

Corroless RF35 (2022)

Two Pack Epoxy Tank Lining

Issue Date: July 2021
Code: L8RF45N
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Product Description	A two-component high build solvent-less epoxy coating.				
Features & Use	<ul style="list-style-type: none"> • Good chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts - seek advice from Corroless • Withstands most greases and immersion in oil • Withstands immersion in aliphatic solvents and splashes of aromatic solvents • NOT suitable for contact with petrol • Glass reinforced for increased impermeability • Applications include water tanks, pipes and fittings, cargo holds and ballast tanks, sewage works, reservoir tunnels and shafts etc. 				
Approvals/ Certification	<ul style="list-style-type: none"> • NATO stock number 0442 8010 99 337 0778 				
Finish	Gloss (will chalk on exterior exposure)				
Volume Solids	96% ± 2%				
VOC Content	Base 24 g/litre Hardener 0 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	200 µm	208 µm	4.8 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 200 microns DFT	10°C	18°C	30°C	
	Dust Free	12 hrs	8 hrs	6 hrs	
	Hard Dry	24 hrs	16 hrs	12 hrs	
	Overcoating	Minimum	24 hrs	16 hrs	12 hrs
		Maximum	3 days	3 days	2 days
	Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	Grey (approximately BS 18B21)				
Mix Ratio	3:1 by volume (base to hardener)				
Pot Life	45 minutes at 18°C				
SG	1.36 ±0.05 kg/litre (mixed material)				
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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<p>Surface Preparation</p>	<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 an intermediate or finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF 										
<p>Mixing</p>	<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>										
<p>Thinner / Cleaner</p>	<p>Corroless Thinners No.4. Solvent Gun wash can be used for cleaning only</p>										
<p>Application Conditions</p>	<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>										
<p>Application Methods</p>	<table border="1" data-bbox="443 925 1476 1048"> <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>No</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless spray: Plural component feed systems such as ‘Graco Hydra-Cat’ are recommended. Output fluid pressure 4000 psi, Tip Size 19 thou, Fan Angle 50°. For detailed advice contact Corroless Technical. Brush: apply un-thinned, lay on, do not over brush 	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	No	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	Yes	No	Yes	Yes							
<p>Product Notes</p>	<ul style="list-style-type: none"> Application Temperature: Range 8°C -35°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself. To overcoat with other Corroless products consult Corroless Technical If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water 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 before continuing 										
<p>Health & Safety</p>	<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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