



CORROLESS RF35 (2006)

TWO PACK EPOXY TANK LINING

DESCRIPTION A, two-component, high build, solvent-less epoxy coating, reinforced with self-leaving glass flake

PRODUCT FEATURES AND RECOMMENDED USES

- Used in conjunction with Corroless EPF to BS 6920:2000 for use in contact with potable water.
- Listed in the Water Fittings and Materials Directory.
- Glass reinforced for increased impermeability
- Applications include water tanks, pipe linings, cargo holds, sewage works, reservoir tunnels and shafts, etc.

TECHNICAL DATA

Volume Solids ($\pm 2\%$) 96%

Volatile Organic Content **Base** 24 g/litre **Hardener** 0 g/litre

Specific Gravity 1.36 \pm 0.05 kg/litre (mixed material).

Film Thickness **Wet Film:** 208 microns **Dry Film:** 200 microns

Theoretical Coverage 4.8 m²/litre at 200 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.

Application Airless Spray, brush, or roller.

Mixing Ratio 3:1 by volume (base to hardener)

Pot Life (at 18°C) 45 minutes

DryingTime (at 18°C)

	10°C	18°C	30°C
Dust Free	12 hours	8 hour	6 hours
Hard Dry	24 hours	16 hours	12 hours
Overcoating Minimum.	24 hours	16 hours	12 hours
Maximum.	3 days**	3 days**	2 days**

** Note for solvent based products 7 days is acceptable but for solvent free products the maximums listed apply.

Finish Gloss

Colours Grey (approximately 18B21)

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 oil and grease, and other contamination. This is a finish coat and should be applied over Corroless primers or intermediate coats.
Recommended primers: Corroless EPF.

Application: Always follow the overcoating time.

Method	Airless Spray	Brush	Roller
Output fluid pressure	4000 psi	Yes	Yes
Tip size	19 thou		
Fan Angle	50°		

Spraying Airless Spray – At ambient temperatures the use of a heater block set at 35-40°C and a heavy duty pump such as a Graco King 63:1 King is recommended. Plural component feed systems such as Hydracat may also be used. Further details available on request.

Brushing/Rolling Apply un-thinned. When brushing, lay on, do not over brush. When rolling use a short nap lamb's wool roller is recommended followed by laying off with a brush.

Mixing Mix each component separately prior to mixing together for 2-3 minutes at medium speed. Over-mixing will create heat and reduce the working life. Always use a mechanical agitator. Ensure product is only used in the proportions recommended.

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

Application Temperature Range 8°C - 35°C.

Ambient Conditions Only apply in conditions of good ventilation, which should be maintained during curing. Do not apply when rain, mist, sleet or snow are imminent. During application and curing 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 – for overcoating with other Corroless topcoats please consult Corroless. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water wash and allow to dry before continuing. If maximum overcoat times are exceeded, abrade the surface to provide a key, wash down with fresh water and allow to dry.

Flash Point Greater than 55°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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