



**RSI**  
INDUSTRIAL  
PAINTS Inc. .

## ZINC-RICH EPOXY PRIMER REP-113

### PRODUCT DESCRIPTION

**REP-113** is a two component polyamide cured zinc rich epoxy coating. It is a very high zinc dust containing product. It conforms to the compositional requirements of SSPC paint 20, level 2. It provides very good corrosion protection as part of a complete coating system. To be used as primer in atmospheric environments. Suitable for carbon steel, repair of inorganic zinc silicate coating and damaged galvanised steel substrates.

**Standard color availability** Manufactured only in metal gray color.

### GENERAL PROPERTIES

<b>Adhesion</b>	Excellent on correctly prepared steel surfaces.
<b>Corrosion Resistance</b>	Excellent on correctly prepared steel surfaces.
<b>Zinc content in dry film</b>	77±2%
<b>Salt spray ASTM B117</b>	1000 hrs Single Layer

### PHYSICAL PROPERTIES

<b>Color</b>	Gray
<b>Finish</b>	Flat
<b>Volume Solid</b>	59 ± 3%
<b>Theoretical spreading rate</b>	11.8 m <sup>2</sup> /liter at 50 Mic. Dft.
<b>Flash point</b>	27 °C
<b>Specific gravity</b>	2.55±0.1 kg/liter
<b>V.O.C.</b>	Max. 350 gr/liter
<b>Shelf life</b>	1 year (25°C) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage. Storage environment should be ventilated and away from sunlight and high temperature (above 30 ° C)

### MIXING

<b>Mixing ratio (by weight)</b>	Component A: 14	Component B: 1
<b>Pot life</b>	8 h at 23°C	

### 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 spray	Brush (touch-up)
<b>Thinner (max. vol.)</b>	RTH-104 (5%)	RTH-104(5%)
<b>Pump ratio minimum</b>	30:1	
<b>Tip size</b>	0.015"-0.021"	
<b>Tip pressure</b>	110-150 bar	
<b>Cleaning of tools</b>	RTH-104	
<b>Indicated film thickness, dry</b>	50-80 microns	
<b>Indicated film thickness, wet</b>	80-120 microns	

## DRYING AND CURING TIMES

<b>Condition</b>	Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with: * Good ventilation (Outdoor exposure or free circulation of air) * Typical film thickness * One coat on top of inert substrate
<b>Surface temperature</b>	23 °C
<b>Surface drying</b>	1 hour
<b>Deep drying</b>	3 hours
<b>Complete curing</b>	7 days
<b>Recoat interval, min</b>	8 hours
<b>Recoat interval, max</b>	7 days

## APPLICATION AND CURING CONDITIONS

<b>Surface preparation</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 above the dew point to avoid condensation. Optimum performance, including adhesion, corrosion protection, heat resistance and chemical resistance is achieved with recommended surface preparation.
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Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)

## REMARKS

<b>Subsequent coat</b>	Epoxy intermediate and Epoxy Top Coat.
<b>Film thickness</b>	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 50-80 microns.
<b>Thinning</b>	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. RTH-104 is recommended in general. <i>(i) A completely clean surface is mandatory to ensure inter coat adhesion, especially at long recoating intervals. Any dirt, oil, and grease have to be removed, e.g. with suitable detergent.</i> <i>(ii) 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.</i>

## SAFETY

This product is intended for use of professional applicators. Applicators and operators shall use appropriate protection equipment when using this product. Use it in well ventilated environment and prevent direct contact with skin. Spillage on the skin should immediately be removed with suitable cleaner. Eye should be well flushed with water and medical cleaner.

## RSI Co.

Product data sheet REP-113  
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