

Corroless RF61

Two Pack Polyurethane Reinforced Gloss Finish

Issue Date: June 2020
Code: 4836
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Product Description	A two component, glass reinforced, aliphatic polyurethane gloss finish.				
Features & Use	<ul style="list-style-type: none"> • Excellent gloss retention • Tough durable finish, good anti-abrasion resistance and weathering characteristics • Glass reinforced for increased impermeability • Excellent chemical resistance • Infinitely recoatable • Durable finish used for long-term performance both on and offshore • Gives excellent protection in urban, marine and industrial environments • Applications include piping, cranes, mechanical equipment, storage tank exteriors, bridges chemical plant and other structural steel 				
Approvals/ Certification	<ul style="list-style-type: none"> • Sold on track record 				
Finish	High Gloss				
Volume Solids	53% ± 2%				
VOC Content	Base 428 g/litre (average), Hardener 379 g/litre ± 20g /litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	30 µm	56 µm	17.7 m ² /litre	
	Maximum	60 µm	113 µm	8.8 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied at 40 microns DFT	+10°C	+18°C	+30°C	
	Dust Free		2 hrs	1½ hrs	45 minutes
	Hard Dry		6hrs	4 hrs	2 hrs
	Overcoating	Minimum	24 hrs	16 hrs	12 hrs
		Maximum	Indefinite	Indefinite	Indefinite
Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Available in a wide range of colours				
Mix Ratio	5:1 by volume (base to hardener)				
Pot Life	4 hours at 18°C				
SG	1.1 1.3 kg/litre (mixed material) varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

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Surface Preparation	<ul style="list-style-type: none"> All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination This is a finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF Intermediate coat: Corroless RF31 														
Mixing	<p>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.</p>														
Thinner / Cleaner	<p>Corroless Thinners No.5. (Solvent Gun Wash may be used for cleaning only)</p>														
Application Conditions	<p>High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes-Thinning required</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes-Thinning required	Yes	Yes				
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	Yes	Yes-Thinning required	Yes	Yes											
<ul style="list-style-type: none"> Airless spray: output fluid pressure 2200-2500 psi, tip size 13-18 thou, Fan Angle 30-65°. Caution contains isocyanate. Ensure adequate ventilation and wear air fed hood when spraying. An addition of 5-10% of Corroless Thinners No.5 is recommended for best results when airless spraying. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.5 will be required Brush: apply unthinned, lay on, do not over brush 															
Product Notes	<ul style="list-style-type: none"> Caution contains isocyanate Application Temperature: Range 5°C (10°C preferred) to 25°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself, or RF65 If overcoating time exceeds 24 hrs and contamination has occurred clean using a detergent solution/fresh water to remove contamination rinse and allow to dry before continuing 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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