

Corroless RF65

Two Pack Polyurethane Reinforced Finish

Issue Date: June 2020
Code: 4837
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Product Description	A two component, glass reinforced, acrylic urethane semi-gloss finish.				
Features & Use	<ul style="list-style-type: none"> • Excellent colour and UV resistance • Tough durable semi-gloss finish, good anti-abrasion resistance and weathering characteristics both onshore and offshore • Glass reinforced for increased impermeability • Excellent chemical resistance • Indefinitely recoatable • 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"> • Approved for use by Network Rail with Corroless EPF as primer. Systems for blast prepared surfaces: XM92 M21,085 and XN90 N2,054 System for hand prepared surfaces: XM92 M24,084 • For full details and a copy of the certificate contact Corroless Technical 				
Finish	Semi-Gloss				
Volume Solids	58% ± 2%				
VOC Content	Base 431 g/litre (average) Hardener 112 g/litre ± 20g /litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	30 µm	52 µm	19.3 m ² /litre	
	Maximum	50 µm	86 µm	11.6 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 50 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	9:1 by volume (base to hardener)				
Pot Life	4 hours at 18°C				
SG	1.4-1.6 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 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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