

technical data

Corroless RF65

Two Pack Polyurethane Reinforced Finish

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Product Description	A two compon	ent, glass reinfor	ced, acı	rylic uret	hane semi-gloss	s finish.			
Features & Use	 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	 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% <u>+</u> 2%								
VOC Content	Base 431 g/litre (average) Hardener 112 g/litre ± 20g /litre								
Film Thickness Range And Coverage		Dry Film Thic	Dry Film Thickness		ilm 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 shap and roughness of the surface to be coated								
Drying Times	Applied at 50 r	microns DFT	+10ºC		+18ºC	+30°C			
	Dust Free		2 hrs		1½ hrs	45 minutes			
	Hard Dry		6hrs		4 hrs	2 hrs			
	Overcoating	Minimum		hrs	16 hrs	12 hrs			
		Maximum		lefinite	Indefinite	Indefinite			
	Drying and recoat times are related to the film thickness, temperature, the relative humidi 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	 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	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.									
Thinner / Cleaner	Corroless Thinners No.5. (Solvent Gun Wash may be used for cleaning only									
Application Conditions	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.									
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller					
		Yes	Yes-Thinning required	Yes	Yes					
	 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	 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	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.									



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