



RSI
INDUSTRIAL
PAINTS Inc.

ALKYD TOPCOAT RAK-302

PRODUCT DESCRIPTION

RAK-302 is a one component oxidatively drying alkyd coating. It has a semi gloss finish. It is fast drying. Can be used as primer or top coat in atmospheric environments. Suitable for properly prepared carbon steel and aluminium substrates.

Typical use Recommended for oil production tools, disposal bins, walls, valves, ceiling and also appropriate for touch-up purposes.

PHYSICAL PROPERTIES

Color	RAL No
Gloss Level	Semi gloss
Volume Solid	42±3%
Theoretical spreading rate	5.25 m ² /liter 80 Mic. Dft.
Specific gravity	1.25±0.1 kg/l
Flash point	27 °C
V.O.C.	435 g/l
Shelf life	12 months (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).

APPLICATION

Conditions	When the temperature is less than 10 °C and more than 45 °C and the humidity is more than 85% the paint application should be avoided. The temperature should be above dew point to avoid condensation. The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.		
Method	Spray: Use airless spray or conventional spray.	Brush: Appropriate for stripe coating and small areas. Care should be taken to achieve the specified dry film thickness	Roller: Care should be taken to achieve the specified dry film thickness.
Thinner (max. vol.)	RTH-101(5-10%)		
Nozzle tip	0.015"-0.019"		
Tip Pressure	150 bar (2100 psi)		
Cleaning tool	RTH-101		
Indicated film thickness, dry	50-80 micron		
Indicated film thickness, wet	120-190 micron		

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
Surface drying	3 hours
Deep drying	24 hours
Full drying	5 days
Recoat interval, min	16 hours

APPLICATION AND CURING CONDITIONS

Surface preparation

The surface should be free of any contamination. Before the operation, the surface should be washed with water and in the presence of oil, grease or other materials using a special solvent. It is also recommended for metal surfaces if there is a metal weld, clean up them to have a smoother surface.

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
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 and to remove all polish from the surface.	Dry abrasive blast cleaning to SSPCSP 13/NACE No. 6.
Coated surfaces	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)

REMARKS

Preceding coat

Alkyd or epoxy primer.

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 40-100 microns.

Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. RTH-101 is recommended in general.

Storage

The containers must be completely closed and kept in a dry, cool and well ventilated environment. Be careful not to have any heat source near the containers.

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 RAK-302

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