

CORROLESS RF33

TWO PACK EPOXY INTERMEDIATE/FINISH

DESCRIPTION A two-component, high solids, epoxy intermediate/finish coating.

PRODUCT FEATURES AND RECOMMENDED USES

- Will cure down to 2°C although cure time will be extended.
- Indefinitely overcoatable with itself.
- Film build per coat of 125 microns (brush) and 200 microns (spray).
- High film build enables minimum number of coats.
- Can be used to upgrade existing alkyds or chlorinated rubber systems to an epoxy/polyurethane specification (see product notes on page 2).
- For summer and winter use.

TECHNICAL DATA

Volume Solids (±2%) 82%.

Specific Gravity 1.46-1.50 kg/litre (mixed material, varies with colour).

Film Thickness **Wet Film** 152-244 microns. **Dry Film** 125-200 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.

Application Airless spray, brush or roller.

Mixing Ratio 1:1 by volume (base to hardener).

Pot Life (at 18°C) 3½ hours.

Drying Times
at recommended dft

	5°C	10°C	18°C
Dust Free	9 hours	6 hours	3 hours
Hard Dry	15 hours	10 hours	6 hours
Overcoating Minimum	15 hours*	10 hours*	6 hours*
Maximum	*Indefinite if clean and sound		

Thinners and Cleaning solvent Thinning not recommended. Solvent Gun Wash may be used for cleaning only.

Finish High Sheen.

Colour Wide Range of BS4800 and RAL Shades

Storage Store in dry, cool conditions and protect from frost .

CORROLESS Corrosion Control, Worldwide Headquarters, Kelvin Way, WEST BROMWICH, West Midlands B70 7JZ,

Telephone:
+44 (0)121 524 2235

Fax:
+44 (0)121 553 2787

Web:
www.corroless.com

e-mail:
contact@corroless.com

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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/finish coat and should be applied over Corroless primers or intermediate coats.
Approved primer: Corroless EPF.

Application Always follow the overcoating time for the primer.

Method	Airless Spray	Brush	Roller
Output Fluid Pressure	2000-3000 psi	Yes	Yes
Tip size	19-27 thou		
Fan angle	50°		

Mixing Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Over-mixing will create heat and reduce the working life. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.

Stripe coating Stripe coat all edges, nuts, bolts, welds etc.

Overcoating Overcoatable with itself – for overcoating with other Corroless topcoats please consult Corroless.. No maximum overcoating times but ensure the surface is clean. If contamination has occurred, clean using a detergent solution/fresh water rinse to remove contamination and allow to dry before continuing.

Application Temperature Range 8°C - 25°C.

Ambient Conditions 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.

Flash Point 32 - 55°C.

Product Notes Product will chalk, the degree to which is subject to atmospheric conditions. For UV resistance overcoat with Corroless RF61 or Corroless RF65.

When overcoating with Corroless RF61 or RF65 – allow 24 hours minimum at 18°C, when Corroless RF33 is applied at 125 microns dft.

When overcoating with conventional, chlorinated rubber or vinyl, ideally overcoat between 24 – 48 hours at 18°C, with a maximum of 7 days, or abrading will be required.

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