

PRODUCT DESCRIPTION

ONE COMPONENT AIR DRY EPOXY ESTER TOP COAT 51118

RSI PRIMER 51118 is designed for use as an epoxy ester topcoat available in a wide range of colors. The product is ideally suited for metal, interior and exterior surfaces with good color and gloss retention.

RSI TOPCOAT 51118 can be applied as an inhibitive primer on blasted steel structure.

Standard color availability Manufactured only in light gray and off white color.

GENERAL PROPERTIES

Adhesion	Good to both grit blasted and manually prepared surfaces.
Corrosion Resistance	Good on correctly prepared surfaces.
Temperature resistance	Dry: Maximum 120 °C

PHYSICAL PROPERTIES:

Colors/Shade No	Grey/Ral No.
Finish	Semi gloss
Volume Solid	45%
Theoretical spreading rate	15 m ² /liter 30 Mic. Dft.
Flash point	35 °C
Specific gravity	1.25-1.35 kg/liter
V.O.C.	Max. 500 gr/liter
Shelf life	1 Year (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

APPLICATION

Conditions	Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3 °C above the dew point.		
Method	Airless sprays	Air spray	Brush (touch-up)
Thinner (max. vol.)	30049 (10-30%)	30049(25%)	30049 (5%)
Spray setting			
Pump ratio minimum	30:1		
Tip size	.021”	1.8 mm	
Tip pressure	150 bar / 2200 Psi	4 – 5 bar	
	(Airless spray data are indicative and subject to adjustment)		
Cleaning of tools	Thinner 30049		
Indicated film thickness, dry	45 microns		
Indicated film thickness, wet	100 microns		

DRYING AND CURING TIMES AT (20 °C)

Dry to touch	Max.4 hour
Hard dry	16 hours
Full curing	10 days
Recoat interval, min	16 hours
Recoat interval, max	15 days , see REMARKS

SURFACE PREPARATION

New steel	Steel surface should ideally be abrasive blast cleaning to minimum Sa 2. The surface must be completely clean and dry prior to application. And its temperature must be above the dew point to avoid condensation.
Maintenance	Remove oil and grease, etc. with suitable detergent. Remove salt and other contaminants by (high pressure) fresh water cleaning. Remove all rust and loose material by abrasive blasting or power tool cleaning. Dust off residues. Touch up to full film thickness.

REMARKS

PRECEDING COAT:	AIR DRYING EPOXY ESTER PRIMER OR INTER MEDIATE COAT.
SUBSEQUENT COAT:	None.
Film thickness:	May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating intervals. Normal range is 40-50 microns1.6/ 2 mils.
Thinning:	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 30049 is recommended in general.
Recoating And drying/curing Time	

Physical data versus temperatures in mild atmosphere:					
Surface temperature	5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F	
Dry to touch approx.	12 hours	6 hours	3 hours	2 hours	
Resist condensing humidity/ light showers after	4 days	2 days	48 hours	24 hours	
Fully cured	20 days	14 days	15 days	10 days	
Recoating interval with alkyd intermediate	Min	24 hours	16 hours	8 hours	4 hours
	Max	None	None	None	None

Maximum recoating interval in moderate atmosphere is 15 days.

A completely clean surface is mandatory to ensure intercoat adhesion, especially at long Recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent.

Salts to be removed by fresh water hosing. To check an adequate quality of the surface cleaning a test patch is recommended before actual recoating.

SAFETY

Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult RSI material safety data sheets and follow all local and national safety regulations. Harmful or fatal if swallowed; immediately seek medical assistance. Avoid inhalations of possible solvent vapors or paint mist, as well as paint contact with skin and eyes. Apply only on well-ventilated areas and ensure that adequate forced ventilation exists when applying paint in confined spaces or when the air is stagnant. Always take precautions against the risks of fire and explosions.

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