

## PRODUCT DESCRIPTION

# TWO COMPONENT HIGH BUILD EPOXY 54151

(CURING AGENT 20080)

RSI EPOXY HB 54151 is a high-build, modified, two-component epoxy paint, which cures to a coating with good resistance to water, splashes of mineral oils, aliphatic hydrocarbons, and to abrasion and impact. Limited resistance to aromatic and stronger solvents and to acids and oxidizing materials.

RSI EPOXY HB 54151. As a Top coat with no maximum recoating interval in EPOXY/POLYURETHANE systems. CURING AGENT 20080, polyamide, is typically for use above 5°C/41°F.

**Standard color availability** Manufactured light gray, beige and off white colors.

## GENERAL PROPERTIES

<b>Adhesion</b>	Excellent to both primed & grit blasted and manually prepared steel surfaces.
<b>Corrosion Resistance</b>	Excellent on correctly prepared steel surfaces and primed surfaces.
<b>Temperature resistance</b>	Dry: Maximum 120 °C

## PHYSICAL PROPERTIES:

<b>Colors/Shade No</b>	Grey /Ral. No
<b>Finish</b>	Flat
<b>Volume Solid</b>	60%
<b>Theoretical spreading rate</b>	12 m <sup>2</sup> /liter 50 Mic. Dft.
<b>Flash point</b>	28 °C
<b>Specific gravity</b>	1.45-1.55 kg/liter
<b>V.O.C.</b>	Max. 280gr/liter
<b>Shelf life</b>	1 Years (25°C / 77°F) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

## MIXING

<b>Mixing ratio (by weight)</b>	Component A 54151	Component B 20080
	100	12.5
<b>Pot life</b>	8 hours (20 °C/ 68 °F)	

## APPLICATION

<b>Conditions</b>	Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3 °C above the dew point.	
<b>Method</b>	Airless sprays	Brush (touch-up)
<b>Thinner (max. vol.)</b>	1051 (10-30%)	1051 (5%)
<b>Spray setting</b>		
<b>Pump ratio minimum</b>	40:1	
<b>Tip size</b>	0.021" – 0.019"	
<b>Tip pressure</b>	150 bar / 2100 Psi (Airless spray data are indicative and subject to adjustment)	
<b>Cleaning of tools</b>	Thinner 1051	
<b>Indicated film thickness, dry</b>	60 microns	
<b>Indicated film thickness, wet</b>	100 microns	

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## DRYING AND CURING TIMES AT (20 °C)

<b>Dry to touch</b>	1 hour
<b>Hard dry</b>	24 hours
<b>Full curing</b>	7 days
<b>Recoat interval, min</b>	8 hours
<b>Recoat interval, max</b>	14 days , see REMARKS

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## SURFACE PREPARATION

<b>New steel</b>	Steel surface should ideally be abrasive blast cleaning to minimum Sa 2½. The surface must be completely clean and dry prior to application. And its temperature must be at least 3°C above the dew point to avoid condensation.
<b>Primed surfaces</b>	The surface should be stable, firm, dry and free of dust, sand, loose old paint, dirt, grease and oil. It is recommended to apply mid coat before exceeding maximum interval of primer.

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## REMARKS

**PRECEDING COAT:** Epoxy primers such as RSI 74352 and Epoxy intermediate such as 63150.

**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 100-150 microns/ 4-6 mils.

**Thinning:** The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 1051 is recommended in general.

**Recoating and drying/curing time** Recoating intervals related to later conditions of temperature:  
(75 micron/3 mils dry film thickness of RSI 74151)

Physical data versus temperatures:					
Surface temperature		5°C/41°F	10°C/50°F	20°C/68°F	30°C/86°F
Dry to touch approx.		16 hours	8 hours	4 hours	3 hours
Resist condensing humidity/ light showers after		4 days	2 days	24 hours	12 hours
Fully cured		20 days	14 days	7 days	5 days
Recoating interval with epoxy and polyurethane top coats	Min	24 hours	16 hours	8 hours	4 hours
	Max	60 days	30 days	14 days	10 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.**

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## 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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Ranghay e Sanati e Iran Co.  
Product data sheet 54151

**RSI**  
**COATING**