RONASS EPOXY COATING
RTB-442 (A&B COMPONENTS)

Special two-component, quick-drying epoxy primer with excellent adhesion, chemical and mechanical resistances, and anti-corrosive properties.

USES AND SUITABALE TOP-COATS

Recommended Uses	Shop primer, first coating or intermediate coating in multi-layered coating systems for steel structures and metal surfaces, or as a single coating system in maintenance operations.
Suitable Top-Coats	Alkyd paints, chlorinated rubber coatings, epoxy coatings, acrylic paints and polyurethane systems.

CHEMICAL COMPOSITION

Type of Binder	Epoxy – Polyamide	Solid Content After Mixing	70 ± 1% By Weight
Number of Component(s)	2 Components		48 ± 2% By Volume
Curing Mechanism	Chemical Reaction	Flash Point	28°C (82°F)

PHYSICAL PROPERTIES

Finish	Flat
Colour	Oxide Red (RAL-3009) and Squirrel Grey (RAL-7000)
Specific Gravity after Mixing	1.45 ± 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 is recommended.
Mixing Ratio	Component A: 100 Parts by weight Component B: RTB-442-B or RTB-9600 15 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	150 gr/m² @ 50 Microns DFT

Paint Application

Methods	Airless Spray	Air Spray	Brush	Roller
Nozzle Size	0.009" – 0.015"	1.80 mm	---	---
Pump Ratio	1 / 45	---	---	---
Air Pressure	4 – 6 Bar	3 – 5 Bar	---	---
Thinning	5 – 10% T-445	10 – 15% T-445	3 – 5% T-445	3 – 5% T-445

Film Thickness

	Recommended	Minimum	Maximum
Wet Film Thickness (µm)	105	30	210
Dry Film Thickness (µm)	50	15	100

Drying Time

Dust Free Time	Tack Free Time	Dry to Handle	Fully Cured	Recoating Interval
10 – 15 Minutes	30 – 60 Minutes	2 – 3 Hours	10-14 Days	Min. 8 Hours Max. 10 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-445.

PACKING, STORAGE AND SAFETY

Packing	Component A(Epoxy): 20 Litres Containers (25 kgs. Net) and Component B(Hardener): 4 Litres Containers (3.75 kgs. Net)
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.