



RAINBOW

RAINBOXY 854

PRODUCT NUMBER 30854
 TYPE Two component polyamine cured epoxy tiecoat.
 CHARACTERISTICS
 1. Finish coat in epoxy polyamine cured epoxy tiecoat.
 2. Excellent water resistance.
 3. Good abrasion and impact resistance.
 4. Epoxy tiecoat for use with antifouling as specified.

GLOSS Flat
 COLORS Black, grey
 VOC Max. 376 g/L
 PRODUCT WEIGHT Above 1.3 Kg/L
 DRYING TIME Set-to-touch 8 hrs
 OPTIMUM FILM THICKNESS Wet 114 ~ 238μ (Micron) Dry 75 ~125μ (Micron)
 VOLUME SOLID 66±2%
 THEORETICAL COVERAGE 33.3 m²/Gal 8.8 m²/L @ 75μ
 OVERCOATING TABLE

EPOXY system

Substrate temp.	-5 °C	5 °C	10 °C	20 °C	30 °C	40 °C
Minimum interval	20 hours	16 hours	14 hours	12 hours	10 hours	8 hours
Maximum interval	18 days	18 days	18 days	14 days	7 days	3 days

MIXING RATIO Base : Hardener = 17.2 : 2.8 (by volume)
 POT LIFE 12 hrs (20°C)
 THINNER No.1005 Epoxy Thinner (SP-12)
 THINNER RATE The mixing temp. for the base and hardener should be performed at above 15°C. or else thinner should be added in order to achieve application viscosity, too much thinner will result in sagging. Well mix the base and hardener before any thinner is added.
 0~5% (by bush and roller) 0~10% (Airless)

RECOMMENDED SPEC Please refer the painting specification
 SHELF LIFE Minimum one year under normal storage condition
 APPLICATION METHOD Airless spray, Bush and Roller
 NOTE
 1. Previous coat; dry and free from any contamination.
 2. Substrate temperature should be above -5°C during application and curing and at least 3°C above dew point and free from ice and any contamination.
 3. During application and curing a substrate temperature down to -5°C is possible but curing to hardness takes longer and complete resistance will be reached when temperature increasing.

EPDM3030854X V1.0

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