



RSI
INDUSTRIAL
PAINTS Inc.

POLYAMIDE CURED EPOXY FINISH COATING REP-303

PRODUCT DESCRIPTION

REP-303 is a two component polyamide cured epoxy coating. It has a semi gloss finish. Suitable for properly prepared carbon steel, galvanised steel, stainless steel and aluminium substrates.

This product can be applied as a top coat and mid coat in epoxy systems on primed surfaces. When exposed to direct sun light in outdoor service become discolor and decrease of gloss.

Standard color availability Manufactured according RAL catalogue.

GENERAL PROPERTIES

Adhesion	Excellent to primed surfaces.
Corrosion Resistance	Excellent on correctly primed surfaces.

PHYSICAL PROPERTIES

Colors/Shade No	RAL No
Finish	Semi gloss
Volume Solid	45±3%
Theoretical spreading rate	9 m ² /liter 50Mic. Dft.
Flash point	27°C
Specific gravity	1.6±0.1 kg/liter
V.O.C.	Max. 350 gr/liter
Shelf life	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

Mixing ratio (by weight)	Component A: 6	Component B: 1
Pot life	1.5 hours (23 °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	Roller: Use a suitable roller. Care must be taken to achieve the specified dry film thickness.	Brush (touch-up): Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.
Thinner (max. vol.)	RTH-104 (10-15%)	RTH-104(5%)	RTH-104(5%)
Spray setting			
Pump ratio minimum	30:1		
Tip size	0.013" – 0.017"		
Tip pressure	150 bar / 2200 Psi		
Cleaning of tools	RTH-104		
Indicated film thickness, dry	50-60 microns		
Indicated film thickness, wet	110-135 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	1 hour
Hard dry	7 hours
Full curing	7 days
Recoat interval, min	4 hours

Recoat interval, max

7 days

APPLICATION AND CURING CONDITIONS

Condition

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. Minimum temperature for curing is 10°C. High humidity and/or condensation during application and the following 16 hours (20°C) may adversely affect the film formation. In confined spaces provide adequate ventilation during application and drying.

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

Preceding Coat

Epoxy primer REP-127or Epoxy midcoat REP-202.

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 50-60 microns.

Thinning

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

- *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.*
- *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-303

July 2022

