CORCHEM®

INFORMATION BULLETIN

CORCHEM® 243 CHEMICAL RESISTANT ESTER FORCED CURE PROCEDURE

AMBIENT CURING TIME

This curing schedule is predicated upon application conditions where the mixed product, substrate, and ambient air temperatures are the same:

Temperature	50°F	70°F	90°F
Minimum Recoat Time	8 Hours	4 Hours	2 Hours
Maximum Recoat Time	24 Hours	16 Hours	8 Hours
Immersion – Final Cure	7 days	5 days	3 days

Curing times are significantly shorter for higher temperatures or lower thickness and are longer for lower temperatures or higher thickness. Curing times are affected by the method of application; thickness of applied film; the quantity of thinner (if used); the amount of ventilation and air circulation; relative humidity; etc. *Refer to RECOAT AND REPAIR Section for extended recoat instructions, if subjected to extended exposure to sunlight, or if coating reaches complete cure and hardness.*

NOTICE!

For faster curing / return to service time and lower temperature applications CORCHEM® 243 WINTER GRADE PEROXIDE CATALYST may be desired. Heat curing will increase drying speed and improve resistance properties. See instructions and heat cure times below.

VENTILATION

Proper ventilation during the curative process is vital for the evacuation of solvent vapors. Warm dry air should be circulated across the entire coated surface throughout the curative process. Solvent fumes are heaver than air and should be exhausted through lower openings while fresh dry air is supplied through upper openings.

FORCED CURE

When CORCHEM® 243 CHEMICAL RESISTANT ESTER is properly force cured the resulting lining may achieve improved physical and chemical resistance properties.

WARNING!

DO NOT allow potential sources of spark or ignition near vessels containing explosive vapors!

FORCED CURING SCHEDULE

Air dry with continuous ventilation for 1 hour minimum and until flash off/curing time necessary to prevent blistering and defects is achieved, then gradually raise the temperature until the coated surfaces reach 125°F to 150°F for a period of 30 minutes. **CAUTION!** Over-baking between coats will result in loss of adhesion. Allow the coated surfaces to cool and then repeat each of the above application procedures until the desired total dry film thickness is obtained.

After the final coat has been applied, allow the minimum flash off/curing time necessary to prevent blistering and defects, then:

1. Gradually raise the temperature not more than 50°F every 30 minutes until the substrate reaches 150°F to 200°F and bake for 1-hour, then;
2. Gradually increase the temperature not more than 50°F every 30 minutes until the substrate reaches 250°F to 300°F and bake for 2-hours.

Caution: Exceeding the times and/or temperatures indicated above may result in reduced performance or damage to the coating.

C243 CHEMICAL RESISTANT ESTER
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MADE IN TEXAS, USA

CORCHEM 1964 ESTABLISHED

CERTIFIED ISO 9001 COMPANY

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