

# Corroless RF35 (2006)

## Two Pack Epoxy Tank Lining

Issue Date: June 2020  
Code: L7RF45N  
Page 1 of 2

|                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                           |                           |                             |             |
|-----------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------|---------------------------|-----------------------------|-------------|
| <b>Product Description</b>                                                                                                        | A two-component high build solvent-less epoxy coating.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                           |                           |                             |             |
| <b>Features &amp; Use</b>                                                                                                         | <ul style="list-style-type: none"> <li>• Approved in conjunction with Corroless EPF for contact with potable water</li> <li>• Good chemical resistance, withstands immersion in dilute solutions of non-oxidising acids, alkalis and salts - seek advice from Corroless</li> <li>• Withstands most greases and immersion in oil</li> <li>• Withstands immersion in aliphatic solvents and splashes of aromatic solvents</li> <li>• NOT suitable for contact with petrol</li> <li>• Glass reinforced for increased impermeability</li> <li>• Applications include water tanks, pipes and fittings, cargo holds and ballast tanks, sewage works, reservoir tunnels and shafts etc.</li> </ul> |                           |                           |                             |             |
| <b>Approvals</b>                                                                                                                  | <ul style="list-style-type: none"> <li>• BS6920:2000 for use in contact with potable water (with Corroless EPF as Primer)</li> <li>• WRAS listed 170552 for application to metal</li> <li>• WRAS listed 170551 for application to concrete</li> <li>• NATO Stock Number 0442 8010 99 337 0778</li> </ul>                                                                                                                                                                                                                                                                                                                                                                                    |                           |                           |                             |             |
| <b>Finish</b>                                                                                                                     | Gloss (will chalk on exterior exposure)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                           |                           |                             |             |
| <b>Volume Solids</b>                                                                                                              | 96% ± 2%                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                           |                           |                             |             |
| <b>VOC Content</b>                                                                                                                | <b>Base</b> 24 g/litre <b>Hardener</b> 0 g/litre                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |                           |                             |             |
| <b>Film Thickness Range And Coverage</b>                                                                                          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | <b>Dry Film Thickness</b> | <b>Wet Film Thickness</b> | <b>Theoretical Coverage</b> |             |
|                                                                                                                                   | <b>Minimum</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 200 µm                    | 208 µm                    | 4.8 m <sup>2</sup> /litre   |             |
| Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                           |                           |                             |             |
| <b>Drying Times</b>                                                                                                               | Applied at 200 microns DFT                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                           | <b>10°C</b>               | <b>18°C</b>                 | <b>30°C</b> |
|                                                                                                                                   | <b>Dust Free</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           | 12 hrs                    | 8 hrs                       | 6 hrs       |
|                                                                                                                                   | <b>Hard Dry</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                           | 24 hrs                    | 16 hrs                      | 12 hrs      |
|                                                                                                                                   | <b>Overcoating</b>                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | Minimum                   | 24 hrs                    | 16 hrs                      | 12 hrs      |
|                                                                                                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | Maximum                   | 3 days                    | 3 days                      | 2 days      |
| Drying and recoat times are related to the film thickness, temperature, the relative humidity of the air and ventilation          |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                           |                           |                             |             |
| <b>Colours</b>                                                                                                                    | Grey (approximately BS 18B21)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                           |                           |                             |             |
| <b>Mix Ratio</b>                                                                                                                  | 3:1 by volume (base to hardener)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                           |                           |                             |             |
| <b>Pot Life</b>                                                                                                                   | 45 minutes at 18°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                           |                           |                             |             |
| <b>SG</b>                                                                                                                         | 1.36 ±0.05 kg/litre (mixed material)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                           |                           |                             |             |
| <b>Storage Conditions</b>                                                                                                         | Store in dry, cool conditions and protect from frost                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                           |                           |                             |             |
| <b>Shelf Life</b>                                                                                                                 | Minimum 24 months if stored as above in unopened containers                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                           |                           |                             |             |
| <b>Flash Point</b>                                                                                                                | 23-60°C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                           |                           |                             |             |

# Corroless RF35 (2006)

Issue Date: June 2020  
Page 2 of 2

| <b>Surface Preparation</b>                                                                                                                                                                                                                                                                                                                   | <ul style="list-style-type: none"> <li>All surfaces when coated should be firm, clean, dry and free from all oil, grease, salts and other contamination</li> <li>This is an intermediate or finish coat and should be applied over appropriate Corroless Primers</li> <li><b>Recommended Primer:</b> Corroless EPF</li> </ul>                                                                                                                                                                                                                                                                                         |               |                    |       |        |        |               |                    |       |        |  |     |    |     |     |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------|--------------------|-------|--------|--------|---------------|--------------------|-------|--------|--|-----|----|-----|-----|
| <b>Mixing</b>                                                                                                                                                                                                                                                                                                                                | <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>                                                                                                                                                                                                                                                                                                                                                                                                            |               |                    |       |        |        |               |                    |       |        |  |     |    |     |     |
| <b>Thinner / Cleaner</b>                                                                                                                                                                                                                                                                                                                     | <p>Corroless Thinners No.4, but <b>not for potable water applications</b> where thinning is not allowed. Solvent Gun wash can be used for cleaning only</p>                                                                                                                                                                                                                                                                                                                                                                                                                                                           |               |                    |       |        |        |               |                    |       |        |  |     |    |     |     |
| <b>Application Conditions</b>                                                                                                                                                                                                                                                                                                                | <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>                                                                                                                                                  |               |                    |       |        |        |               |                    |       |        |  |     |    |     |     |
| <b>Application Methods</b>                                                                                                                                                                                                                                                                                                                   | <table border="1"> <thead> <tr> <th data-bbox="416 922 683 992">Method</th> <th data-bbox="683 922 933 992">Airless Spray</th> <th data-bbox="933 922 1184 992">Conventional Spray</th> <th data-bbox="1184 922 1334 992">Brush</th> <th data-bbox="1334 922 1471 992">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="416 992 683 1048"></td> <td data-bbox="683 992 933 1048">Yes</td> <td data-bbox="933 992 1184 1048">No</td> <td data-bbox="1184 992 1334 1048">Yes</td> <td data-bbox="1334 992 1471 1048">Yes</td> </tr> </tbody> </table>                                                             |               |                    |       |        | Method | Airless Spray | Conventional Spray | Brush | Roller |  | Yes | No | Yes | Yes |
|                                                                                                                                                                                                                                                                                                                                              | Method                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | Airless Spray | Conventional Spray | Brush | Roller |        |               |                    |       |        |  |     |    |     |     |
|                                                                                                                                                                                                                                                                                                                                              | Yes                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | No            | Yes                | Yes   |        |        |               |                    |       |        |  |     |    |     |     |
| <ul style="list-style-type: none"> <li><b>Airless spray:</b> Plural component feed systems such as ‘Graco Hydra-Cat’ are recommended. Output fluid pressure 4000 psi, Tip Size 19 thou, Fan Angle 50°. <b>For detailed advice contact Corroless Technical.</b></li> <li><b>Brush:</b> apply un-thinned, lay on, do not over brush</li> </ul> |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |               |                    |       |        |        |               |                    |       |        |  |     |    |     |     |
| <b>Product Notes</b>                                                                                                                                                                                                                                                                                                                         | <ul style="list-style-type: none"> <li>Application Temperature: Range 8°C -35°C</li> <li>Stripe Coating: Stripe coat all edges, nuts and bolts, welds etc.</li> <li>Overcoating: Overcoat with itself. To overcoat with other Corroless products consult Corroless Technical</li> <li>If overcoating time exceeds 24 hours and contamination has occurred, clean using a detergent solution/fresh water and allow to dry before continuing</li> <li>If maximum overcoating times are exceeded abrade the surface and wash down with fresh water to remove contamination and allow to dry before continuing</li> </ul> |               |                    |       |        |        |               |                    |       |        |  |     |    |     |     |
| <b>Health &amp; Safety</b>                                                                                                                                                                                                                                                                                                                   | <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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