

CORROLESS RF31

TWO PACK EPOXY REINFORCED INTERMEDIATE/FINISH

DESCRIPTION

A high solids glass reinforced, chemically resistant, two pack epoxy intermediate/finish.

PRODUCT FEATURES AND RECOMMENDED USES

- Excellent chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts.
- Cures down to 2°C
- Withstands splashes of oxidising acids or bleaching agents.
- Withstands most greases and immersion in oil.
- Withstands immersion in aliphatic solvents and splashes of aromatic solvents.
- Durable finish used for long-term performance both on and off shore.
- Gives excellent protection in urban, marine and industrial environments.

TECHNICAL DATA

Volume Solids (±2%)

82%.

Volatile Organic Content

173 ± 20 g/litre

Specific Gravity

1.46 to 1.50 kg/litre (mixed material) depending on colour.

Film Thickness

Wet Film 152 microns. **Dry Film** 125 microns.

Theoretical Coverage

6.6 m²/litre at 125 microns dft. Practical coverage rate can vary depending on application method, temperature, profile and porosity of the substrate.

Mixing Ratio

1:1 by volume (base to hardener).

Pot Life (at 23°C)

3½ hours.

Drying Times (at 50 microns dft)

	5°C	10°C	23°C
Dust Free	19 hours	6 hours	3 hours
Hard Dry	15 hours	7 hours	2 hours
Overcoating Minimum	24 hours	16 hours	10 hours
Maximum	7 days	7 days	3 days

Thinners and Cleaning Solvent

Corroless Thinners No.4. (Solvent Gun Wash may be used for cleaning only).

Finish

Gloss (will chalk on exterior exposure).

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 an intermediate or finish coat and should be applied over appropriate Corroless primers.
Recommended primer: Corroless EPF.

Application Always follow the overcoating time for the selected primer.

Method	Airless Spray	Conventional Spray	Brush	Roller
Output Fluid Pressure	2500-3000 psi	Yes – thinning required	Yes	No
Tip size	19-27 thou			
Fan angle	30° - 65°			

Spraying For conventional spray, an addition of up to 10% Corroless Thinners No.4 will be required.

Brushing Apply unthinned, do not over brush.

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 2°C (10°C preferred) - 30°C. (Do not apply below 2°C).

Ambient Conditions High humidity and condensation will impair gloss. 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, Corroless RF61 and RF65. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water rinse and allow to dry before continuing. If maximum overcoating times are exceeded, abrade the surface and wash down with fresh water to remove contamination and allow to dry.

Flash point 23-60°C.

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

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