

Two-component epoxy vinyl sealer with excellent adhesion, durability, and great chemical, moisture, ultra-violet radiation, and weather resistances.

**USES AND SUITABLE TOP-COATS**

Recommended Uses Intermediate and finish coat for metal surfaces and maintenance operations in marine and offshore environments.  
 Suitable Top-Coats Ronaseal 1415 can be over-coated with a wide range of epoxy coatings and polyurethane systems and Antifouling Coatings.

**CHEMICAL COMPOSITION**

Type of Binder	Epoxy –Polyamio-Amide	Solid Content After Mixing	76± 1% By Weight
Number of Component(s)	2 Components		57± 2% By Volume
Curing Mechanism	Chemical Reaction	Flash Point	29°C (84°F)

**PHYSICAL PROPERTIES**

Finish Semi Gloss  
 Colour Silver Grey(RAL-7001).  
 Specific Gravity after Mixing 1.50 ± 0.05 gr/cm<sup>3</sup>

**APPLICATION DETAILS**

Surface Preparation All oil, grease, dirt and other contaminants must be removed from the surface. Sandblast according to Swedish Standard (SIS 5900). Sa 2 ½, and treatment with an epoxy primer is recommended.  
 Mixing Ratio Component A: 100 Parts by weight Component B :RTB-9400 10 Parts by weight  
 Mixing Instructions Mix component A thoroughly with a suitable mixer, then add component B slowly and mix well for 5 minutes. Keep the mixture for 5 additional minutes prior to thinning down to allow for the pre-reaction time. Do not thin down each component separately.  
 Pot Life 4 Hours at 25°C  
 Theoretical Consumption 260 gr/m<sup>2</sup> @ 100 Microns DFT

Paint Application	Methods	Airless Spray	Air Spray	Brush	Roller
	Nozzle Size	0.017" – 0.023"	1.80 mm	---	---
	Pump Ratio	1 / 45	---	---	---
	Air Pressure	4 – 6 Bar	3 – 5 Bar	---	---
	Thinning	8 – 15% T-444	10– 20% T-444	3 – 5% T-444	3 – 5% T-444

Film Thickness		Recommended	Minimum	Maximum
	Wet Film Thickness (µm)	175	90	265
	Dry Film Thickness (µm)	100	50	150

Drying Time	Substrate Temp.	10°C	25°C	35°C
	Tack Free Time	4-5 Hours	2-3 Hours	1-2 Hours
	Dry to Handle	24-30 Hours	8-10Hours	12-18 Hours
	Recoating Time	Min. 16 Hours	Min. 16 Hours	Min. 16 Hours
		Max. 11 Days	Max. 10 Days	Max. 9 Days

*\*Drying time calculated at 25°C according to ASTM test method D-1640 for 100 µm WFT*

Application Limits	Relative Humidity	Min. ---	Max. 80%
	Temperature	Min. +5°C	Max. +40°C
	Substrate Temperature*	Min. +5°C	Max. +45°C

*\*Please note that the substrate temperature should be at least 5°C above the dew point*

Recommendations -Should the recoating interval have expired, please refer to the procedures outlined in the Ronass Instruction Leaflet.  
 -Clean tools thoroughly before and immediately after use with cleaning solvent T-111 or T-444.

**PACKING, STORAGE AND SAFETY**

Packing Component A (Epoxy): 20 Liter Containers | Component B (Hardener):5 Liter Containers  
 Storage Conditions To be stored in cool and dry conditions in original sealed containers.  
 Shelf Life At least 18 months after delivery in original sealed containers and proper storage conditions with temperature of 25°C.  
 Safety This product contains organic solvents and flammable materials. Keep away from sparks, fires, electrical cables and equipments,, direct sunshine and out of children's reach.  
 Protect skin, eyes, and avoid prolonged breathing of solvent vapor during application. Use with adequate ventilation.