



Rhinamel®

Industrial epoxy surface coating

7000 - line

Not recommended for DIY painting of swimming pools

Description

- 2-pack epoxy / polyamide finish coat

Properties

- Tough, durable surface
- High corrosion, chemical and abrasion resistance
- Long pot life

Typical Applications

- Steel fabrications (machinery, tanks, etc.)
- Concrete floors

General Data

- Weather resistance Good (will chalk and yellow on prolonged exterior exposure, however film integrity is not compromised)
- Solvent resistance Good
- Chemical resistance

Fats & Oils	Excellent
Alkalis, dilute	Excellent*
Acids, dilute	Good*

*may cause discolouration of some colours
- Abrasion resistance Excellent
- Recommended primers Rhinamel® Undercoat, Rhinamel® CC Primer, Epoxycoat, Rhinamel® Clear Sealer

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

- Resin type..... Epoxy / polyamide
- Mixing ratio..... 3 : 1
- Solids content..... 50% (by volume)
- Typical film thickness (per coat)..... 125 microns (dry)
250 microns (wet)
- Theoretical coverage..... 10 - 12m² / L @ 125 microns dry film thickness
- Touch dry..... 4 - 6 hours
- Hard dry..... 16 hours
- Full cure..... 7 days (will not cure at temperatures below 10°C)
- Recoating..... within 24 hours to ensure good intercoat adhesion
after 24 hours, sanding is required
- Pot life..... 4 - 12 hours (depending on temperature and level of thinner added)
- Gloss..... Gloss
- Colour..... Range of stock colours, plus extensive colour library
- Shelf life..... minimum 12 months (in cool, dry conditions)

Surface Preparation

- 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). Apply Rhinamel® before flash rusting occurs.
- Concrete** must be cured for a minimum of 28 days. Remove all traces of curing membrane, release agents, oil and grease. Acid etch with a 10% solution of Phosphoric Acid or Hydrochloric Acid in water. (Alternatively, shotblast or diamond grind to remove surface laitance) Allow concrete to dry thoroughly, then seal with one coat of Rhinamel® Clear Sealer
- Timber** Sand and dust down. Remove all traces of previous coatings. Not recommended for softer timbers, e.g. pine, cedar, etc. Timber should be well seasoned and of less than 10% moisture content prior to coating.

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Mixing recommendation

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 3:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Allow mixture to stand for 30 minutes in warm conditions, and up to 2 hours in cool conditions, prior to application
- Thin up to 20% by volume with Wagon Paints' T3 Epoxy Thinner (see Application directions), and stir as above

Application

- May be applied using roller, airless or conventional air spray equipment
- **Roller** short nap..... 5 - 10 mm
volume of thinner.....Up to 15%
- **Airless Spray** nozzle size.....0.33 - 0.38 mm
nozzle pressure.....2800 - 4000 psi (19 - 27mPa)
volume of thinner.....up to 10%
- **Air Spray** nozzle size.....1.8 - 2.2 mm
nozzle pressure.....45 - 60 psi (300 - 400kPa)
volume of thinner.....10 - 20%
- **No. of Coats**.....Two
- **Cleaning solvent**T3 Epoxy Thinner

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 III **UN No.** 1263 (Pack A); 1866 (Pack B)

Pack sizes 750ml, 3 litre, 15 litre (Pack A)
250ml, 1 litre, 5 litre (Pack B)

Authorised: A. De Mello, Sales Manager

June 2008

These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.



Wagon Paints

5 Stephenson Road, Bayswater North, Victoria 3153 Australia

Phone: 61 3 97291344 Fax: 61 3 97202179 Email: sales@wagonpaints.com.au