



Rhino Linings®

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RhinoPrime RL315 (Formerly RL315) TECHNICAL DATA SHEET

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PRODUCT DESCRIPTION

RhinoPrime RL315 is a two component, isocyanate-cured epoxy holding primer for polyurethane and polyurea elastomer systems.

USES

Intended primarily for use as a blast holding primer. Also suitable for use as a holding primer/tie-coat on properly prepared surfaces under other high build secondary containment systems such as elastomeric urethanes.

RhinoPrime RL315 offers protection to blasted substrates prior to the application of the secondary containment system, and offers superior inter coat adhesion compared to standard epoxy primers.

PRODUCT CHARACTERISTICS

RhinoPrime RL315 will not cure adequately below 5°C (41°F). For maximum performance, ambient curing temperature should be above 10°C (50°F). Surface temperature must always be a minimum of 3°C (5°F) above dew point.

The history and age of the steel and the method of working can have a significant effect on the primer consumption.

Care should be taken to apply RhinoPrime RL315 as close as practically possible to the specified dry film thickness (DFT). Over application of RhinoPrime RL315 will extend both the minimum over coating periods and handling times, and may be detrimental to long-term over coating properties.

When using as a blast holding primer avoid over-application as thick films may suffer from cohesive film splitting if subsequent coats are also over-applied.

PRACTICAL INFORMATION

Colour: Red
Gloss Level: Matt
Volume Solids: 18%
Typical Thickness: 15-25 microns dry is equal to 83-138 microns wet.
Theoretical Coverage: 9.0sqm/litre at 20 microns DFT and stated volume solids.
Practical Coverage: Allow appropriate loss factors.
Method of Application: Airless spray and air spray

Drying Time:-

Temp.	Touch Dry	Hard Dry	Overcoating Interval	
			Minimum	Maximum
15°C	45 mins	4 hours	4 hours	72 hours
25°C	30mins	2 hours	2 hours	36 hours
40°C	30 mins	2 hours	2 hours	24 hours

* See product Characteristics section

REGULATORY DATA

Flash Point	Base (Part A) >32°C	C/A (Part B) >32°C	Mixed >32°C
Product Weight	1.06 kg/l		
VOC	761 g/l		

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to primer application all surfaces should be assessed and treated in accordance with ISO 8504:1992 .

Oil or grease should be removed in accordance with SSPC-SPI solvent cleaning.

Steel – Abrasive Blast Cleaning

Abrasive blast clean to a minimum of Class 21/2 (ISO 8501-1:1998) SSPC-SP10. If oxidation has occurred between blasting and application of RhinoPrime RL315, the surface should be re-blasted to the specified visual standard. Surface defects revealed by the blast cleaning process, should be ground, filled or treated in the appropriate manner.

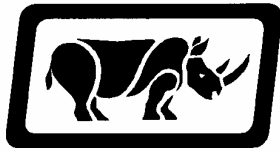
Weld seams and damaged areas should be blast cleaned to Class 21/2 (ISO 8501-1:1988) SSPC SP10.

APPLICATION

Mixing: Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.
(1) Agitate Base (Part B) with power agitator
(2) Combine entire contents of Curing Agent (Part A) with Base (Part B) and mix thoroughly with power agitator.

Mix Ratio: 9 parts (B) : 1 part (A) by volume

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APPLICATION cont.

<i>Working pot</i>	15°C	25°C	40°C
<i>Life:</i>	6 Hours	4 hours	1 ^{1/2} hours

Airless Spray: Recommended

- Tip range 0.38-0.46mm (13-15 thou)
- Total output fluid pressure at spray tip not less than 2,500 psi.

Air Spray Recommended

<i>(Pressure Pot):</i>	Gun	DeVilbiss MBS or JGA
	Air Cap	704 or 765
	Fluid Tip	E

Brush: Small areas only

Roller: Small areas only

Thinner: Acetone

Cleaner: Acetone

Work Stoppages: Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommence with freshly mixed units.

Clean up: Clean all equipment immediately after use, it is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

SAFETY PRECATIONS cont.

advice given on this TDS, the Material Safety Data Sheet (MSDS) and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which Rhino Linings Australasia Pty Ltd has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult Rhino Linings for further advice.

WARNING: *contains Isocyanate. Wear air fed hood for spray application*

SYSTEMS COMPATIBILITY

RhinoPrime RL315 is designed specifically as a blast holding primer; as such it should only be applied direct to correctly prepared steel and not be applied over any other coating.

For topcoat information consult Rhino Linings Australasia.

SAFETY PRECATIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the

Pack Size:	5 litre unit	Base (Part B)	4.5 litres in a 5 litre steel container
		Curing agent (Part A)	500ml in a 500ml steel container
For availability of other pack sizes contact Rhino Linings Australasia			
Shipping Weight:	U.N. Shipping No. 1263		
	5 litre unit	5 litre unit	5.25kg Base (Part B) .66kg Curing agent (Part A)
Storage:	Shelf Life	12 months minimum at 25oC (77oF). Subject to re-inspection thereafter.	
		Store in a dry, shaded conditions away from sources of heat and ignition.	