RSI COATING

PRODUCT DATA
RSI HB 64151

PRODUCT DESCRIPTION

TWO COMPONENT HIGH BUILD EPOXY 64151

(CURING AGENT 20080)

RSI EPOXY HB 64151 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 64151 As an intermediate coat with no maximum recoating interval in EPOXY/POLYURETHANE systems. CURING AGENT 20086, polyamide, is typically for use above 5°C/41°F.

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

GENERAL PROPERTIES

Adhesion	Excellent to both primed & grit blasted and manually prepared steel surfaces.
Corrosion Resistance	Excellent on correctly prepared steel surfaces and primed surfaces.
Temperature resistance	Dry: Maximum 120 ºC

PHYSICAL PROPERTIES:

Colors/Shade No	Grey /Ral No
Finish	Flat
Volume Solid	60%
Theoretical spreading rate	12 m² /liter 50 Mic. Dft.
Flash point	28 ºC
Specific gravity	1.45-1.55 kg/liter
V.O.C.	Max. 280gr/liter
Shelf life	1 Years (25ºC / 77ºF) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage.

MIXING

Mixing ratio (by weight)	Component A 64150	Component B 20080
	100	12.5
Pot life	8 hours (20 ºC/ 68 ºF)	

APPLICATION

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

DRYING AND CURING TIMES AT (20 ºC)

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

SURFACE PREPARATION

New steel 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.

Primed surfaces 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.

REMARKS

PRECEDING COAT: Epoxy primers such as RSI 74250 ZC or RSI ZINC 74352.

SUBSEQUENT COAT: Epoxy, and polyurethane top coat such as 52131 or 54151.

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 50-125 microns/ 2-5 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 64150)

Physical data versus temperatures:					
Surface temperature		5ºC/41ºF	10ºC/50ºF	20ºC/68ºF	30ºC/86ºF
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.

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.

Mar 2010

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