RONASS RED LEAD EPOXY PRIMER
RTB-665 (A&B COMPONENTS)

Special two-component epoxy primer with excellent adhesion and anti-corrosive properties.

USES AND SUITABALE TOP-COATS

Recommended Uses	First coat for steel structures, metal surfaces and maintenance operations.
Suitable Top-Coats	Alkyd paints, chlorinated rubber coatings, epoxy coatings and polyurethane systems.

CHEMICAL COMPOSITION

Type of Binder	Epoxy – Polyamide	Solid Content After Mixing	78 ± 1% By Weight
Number of Component(s)	2 Components		60 ± 2% By Volume
Curing Mechanism	Chemical Reaction		
Main Pigment(s)	Red Lead and Other Active Pigments	Flash Point	28°C (82°F)

PHYSICAL PROPERTIES

Finish	Semi flat
Colour	Orange (Comparable with RAL-2011: Deep Orange)
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 is recommended.
Mixing Ratio	Component A: 100 Parts by weight Component B: 10 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	4 Hours at 25°C
Theoretical Consumption	200 gr/m² @ 80 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)	100	65	165
Dry Film Thickness (µm)	60	40	100

Drying Time@25°C

Dust Free Time	Tack Free Time	Dry to Handle	Fully Cured	Recoating Interval
30 – 60 Minutes	2 – 3 Hours	12 – 16 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): 5 Litres Containers (2.5 kgs. Net)
Storage Conditions	To be stored in cool and dry conditions in original sealed containers.
Shelf Life	At least 12 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.