



Rhinofleet[®] AC HS

2K polyurethane-acrylic enamel

6075 - line

Description

- 2-pack acrylic-modified polyurethane high performance topcoat

Properties

- Superior weather resistance and light fastness
- High solids, providing high film build per coat
- Excellent gloss retention

Typical Applications

- Steel fabrications (e.g. cranes)
- Truck and bus refinishing

General Data

- Weather resistance Excellent
- Solvent resistance Resists splashes of most common solvents; not recommended for continuous immersion
- Chemical resistance Good
- Abrasion resistance Good
- Suitable primers 2K Hi Fill Primer, Rhinamel[®] CC Primer, Rhinogrip[®] Etch Primer, Epoxycoat

Specifications (at 25°C and 50% relative humidity)

- Resin type..... Acrylic-modified polyurethane
- Mixing ratio..... 4 : 1
- Solids content..... 55% (by volume)
- Typical film thickness (per coat)..... 50 microns (dry)
90 microns (wet)
- Theoretical coverage..... 10m² / L @ 25 microns dry film thickness (dependant on colour)
- Touch dry..... 2 - 3 hours
- Hard dry..... 16 hours
- Full cure..... 7 days
- Recoating..... after 16 hours
- Pot life..... 2 hours (depending on temperature and level of thinner added)
- Gloss..... Gloss
- Colour..... Extensive colour library and easy colour matching with Coloryte[®] Industrial Tint System
- Shelf life..... minimum 12 months (in cool, dry conditions; unopened containers)

Surface Preparation

- Bare steel surfaces must be degreased, then subjected to abrasive blasting (to AS 1627.4 Class 2½) or abrasion with a suitable power cleaning tool (e.g. disc sander)
- Not suitable for application directly to bare metal. Refer to recommendations Coatings Systems below.

Mixing recommendation

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 4:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Thin up to 20% by volume with Wagon Paints' T1 PU Spray Thinner (see Application directions), and stir as above

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Application

- May be spray applied using airless or conventional air spray equipment
- Small areas may be coated by brush or roller
- **Airless Spray** nozzle size.....0.33 - 0.38 mm
nozzle pressure.....2200 - 3000 psi (15 - 20mPa)
volume of thinner.....up to 10%
- **Air Spray** nozzle size.....1.8 - 2.2 mm
nozzle pressure.....55 - 70 psi (350 - 450kPa)
volume of thinner..... up to 20%
- **Cleaning solvent** T1 PU Spray Thinner

Coating Systems

Substrate	Primer	Undercoat*	Topcoat
Aluminium	Rhinogrip® Etch Primer		Rhinofleet® AC HS
Galvanised Iron	Rhinogrip® Etch Primer	2K Hi Fill Primer	Rhinofleet® AC HS
Steel	Rhinogrip® Etch Primer	2K Hi Fill Primer	Rhinofleet® AC HS
Zincseal / Zinalume	Rhinogrip® Etch Primer		Rhinofleet® AC HS
Fibreglass		2K Hi Fill Primer	Rhinofleet® AC HS
Timber		2K Hi Fill Primer	Rhinofleet® AC HS

Rhinogrip Etch primer may be directly overcoated with Rhinofleet® AC HS to provide an economical and quick drying alternative to the traditional two pack epoxy undercoats. For optimum performance in severe environments, the use of a single coat of epoxy undercoat between Rhinogrip® Etch & Rhinofleet® AC HS is recommended.

***Rhinamel® CC Primer may be used in place of 2K Hi Fill Primer**

Caution:

Store Rhinofleet® AC HS Pack A & B in a cool, dry location. Do not allow water to contaminate the products.
Must not be applied over damp surfaces. Do not apply when the air/surface temperatures are below, or are likely to fall below, 10°C or the relative humidity is above 70%.

Safety precautions

- **Refer to the relevant Material Safety Data Sheets for Pack A and Pack B**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

Packaging Group II **UN No.** 1263 (Pack A); 1866 (Pack B)

Pack sizes 4 litre, 20 litre (Pack A)
1 litre, 5 litre (Pack B)

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