supplied (without reducer)			
	g/L	lb/gal	g/Kg	lb/lb
OR4330 Base	254	2.12		
OR3330 Converter	628	5.24		
Max Cor CF	378	3.16		



Surface Preparation

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.

Max Cor CF may be directly applied to grit blasted steel in accordance with SSPC-SP10 to a 2-3 mil (50-70 microns) profile (or Sa2½ outside of the US). Alternatively power grind with 16 to 36 grit disc to obtain profile. The surface must be clean and dry, free of all dirt, grease and oil. Use Awlgrip Wipe-Down Solvent (NA: Awlprep T0008 or Awlprep Plus T0115; AP: Awlprep Plus T0115; EU: Surface Cleaner T0340).

Aluminium: Sandblasted/ground to 100% clean silver color. A surface profile of 2-3 mils (50-75 microns) is recommended.

Steel: Sandblast/grind SSPC-SP10 or Sa2½. A surface profile of 2-3 mils (50-75 microns) is recommended.



Mixing & Reduction

Mix by volume 2 parts OR4330 with 1 part OR3330. Ensure OR4330 is uniformly dispersed before addition of OR3330. Mix until a smooth homogenous mixture is obtained.

Anticipated Pot Life at 77°F (25°C) @ 50% R.H: 2 hours

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full-scale application is recommended.



Application

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

Spray only. Apply one smooth wet coat. Substrate may be visible through dry film. Do not exceed maximum recommended dry film thickness.

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Do not apply paint materials to surfaces warmer than 40°C/105°F or colder than 15°C/59°F. Do not attempt to cure products at temperatures below 15°C/59°F.

IMPORTANT NOTES: Read Material Safety Data Sheet before using.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	134.00 mm 5276 thou	-	-	2 - 4.1 bar 29 - 59 psi



Recoatability & Drying Times

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Drying	15°C (59°F)	25°C (77°F)	35°C (95°F)	
Hard Dry	6 Hours	4 Hours	2 Hours	
Pot Life	2 Hours	2 Hours	60 Minutes	

Overcoated By	15°C (59°F)		25°C (77°F)		35°C (95°F)			
	Min	Max	Min	Max	Min	Max		
High Build, Hullgard Extra Epoxy Primer	17 Hours	72 Hours	17 Hours	72 Hours	7 Hours	72 Hours		

Note: If maximum overcoating interval is exceeded Max Cor CF will need to be fully removed and re-applied. If maximum overcoating interval is likely to be exceeded apply Hullgard Extra to give up to 6 months overcoating without the need for sanding.



Warning Notes

Always ensure the overcoating times are adhered to. Failure to allow the required overcoating time will result in blistering and delaminating of the underlying Max Cor CF.

Note: If maximum overcoating interval is exceeded Max Cor CF will need to be fully removed and re-applied. If maximum overcoating interval is likely to be exceeded apply Hullgard Extra to give up to 6 months overcoating without the need for sanding.

The information in this Product Data Sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law, we can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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