Riley Paint Company

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PRODUCT DATA SHEET

PRODUCT DESCRIPTION: Riley's 2-Component Polyamide Epoxy is intended for use on properly prepared surfaces for finishing or refinishing. Suitable applications include agricultural, construction, and industrial equipment, castings, metal fabrications, and tank exteriors.

ADVANTAGES:

WIDE BALANCE OF PERFORMANCE PROPERTIES:

- Excellent Adhesion
- Excellent Chemical Resistance
- Fast Recoat Time
- Good One Coat Protection
- Good Hardness And Film Toughness
- Excellent flow and leveling
- Good Humidity and Gasoline Resistant
- Excellent Salt Spray Performance
- Virtually any new or existing color standard can be matched
- Gloss can be matched to customer specifications
- Can be formulated for lower Hazardous Air Pollutants—HAP's

SOLVENT REDUCTION DATA:

Solvent	Comparative Spot Dry	Reduction Strength
Toluene	1 min. 5 sec.	Strong
Xylene	2 min. 40 sec.	Strong
D-100	6 min. 30 sec.	Average
D-150	22 min.	Average
N-Butyl-Acetate	2 min. 7 sec.	Strong
Methyl Ethyl Ketone	35 sec.	Strong. Used to enhance electrostatic wrap.

CHARACTERISTICS:

GLOSS: Full Range
VOLUME SOLIDS: 45-65% Varies by color
VISCOSITY: 20-50 Seconds Zahn #3

SPREADING RATE: 600-900 SQ. FT./GAL. At 1 Mil, No Application Loss

PACKAGE LIFE: 1 Years

DRYING: Air Dry @ 77°F (25°C) 45% RH
To Touch: 30 MINUTES
To Handle: 60 MINUTES
To Recoat: AFTER 60 MINUTES
To Pack: 24 HOURS

FORCE DRY: Up to 200°F for 30 minutes for most colors.

RECOMMENDED FILM THICKNESS:
WET: 4.0-8.0 MILS
DRY: 2.0-4.0 MILS

REDUCTION: Xylene, Toluene, D-100, D-150, N-Butyl-Acetate

CLEAN UP: Toluene, Xylene or MEK. Warning. Residue from clean up is flammable.

PRODUCT LIMITATIONS:

1. On sand blasted or rough surfaces more dry film thickness may be necessary to fully cover profile.
2. Mix "A" and "B" at the specified ratio. An induction time of 30 minutes is required prior to application.
3. Blocking or sticking may occur when flat surfaces are stacked before adequate cure. Allow at least 24 to 48 hours drying before stacking depending on dry film thickness.
4. For best application of applying paint to a substrate the temperature of the paint should be between 65-90°F (18-32°C). If specified temperature is not met poor atomization can result.
5. Stir thoroughly before and during use. Stirring is critical to maintaining consistent coating material parameters.
6. Epoxy systems provide super durable properties, however loss of gloss will occur when exposed to sunlight. If gloss retention is required, consider an Acrylic Polyurethane.

APPLICATION:

APPLICATION PRECAUTIONS AND LIMITATIONS: Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point. Condensation will cause paint film failures.

SURFACE PREPARATION:
METAL: Apply to properly cleaned or treated metal surface. A solvent wipe to remove contaminates or sandblasting will work. Sand blasted metal may require more dry film thickness to fully cover blasted profile. Priming metal prior to topcoating is recommended for best overall properties. Preprimed surfaces may need to be lightly sanded and tacked off for best inner coat adhesion. Chemical treatment will improve the adhesion and performance properties of the paint. Treatment may consist of an iron phosphate chemical pretreatment. Riley manufactures several chemicals for surface preparation.

ALUMINUM AND GALVANIZED IRON (UNTREATED): Prime with a vinyl wash primer then coat with an alkyd primer followed by a topcoat.

WOOD (INTERIOR): No primer is required for properly prepared, previously painted surfaces. For new wood priming is recommended. Riley has specialty wood coating products that may work better.

CONVENTIONAL SPRAY: Reduce to the desired viscosity using a solvent that has the appropriate reduction strength and dry time. Add with agitation. Spray at 40-60 psi atomizing pressure and 15-20 psi fluid pressure. Viscosity 25-55 seconds #2 EZ.

AIRLESS SPRAY: Reduce to the desired viscosity using a solvent that has the appropriate reduction strength and dry time. Use .013"-.019" tips and 12"-16" fan for best application. Viscosity 20-30 seconds #3 EZ. WARNING. Over spray residues will spontaneously combust.

DIP: Not recommened.

KEEP OUT OF REACH OF CHILDREN

Consult MSDS for more information. **Revised 9-07-06**