

Special two-component, high-build Zinc-rich epoxy primer with excellent mechanical resistances and anti-corrosive properties.

USES AND SUITABLE TOP-COATS

Recommended Uses	First coat for steel structures brushed or sandblasted steel surfaces, and maintenance operations.
Suitable Top-Coats	RTB-440 can be over-coated with all types of coatings and finishes.

CHEMICAL COMPOSITION

Type of Binder	Epoxy – Polyamide	Zinc Content in Dried Film	90 ± 2% By Weight
Number of Component(s)	2 Components	Solid Content After Mixing	85 ± 1% By Weight
Curing Mechanism	Chemical Reaction		51 ± 3% By Volume
Main Pigment(s)	Pure Zinc Powder	Flash Point	28°C (82°F)

PHYSICAL PROPERTIES

Finish	Flat
Colour	Grey
Specific Gravity after Mixing	2.75 ± 0.05 gr/cm ³

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 or Sa 3 is recommended.				
Mixing Ratio	Component A: 100 Parts by weight		Component B: 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	270 gr/m² @ 50 Microns DFT				
Paint Application	Methods	Airless Spray	Air Spray	Brush	Roller
	Nozzle Size	0.013" – 0.019"	1.80 mm	---	---
	Pump Ratio	1 / 45	---	---	---
	Air Pressure	4 – 6 Bar	3 – 5 Bar	---	---
	Thinning	5 – 10% T-445	10 – 15% T-445	2 – 3% T-445	2 – 3% T-445
Film Thickness		Recommended	Minimum	Maximum	
	Wet Film Thickness (µm)	150	50	200	
	Dry Film Thickness (µm)	75	25	100	
Drying Time	Dust Free Time	Tack Free Time	Dry to Handle	Fully Cured	Recoating Interval
	5 – 10 Minutes	1 – 2 Hours	8 – 12 Hours	10-14 Days	Min. 8 Hours Max. 10 Days
<i>*Drying time calculated at 25°C according to ASTM test method D-1640 for 100 µm WFT</i>					
Application Limits	Relative Humidity	Min. ---		Max. 80%	
	Temperature	Min. +5°C		Max. +40°C	
	Substrate Temperature*	Min. +5°C		Max. +45°C	
<i>*Please note that the substrate temperature should be at least 5°C above the dew point</i>					
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-445.				

PACKING, STORAGE AND SAFETY

Packing	Component A(Epoxy): 10 Litres Containers (25 kgs. Net) and Component B(Hardener): 4 Litres Containers (2.5 kgs. Net)
Storage Conditions	To be stored in cool and dry conditions in original sealed containers.
Shelf Life	At least 9 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.