

Corroless RF 31

Two Pack Epoxy Reinforced Intermediate/Finish

 Issue Date: June 2020
 Code: 4835
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Product Description	A high solids, glass reinforced, chemically resistant, two pack epoxy intermediate/finish.				
Features & Use	<ul style="list-style-type: none"> • Excellent chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts • Cures down to 2°C • Withstands splashes of oxidising acids or bleaching agents • Withstands most greases and immersion in oil • Withstands immersion in aliphatic solvents and splashes of aromatic solvents • Durable finish used for long-term performance both on and offshore • Gives excellent protection in urban, marine and industrial environments 				
Approvals/ Certification	Please consult Corroless				
Finish	Gloss (will chalk on exterior exposure)				
Volume Solids	82% ± 2%				
VOC Content	173 ± 20g /litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	125 µm	152 µm	6.6 m ² /litre	
	Maximum	200 µm	244 µm	4.1 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied at 125 microns DFT		+5°C	+10°C	+23°C
	Dust Free		9 hrs	6 hrs	3 hrs
	Hard Dry		15hrs	7 hrs	2 hrs
	Overcoating	Minimum	24 hrs	16 hrs	10 hrs
		Maximum	7 days	7 days	3 days
Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Available in a wide range of colours				
Mix Ratio	1:1 by volume (base to hardener)				
Pot Life	3½ hours at 23°C				
SG	1.46 -1.50 kg/litre (mixed material) varies with colour				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	23-60°C				

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Surface Preparation	<ul style="list-style-type: none"> All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination This is an intermediate or finish coat and should be applied over appropriate Corroless Primers Recommended Primer: Corroless EPF 														
Mixing	<p>Mix each component separately prior to thoroughly mixing together for 2 to 3 minutes at medium speed. Always use a mechanical agitator. Ensure product is used only in the proportions recommended.</p>														
Thinner / Cleaner	<p>Corroless Thinners No.4. (Solvent Gun Wash may be used for cleaning only)</p>														
Application Conditions	<p>High humidity will impair gloss. Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
Application Methods	<table border="1" data-bbox="443 889 1460 1025"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes-Thinning required</td> <td>Yes</td> <td>No</td> </tr> </tbody> </table> <ul style="list-style-type: none"> Airless spray: output fluid pressure 2500-3000 psi, tip size 19-27 thou, Fan Angle 30-65°. For detailed advice contact Corroless Conventional Spray: An addition of up to 10% Corroless Thinners No.4 will be required Brush: apply unthinned, lay on, do not over brush 					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes-Thinning required	Yes	No
Method	Airless Spray	Conventional Spray	Brush	Roller											
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Product Notes	<ul style="list-style-type: none"> Application Temperature: Range 2°C (10°C preferred) to 30°C. Do not apply below 2°C Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc. Overcoating: Overcoat with itself, Corroless RF61 and RF65. If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing If maximum overcoating times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing 														
Health & Safety	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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