

Always use correct Personal Protective Equipment

RALI DUREPOX XTREME CLEAR - Marine TDS

Description



RALI Durepox Xtreme Clear is a unique 2-pack epoxy urethane clear formulated for the Marine and Wind Turbine Industry as a direct to substrate clear or in conjunction with RALI Durepox Primer or RALI Durepox Xtreme Primer.

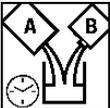
RALI Durepox Xtreme Clear is primarily used in the general marine, racing yacht and wind power industries in particular.

RALI Durepox Xtreme Clear Features:

- Higher crosslink density giving tougher coating with superior slip, mar and abrasion resistance.
- Excellent adhesion to a variety of substrates including Wind Turbine Rotor Blades.
- Excellent for Rudders and Dagger Boards for Racing Yachts.
- UV Stable.
- Excellent Filling properties & gloss level.
- Long term hold out.
- RALI Durepox Xtreme Clear can be tinted to give a coloured topcoat. Colours available include the RAL range.

Best practice is to always test a small area to confirm substrate compatibility and desired finish.

Products



Product Type:	Epoxy Urethane Clear
Colour:	Slightly Yellow Tone with a full 4L can.
Pot Life:	45 min with Durepox Hardener & reducer at 20°C
Induction Time:	5-10 Minutes
Density:	0.95-1.00 kg/L.
Recommended DFT:	25-35 microns DFT PER COAT
Theoretical Coverage:	10m ² /L @ 40µ DFT

Properties

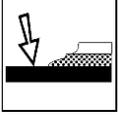


VOC:	505 g/L
Volume Solids:	41% (non catalysed)
Dry Time @ 20°C:	2hr detail sand and recoat. Touch Dry: 1 Hour Handle: 12 Hours
Recoat-ability	Self recoat @ 20°C: between 0 and 2 hours. After 2 hours must be detail sanded to ensure intercoat adhesion. Like most 2 pack products the higher the temperature the shorter the pot life.

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Substrates



RALI Durepox Xtreme Clear can be applied over pigmented RALI Durepox Primer/ RALI Durepox Xtreme Primer or directly over correctly prepared:

- G.R.P. (Fibreglass)
- Carbon Fibre.
- Pigmented Durepox.
- Veneer coated ply wood & most wood finishes.

Surface Preparation



Carbon Fibre:

Wash with warm detergent solution e.g. C-Power solution. Degrease with Wax & Grease Remover. Abrade with 120-180 grit dry sandpaper, finish with P400. Remove dust and wipe clean with RALI Wax & Grease Remover and or IPA spirit wipe. Apply RALI Durepox Xtreme Clear.

After full cure sand and recoat if necessary for desired finish.

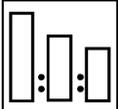
Wood and MDF Board Composites:

Clean all timber surfaces to be coated after final sanding. Strongly advise testing a small area for coating success due to the amount of variables in veneers & timbers.

Ensure substrates are dirt, dust & grease free. Depending on the particular wood substrate most can be coated on day one, left for overnight drying in warm temperatures (at least 20°C) followed by final sanding of P400 grit detail dry sand and recoated the following day.

After full cure sand and recoat if necessary for desired finish.

Directions For Use



Mixing Ratio:

5 parts RALI Durepox Xtreme Clear (Volume) to 1 part Durepox Hardener

Thinning:

Up to 20 – 40% 400, 909 Fast or 400 Slow Reducer

Note

Lower temperatures will slow drying; adding of up to 5% by volume of RALI 62C Accelerator will approximately halve curing and pot life times. Reduce addition to 1-2% RALI 62C Accelerator when drying with IR lamps. Misuse of RALI 62C Accelerator can cause loss of adhesion and poor flow-out.

High temperatures can accelerate drying time and reduce pot life, the use of RALI 400 Slow Reducer can help in these circumstances. Always be mindful of recoat times in warm conditions - as in over 25°C.

Spray Equipment:



Compliant / Conventional suction and gravity feed guns.

Tip Size: 1.5 - 2 mm

Spray pressure: 275-380KPA (40-55 PSI)

Number of coats: 2 coats (5-10 minutes flash between coats)

Air less / Air assisted airless & electrostatic follow equipment manufacturer's recommendations.

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Although Durepox Xtreme Clear can be applied without thinning, best results are obtained by thinning up to 20% by volume with RALI 400 Reducer, RALI 909 Fast Reducer or RALI 400 Slow Reducer. This allows for different gun set-ups and techniques, and assists flow and levelling.

Remarks: Do not use activated material beyond pot life time or by reducing it further to get the viscosity down again. This procedure results in poor flow and adhesion failures. Large surface areas in conjunction with temperatures +20°C it is highly recommended to use RALI 400 Slow Reducer. Plan the job required and seek advice if unsure.

Health & Safety



For detailed information refer to Safety Data Sheet (SDS). Mixed product contains isocyanates. Inhalation of vapours or dust from sanding may cause respiratory sensitisation. Splashes to eyes will cause irritation. Contact with skin may cause irritation. Applicators should use protective clothing and respiratory equipment. Product is flammable, use and store away from heat and ignition sources.

Transport & Storage



Sizes:	1L, 4L
Dangerous Goods:	3A
UN:	1263
Hazchem:	3[Y]
Packing Group:	III
Shipment name:	PAINT Flammable Liquid Low Flash Point
Flash point:	27°C

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