

CORROLESS RF65

TWO PACK POLYURETHANE REINFORCED FINISH

DESCRIPTION

A two-component, glass reinforced, acrylic urethane, semi-gloss topcoat.

PRODUCT FEATURES AND RECOMMENDED USES

- Excellent colour and UV resistance.
- Indefinitely recoatable.
- Tough durable semi-gloss finish, good anti-abrasion resistance and weathering characteristics and chemical resistance.
Approved for use by Network Rail (approved systems available on request).
- Glass reinforced for increased impermeability.
- Suitable for urban, marine or industrial environments.
- Applications include piping, cranes, mechanical equipment, bridges, storage tank exteriors, chemical plants and other structural steel.

TECHNICAL DATA

Volume Solids (±2%)

58%.

Volatile Organic Content

Base 431 g/litre (average) **Hardener** 112 g/litre

Specific Gravity

1.4 to 1.6 kg/litre (mixed material) depending on colour.

Film Thickness

Wet Film 52 - 86 microns. **Dry Film** 30 - 50 microns.

Theoretical Coverage

11.6 m²/litre at 50 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.

Mixing Ratio

9:1 by volume (base to hardener).

Pot Life (at 18°C)

4 hours.

Drying Times (at 50 microns dft)

	10°C	18°C	30°C
Dust Free	2 hours	1½ hours	45 minutes
Hard Dry	6 hours	4 hours	2 hours
Overcoating Minimum	24 hours	16 hours	12 hours
Maximum	Indefinite	Indefinite	Indefinite

Thinners and Cleaning solvent

Corroless Thinners No.5. (Solvent Gun Wash may be used for cleaning only).

Finish

Mid sheen.

Colours

Available in a wide range of colours.

Storage

Product has a shelf life of 2 years when stored in dry, cool conditions and protected from frost.

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APPLICATION DETAILS

Surface Preparation All surfaces when coated should be firm, clean, dry and free from all oil, grease, and other contamination. This is a finish coat and should be applied over Corroless primers or intermediate coats.
Recommended primers: Corroless EPF.
Intermediate coats: Corroless RF31.

Application Always follow the overcoating time for the selected primer.

Method	Airless Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2200-2500 psi	Yes – thinning required	Yes	Yes
Tip size	13-18 thou			
Fan angle	30° - 65°			

Spraying **Caution** contains **isocyanate**. Ensure adequate ventilation and wear air fed hood when spraying. **Airless spray** - an addition of up to 5% Corroless Thinners No.5 may be used for application at lower film builds or under cool conditions. **Conventional Spray** - an addition of up to 10% Corroless Thinners No.5 will be necessary for conventional spray. Maximum dry film thickness by this method is 75 microns.

Brushing/Rolling Suitable for brush or roller.

Mixing Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.

Stripe coating Stripe coat all edges, nuts, bolts, welds etc.

Application Temperature Range 5°C - 25°C.

Ambient Conditions Only apply in conditions of good ventilation, which should be maintained during drying. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point.

Overcoating Overcoatable with itself and Corroless Anti-graffiti topcoats. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water rinse and allow to dry before continuing.

Flash Point 21-32°C.

Health and Safety At all times observe precautionary notices on containers. Refer to Material Safety Data Sheets available from Corroless on request.

AN AXALTA COATING SYSTEMS BRAND



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