RSI COATING

PRODUCT DATA
RSI HB 64551

## PRODUCT DESCRIPTION

# TWO COMPONENT HIGH BUILD MIO EPOXY 64551

(CURING AGENT 20080)

**RSI EPOXY MIO 64551** is designed for use as a high performance, barrier protection primer and mid coat base on epoxy and polyamide resins and micasius iron oxide pigments with an excellent anticorrosive efficiency in moderate to severe environment.

**RSI EPOXY MIO 64551** can be applied as a mid coat in epoxy systems on primed steel structure and as a primer on steel structure.

**Standard color availability** Manufactured light gray and beige colors.

## GENERAL PROPERTIES

| | |
|---|---|
| **Adhesion** | Excellent to both primed & grit blasted and manually prepared steel surfaces. |
| **Corrosion Resistance** | Excellent on correctly prepared steel surfaces and primed surfaces. |
| **Temperature resistance** | Dry: Maximum 120 ºC Wet: Maximum 50 ºC |

## PHYSICAL PROPERTIES:

| | |
|---|---|
| **Colors/Shade No** | Grey/Ral No |
| **Finish** | Flat |
| **Volume Solid** | 60% |
| **Theoretical spreading rate** | 6.5 m2 /liter 100 Mic. Dft. |
| **Flash point** | 29 ºC |
| **Specific gravity** | 1.55-1.65 kg/liter |
| **V.O.C.** | Max. 260 gr/liter |
| **Shelf life** | 1 Years (25ºC / 77ºF) from time of production. Depending on storage condition, mechanical stirring may be necessary before usage. |

## MIXING

| | | |
|---|---|---|
| **Mixing ratio (by weight)** | Component A 64551 | Component B 20080 |
| | 8 | 1 |
| **Pot life** | 8 hours (20 ºC/ 68 ºF) | |

## APPLICATION

| | | |
|---|---|---|
| **Conditions** | Do not apply when relative humidity exceeds 80% or when the surface to be coated is less than 3 ºC above the dew point. | |
| **Method** | Airless sprays | Brush (touch-up) |
| **Thinner (max. vol.)** | 1051 (10-30%) | 1051 (5%) |
| **Spray setting** | | |
| **Pump ratio minimum** | 40:1 | |
| **Tip size** | 0.021” – 0.023” | |
| **Tip pressure** | 200 bar / 2900 Psi | |
| | (Airless spray data are indicative and subject to adjustment) | |
| **Cleaning of tools** | Thinner 1051 | |
| **Indicated film thickness, dry** | 60 microns | |
| **Indicated film thickness, wet** | 100 microns | |

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## DRYING AND CURING TIMES AT (20 ºC)

| | |
|---|---|
| **Dry to touch** | Max.1 hour |
| **Hard dry** | 24 hours |
| **Full curing** | 7 days |
| **Recoat interval, min** | 8 hours |
| **Recoat interval, max** | 7 days , see REMARKS |

## SURFACE PREPARATION

**New steel** Steel surface should ideally be abrasive blast cleaning 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.

**Primed surfaces** 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.

## REMARKS

PRECEDING COAT: Epoxy primers such as RSI 73252 ZP or RSI ZINC 74352.

SUBSEQUENT COAT: Epoxy, polyurethane top coat such as 52131 or 52152.

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 80-125 microns/ 3.2-5 mils.

Thinning: The type and amount of thinner depend on application conditions, application method, temperature, ventilation, and substrate. Thinner 1051 is recommended in general.

Recoating and drying/curing time

| Physical data versus temperatures: | | | | | |
|---|---|---|---|---|---|
| Surface temperature | | 5ºC/41ºF | 10ºC/50ºF | 20ºC/68ºF | 30ºC/86ºF |
| Dry to touch approx. | | 16 hours | 10 hours | 6 hours | 3 hours |
| Resist condensing humidity/ light showers after | | 4 days | 2 days | 24 hours | 12 hours |
| Fully cured | | 20 days | 14 days | 7 days | 5 days |
| Recoating interval with epoxy and polyurethane top coats | Min | 24 hours | 16 hours | 8 hours | 4 hours |
| | Max | 15 days | 12 days | 7 days | 5 days |

**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.**
**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.

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