

Always use correct Personal Protective Equipment

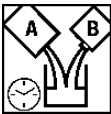
Epacryl 550

Description



Isocyanate-free 2-pack acrylic epoxy topcoat exhibiting a tough, durable, chemical-resistant finish suitable for light industrial applications, best used over Isocyanate-free RALI 440 Industrial Primer to complete the RALI Isocyanate-free paint system. RALI Epacryl 550 has excellent coverage and its quick dry properties, allows early handling of coated items.

Products



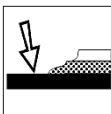
Product Type:	Epoxy reactive acrylic
Colour:	Full range
Pot Life:	8hrs at 20°C
Hardener type:	Epoxy co-polymer
Induction Time:	10 minutes
Recommended DFT:	Minimum 50 microns DFT per coat. Can vary according to application method (i.e. Electrostatic).
Theoretical Coverage:	9 m ² /L Variable according to application method.

Properties



Volume Solids:	45%
Recoat-ability:	Two hours at 20°C
Usual no. of coats	1 to 2
Abrasion resistance	Very good
Durability	Very good
Solvent resistance	Very good when fully cured
Chemical resistance	Acids - good, Alkalis - suitable for splash areas only
Primer required	Yes. RALI 440 Industrial Primer is recommended. Coated after 4 hours dry time at 20°C or overnight.

Substrates



RALI Epacryl 550 is recommended as a top coat over RALI 440 Industrial Primer on correctly prepared:

- Steel
- Galvanised Steel
- Aluminium
- Sanded cured substrates
- Sanded cured 2K substrates
- GRP
- Can be applied direct to glass (Refer RALI Technical Rep)

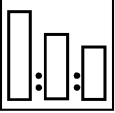
Surface Preparation




Wash with RALI C-Power diluted 20 parts clean water to 1 part RALI C-Power. Degrease with RALI Wax & Grease Remover. Abrade with suitable grit paper; re-clean with RALI Wax & Grease Remover. Ensure surface is completely dry and dust free before application. Do not apply to existing finishes that are blistering, peeling, cracking, flaking or otherwise unsound. Refer to Product Data Sheet.

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Directions For Use 	Mixing Ratio:	Mixing by Volume: 4:1:1:5 (Volume) 1.5 parts
	Viscosity:	Din 4: 16 to 18 sec Ford 4: 16 to 18 sec, this is a guide only due to being applicator & equipment dependent
	Thinning:	RALI 440 Reducer, No. 10 Slow Reducer.
	Application method:	Strain thinned paint before application. Apply a light to medium wet coat overall. After ten minutes flash time spray a further two wet coats with a flash time of fifteen minutes between coats. Care should be taken to avoid dry spray areas. If extra flow is required, a coat thinned up to 50% with RALI 440 Reducer may be applied after the previous coat has flashed off. Care should be taken as flow out continues even after the touch dry stage.
	Application Electrostatic:	Apply using a Graco electrostatic 233-7477 sprayer pump unit or similar equipment with hopper. To spray electrostatically, use only No. 10 Slow Reducer to a maximum of 10 to 15%. Excess thinning will reduce wet film thickness and result in product running. Ensure that unit to be sprayed is earthed correctly before spraying. Spray pressure at the pump should be between 275-380KPA (40-55psi). Units to be sprayed should be a minimum of 2 meters apart to avoid dry spray on finished articles. (Refer to RALI Technical Rep)

Spray Equipment: 	Tip size: Air pressure: Clean up:	Compliant / Conventional Suction and Gravity feed 1.4 – 1.8 mm 310 - 380 KPA (45-55 psi) No. 12
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