



## EPOXY POLYAMIDE PRIMER REP-127

### PRODUCT DESCRIPTION

REP-127 is a 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. Suitable for properly prepared carbon steel, stainless steel, aluminium and galvanised steel.

### GENERAL PROPERTIES

Adhesion	Excellent on correctly prepared steel surfaces.
Corrosion Resistance	Excellent on correctly prepared steel surfaces and primed surfaces.

### PHYSICAL PROPERTIES

Colors/Shade No	Ral No
Finish	Matt-Flat
Volume Solid	65±3%
Theoretical spreading rate	10.8 m <sup>2</sup> /liter 60 mic. Dft.
Flash point	28 °C
Specific gravity	1.65±0.05 kg/liter
V.O.C.	Max. 380 gr/liter
Shelf life	1 Years (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

Mixing ratio (by weight)	Component A: 7	Component B: 1
Pot life	8 hours (20 °C)	

### 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	Brush (touch-up)
Thinner (max. vol.)	RTH-104 (5-10%)	RTH-104(10-15%)
Pump ratio minimum	40:1	
Tip size	0.019" – 0.021"	
Tip pressure	150 bar / 2100 Psi	
	(Airless spray data are indicative and subject to adjustment)	
Cleaning of tools	RTH-104	
Indicated film thickness, dry	60-70 microns	
Indicated film thickness, wet	95-110 microns	

### DRYING AND CURING TIMES

Condition	Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.	
Surface temperature	23 °C	
Dry to touch	30 min	
Hard dry	12 hours	
Full curing	7 days	
Recoat interval, min	8 hours	
Recoat interval, max	5 days	

## APPLICATION AND CURING CONDITIONS

### Condition

Steel surface should ideally be abrasive blast cleaning to minimum Sa 2½. The surface must be completely clean and dry at the time of application, and its temperature must be above the dew point to avoid condensation.

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Stainless steel	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile
Aluminium	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile
Galvanised steel	The surface shall be clean, dry and appear with a rough and dull profile.	Sweep blast-cleaning using nonmetallic abrasive leaving a clean, rough and even pattern.
Coated surfaces	Clean, dry and undamaged compatible coating	Clean, dry and undamaged compatible coating

## REMARKS

### Subsequent coat

Epoxy Intermediate or top coat such as REP-202 or REP-302.

### 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 60-70 micron.

### Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. RTH-104 is recommended in general.

- (i) 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.
- (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.

## 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.

## RSI Co.

Product data sheet REP-127  
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