

EPOXY TIE COAT REP-301

PRODUCT DESCRIPTION

REP-301 is a two component coating base on epoxy and polyamide resins.it can be used as holding primer, sealer and as a tie coat on top of inorganic zinc silicate primers.

When exposed to direct sun light in outdoor service become discolor and decrease of gloss.

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GENERAL PROPERTIES

Adhesion Excellent to primed surfaces.



Colors/Shade No Brown and grey (MIO based) cream and white (without MIO)

Finish Semi Flat. **Volume Solid** 50±2%

Theoretical spreading rate 20 m² /liter 25 Mic. Dft.

Flash point 25 °C

Specific gravity 1.40 ± 0.05 kg/liter VOC Max. 150 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 $^{\circ}$ C).

MIXING

mixing ratio (by weight) Component A: 5 Component B: 1

Pot life 4-5 hours at 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.

MethodAir less sprayBrush (touch-up)Thinner (max. vol.)RTH-112 (30%)RTH-112(10-20%)

Pump ratio minimum 45:1

 Tip size
 0.017" - 0.019"

 Tip pressure
 120 bar / 1750 Psi

Cleaning of toolsRTH-112Indicated film thickness, dry25 -40 micronsIndicated film thickness, wet50-80 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 temperature23 °CSurface drying2 hoursDeep drying6-8 hoursComplete curing7 daysRecoat interval, min12 hours

Recoat interval, max None, see REMARKS

APPLICATION AND CURING CONDITIONS

Primed surfaces

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. 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. For zinc primed surfaces, ensure that the surface is clean, dry and free from any contamination and zinc salts before application.

REMARKS

PRECEDING COAT SUBSEQUENT COAT Film thickness

Thinning

Recoating and drying/curing time

Zinc ethyl silicate (RHR-102) Epoxy intermediate coat (REP-201)

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 25-50 microns.

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. RTH-112 is recommended in general.

Recoating intervals related to later conditions of temperature:

(35 micron dry film thickness)

Physical data versus temperatures					
Surface temperature		10°C	20°C	30°C	40°C
Dry to touch approx.		4 hours	2 hours	1 hour	30 min
Resist condensing humidity/ light showers after		24 hours	12 hours	7 hours	4 hours
Fully cured		14 days	7 days	4 days	3 days
Recoating interval with	Min	24 hours	12 hours	8 hours	4 hours
epoxy Intermediate or top coat	Max	None	None	None	None

- (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

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.

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