



RSI
INDUSTRIAL
PAINTS Inc.

MODIFIED SOLVENT FREE AMINE-CURED PHENOLIC EPOXY REP-337

PRODUCT DESCRIPTION

REP-337 is a solvent-free, two-component, surface tolerant, high-build phenolic epoxy paint, which is suitable for buried pipeline and storage tanks exposed to high temperature (Up to 120 °C). This product is suitable for areas where optimum surface preparation is not possible or desired. This product has extremely corrosion protection, superior resistance to cathodic disbondment, impact and abrasion. It has a high resistance to most sour crude oils and a wide range of chemicals and solvents. It can be used on properly prepared carbon steel and concrete substrates

GENERAL PROPERTIES

Adhesion	Excellent to prepared carbon Steel and concrete surfaces.
Corrosion Resistance	Excellent corrosion resistance and superior resistance to cathodic disbondment.
Service temperature	Up to 120 °C

PHYSICAL PROPERTIES

Colors	RAL No
Finish	Gloss
Volume Solids	98±2%
Theoretical spreading rate	1 m ² /liter @ 1000 mic. Dft.
Flash point	90°C
Specific gravity	1.6±0.1 kg/liter
V.O.C.	Max 2 g/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 vol.)	Component A: 2	Component B: 1
Pot life	30 min (25 °C)	

APPLICATION

Conditions	The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured (less than 80%) in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying.		
Method	Airless spray	Dual airless	Brush, Roller (touch-up)
Thinner (max. vol.)	RTH-104 (5%)	No need	RTH-104 (5%)
Pump ratio minimum	1:68	1:61	
Tip size	0.027" – 0.031"	0.025" – 0.029"	
Tip pressure	260 bar / 3800 Psi	429 bar/6200 psi	
Cleaning of tools	RTH-104		
Indicated film thickness, dry	500-1500 microns		
Indicated film thickness, wet	500-1500 microns		

DRYING AND CURING TIMES

Condition	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 * Number of layer
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Temperature	15±2 °C	23±2 °C
Dry to touch	2 hours	1.5 hours
Hard dry	27 hours	22 hours
Full curing	10 days	7 days
Recoat interval, min	15 hours	8 hours
Recoat interval, max	6 days	4 days

APPLICATION AND CURING CONDITIONS

New steel	Steel surface should ideally be blast cleaned to minimum Sa 2½. 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. A surface profile should be 50-100 microns.
Concrete	<p>Allow new cast-in-place concrete to cure a minimum of 28 days at 75°F (24°C). Verify concrete dryness in accordance with ASTM F 1869 "Standard Test Method for Measuring Moisture Vapor Emission Rate of Concrete Subfloor Using Anhydrous Calcium Chloride" (moisture vapor transmission should not exceed three pounds per 1,000 square feet in a 24 hour period), F 2170 "Standard Test Method for Determining Relative Humidity in Concrete using in situ Probes" (relative humidity should not exceed 80%), or D 4263 "Standard Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method" (no moisture present). Concrete surface preparation by using grinding equipment or high pressure water jetting is critical to achieving the right surface profile prior to paint application.</p> <p>Before apply this product should be used recommended primer and fill cracks, voids and other surface imperfections with recommended grout. Surface preparation be done according to SSPC SP13/NACE NO 6 /ASTM D4258 -05 /ICRI TECHNICAL GUIDELINE 03741. Concrete surface should be clean, dry and undamaged compatible coating as per SSPC SP13/NACE NO 6 /ASTM D4258 -05 /ACI 503.6R97/SSPC-TR 5/ICRI TECHNICAL GUIDELINE 03741/NACE02203.</p>

REMARKS

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.
Thinning	The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate.
Recoat interval details	<p>Make sure that the next layer is applied before the maximum recoat interval, otherwise consult RSI technical experts.</p> <p>(i) <i>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.</i></p> <p>(ii) <i>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.</i></p>

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-337
December 2022

