# RONASEAL
## RTB-1415 (Two-Component Epoxy Sealer)

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

## USES AND SUITABALE 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/cm³ |

## 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
Component A: 6 Parts by volume  Component B :RTB-9400  1 Parts by volume

**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/m² @ 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.<br>Protect skin, eyes, and avoid prolonged breathing of solvent vapor during application. Use with adequate ventilation. |