

Special two-component epoxy coating with excellent adhesion, durability, moisture, chemical and mechanical resistances.

USES AND SUITABLE TOP-COATS

Recommended Uses Primer and intermediate coating for metal surfaces and maintenance operations.
 Suitable Top-Coats Epoxy coatings, polyurethane coatings and synthetic enamels.

CHEMICAL COMPOSITION

Type of Binder	Epoxy – Polyamide	Solid Content After Mixing	75 ± 1% By Weight
Number of Component(s)	2 Components		56 ± 2% By Volume
Curing Mechanism	Chemical Reaction		
Main Pigment(s)	Non-Toxic Inert Pigments	Flash Point	28°C (82°F)

PHYSICAL PROPERTIES

Finish Flat
 Colour Wide range available according to RAL colour system
 Specific Gravity after Mixing 1.50 ± 0.10 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: 20 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 8 Hours at 25°C

Theoretical Consumption 120-135 gr/m² @ 50 Microns DFT

Paint Application	Methods	Airless Spray	Air Spray	Brush	Roller
	Nozzle Size	0.011" – 0.015"	1.80 mm	---	---
	Pump Ratio	1 / 45	---	---	---
	Air Pressure	4 – 6 Bar	3 – 4 Bar	---	---
	Thinning	5 – 10% T-445	15 – 20% T-445	3 – 5% T-445	3 – 5% T-445

Film Thickness		Recommended	Minimum	Maximum
	Wet Film Thickness (µm)	135	45	270
	Dry Film Thickness (µm)	75	25	150

Drying Time	Dust Free Time	Tack Free Time	Dry to Handle	Fully Cured	Recoating Interval
	20 – 40 Minutes	2 – 3 Hours	8 – 12 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): 6 Litres Containers (5 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.