



RSI
INDUSTRIAL
PAINTS Inc.

ALKYD PHENOLIC PAINT RAK-311

PRODUCT DESCRIPTION

RAK-311 is a glossy, general purpose, alkyd phenolic paint forming a weather resistant coating. This product recommended as finishing coat for alkyd systems on exterior and interior steel in mildly to moderately corrosive environment e.g. engine rooms including tank tops, main engines and auxiliary machinery.

PHYSICAL PROPERTIES

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|----------------------------|--|
| Colors/Shade No | RAL No |
| Finish | Flat |
| Volume Solid | 45 ± 3% |
| Theoretical spreading rate | 11.25 m ² /liter 40Mic. Dft. |
| Flash point | 38 °C |
| Specific gravity | 1.25±0.05 kg/liter |
| V.O.C. | Max. 422 gr/liter |
| Shelf life | 18 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

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| 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 | Brush (touch-up) |
| Thinner (max. vol.) | RTH-117 (3-5%) | RTH-117 (10%) | RTH-117(10%) |
| Nozzle tip | 28:1 | | |
| Tip size | 0.013"-0.015" | | |
| Tip pressure | 110 bar | | |
| Cleaning of tools | RTH-117 | | |
| Indicated film thickness, dry | 30-50 microns | | |
| Indicated film thickness, wet | 70-110 microns | | |

DRYING AND CURING TIMES

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| 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. 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 |
| Surface temperature | 23 °C |
| Surface drying | 15 min |
| Deep drying | 4 days |
| Full curing | 7 days |

APPLICATION CONDITIONS

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| Surface preparation | Paint only clean, dry surfaces. Remove all grease, oil, soluble contaminants and other foreign matter by solvent cleaning. |
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REMARKS

Subsequent coat
Film thickness

A layer of RAK-311

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 30-50 microns.

Thinning

The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. RTH-117 is recommended in general.

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 RAK-311
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