RONASEAL
RTB-1415 (Two-Component Epoxy Sealer)

Two-component epoxy sealer with excellent adhesion, durability, and great chemical, moisture, ultra-violet radiation, and weather resistances.

USES AND SUITABALE TOP-COATS

Recommended Uses	Intermediate and finish coat for metal surfaces and maintenance operations in marine and offshore environments.
Suitable Top-Coats	Ronaseal 1415 can be over-coated with a wide range of epoxy coatings and polyurethane systems and Antifouling Coatings.

CHEMICAL COMPOSITION

Type of Binder	Epoxy –Polyamio-Amide	Solid Content After Mixing	76± 1% By Weight
Number of Component(s)	2 Components		57± 2% By Volume
Curing Mechanism	Chemical Reaction	Flash Point	29°C (84°F)

PHYSICAL PROPERTIES

Finish	Semi Gloss
Colour	Silver Grey(RAL-7001).
Specific Gravity after Mixing	1.50 ± 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, and treatment with an epoxy primer is recommended.
Mixing Ratio	Component A: 100 Parts by weight Component B (RTB-9400): 10 Parts by weight Component A: 6 Parts by volume Component B (RTB-9400): 1 Parts by volume
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	260 gr/m² @ 100 Microns DFT

Paint Application

Methods	Airless Spray	Air Spray	Brush	Roller
Nozzle Size	0.017" – 0.023"	1.80 mm	---	---
Pump Ratio	1 / 45	---	---	---
Air Pressure	4 – 6 Bar	3 – 5 Bar	---	---
Thinning	8 – 15% T-444	10– 20% T-444	3 – 5% T-444	3 – 5% T-444

Film Thickness

	Recommended	Minimum	Maximum
Wet Film Thickness (µm)	175	90	265
Dry Film Thickness (µm)	100	50	150

Drying Time

Substrate Temp.	10°C	25°C	35°C
Tack Free Time	4-5 Hours	2-3 Hours	1-2 Hours
Dry to Handle	24-30 Hours	8-10Hours	12-18 Hours
Recoating Time	Min. 16 Hours	Min. 16 Hours	Min. 16 Hours
	Max. 11 Days	Max. 10 Days	Max. 9 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-444.

PACKING, STORAGE AND SAFETY

Packing	Component A (Epoxy): 20 Liter Containers | Component B (Hardener):5 Liter Containers
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.