

RAYSTON PIPE TANK



TECHNICAL DATA SHEET

DESCRIPTION

Two-pack, solvent free, high build polyurethane coating. Certificate standard EN 10290.

FEATURE

Application:

- With dry film thickness up to 3 mm in one layer in the field or factory condition.
- Temperature vary from -5 to +50°C.

Provide:

- Very short drying and curing time.
- Volatile Organic Compound – 0 g/l.

RECOMMENDED TO USE

Steel and concrete structures:

- Operating temperature up to 60°C.
- In protective systems with environmental corrosivity classes C2-C4, C5 and CX (ISO-12944-2/2018).
- For structures immersed in fresh, sea or brackish water, buried tanks, steel piles, steel pipes, compatible with cathodic protection as well (Im1; Im2; Im3 and Im4 - ISO-12944-2 / 2018).

COMPATIBLE COATINGS

Depending on the operating conditions the material can be used with different types of coatings.

- Two-component epoxy coatings (2pack EP) of Rayston.
- Two-component polyurethane coatings (2pack PUR) of Rayston.

For details please contact the Rayston Technical Sales Support.

TECHNICAL DATA

Appearance

Color Grey, Dark Yellow and Black

Appearance Semi-gloss coating

Material properties

Volume solids 100 ±2%

Total mass of solids 1.27 g/cm³

VOC value 0 g/l

Temperature resistance 60°C

Adhesion to steel in the temperature range of 23°C to Tmax=50°C ≥8 MPa

Adhesion after keeping in water for 1000 hours at the temperature Tmax=+60°C ≥5 MPa

Service life expectancy* 30 years

Note: *Service life expectancy depends to a considerable extent on the accuracy of compliance with the technology in the process of surface preparation and coat application, as well as on the peculiarities of coat operation conditions.

SURFACE PREPARATION

| Surface type | Minimum | Recommended |
|--|---|--|
| Surface profile | Ry5 (75–120 µm) (ISO 8503-1) | Ry5 (75-120 µm) (ISO 8503-1) |
| Primed and previously painted surfaces | P St3; P Ma ISO 8501-2, ISO 12944-4 | P Sa2½; PMa ISO 8501-2½, ISO 12944-4 |
| Steel surfaces | Sa 2 (ISO 8501-1) | Sa 2½ (ISO 8501-1) |
| Concrete Surfaces | SSPC-SP 13/NACE N° 6 | SSPC-SP 13/NACE N° 6 |

AMBIENT CONDITIONS

Plural component airless application

Ambient air temperature from -5 to +50°C

Surface temperature from -5 to +50°C

Relative humidity, below 85%

Dew point at least 3°C lower than steel temperature

Paint Material temperature*

Component "A" +40°C

Component "B" not less than +15°C

Note: *Built-in heater for the base material component shall ensure heating upon application of component A to the temperature +50°C.

The surface should be dry and clean. The surface temperature should be min 3°C above the dew point of the air.

THICKNESS & THEORETICAL SPREADING RATE

| Standard Grade | Min. | Middle | Max. |
|--------------------|-----------------------|------------------------|------------------------|
| Dry Film Thickness | 500 µm | 1500 µm | 3000 µm |
| Wet Film Thickness | 500 µm | 1500 µm | 3000 µm |
| Spreading Rate | 2,0 m ² /l | 0,67 m ² /l | 0,33 m ² /l |

Note: Practical coverage depends on the application conditions, structure to be painted, roughness of the surface and application method.



KRYPTON CHEMICAL

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DRYING TIME

| Dry Film Thickness 1500 µ | 23°C |
|---------------------------|----------|
| Gel time | 120 sec. |
| Dry to touch | 30 min. |
| Min. recoating interval | 120 min. |
| Full curing | 7 d |

Note: Drying times and polymerization depend from the relative humidity, temperature, ventilation conditions and the thickness of the film.

For details please contact the Rayston Technical Sales Support.

APPLICATION DATA

Mixing ratio: 3:1

| Product | Volume |
|--------------|-------------------|
| Resin | 3 parts by volume |
| Curing Agent | 1 part by volume |

Plural component airless spray application:

Should be applied by plural component airless spray unit using proportioning pump capable to supply a volume mixing ratio of 3:1.

Thinning:

Thinning is not allowed.

Cleaner:

Mixer should have a safety valve and additional inlet for flushing with thinner, and for washing off equipment from mixed components when work is completed.

Use the cleaner Raystonthinner EP.

When spraying of materials is stopped, wash mixer, whip hose with the thinner within 5- 8 sec. Otherwise, whip hose and sprayer will get clogged with material.

APPLICATION METHODS

Plural component airless spray application unit

with a proportioning pump capable to supply a volume mixing ratio of 3:1 and built-in heater is recommended only.

Heated hose supplying components from the pump to the mixer shall be heat-insulated to keep the temperature of components. Hose pipe of component "A" shall have inner diameter 3/8", and hose pipe of component "B" shall have inner diameter 1/4".

Do not use whip hose longer than 5 meters after static mixer.

PACKAGING

| | Volume (liters) | Size of containers (liters) |
|---------|-----------------|-----------------------------|
| Comp. A | 200 | 200 |
| Comp. B | 200 | 200 |

STORAGE & SHELF LIFE

The product must be stored in original sealed containers. The storage conditions are to keep the containers in a dry, well ventilated space away from source of heat and ignition.

| Storage temperature | from 5 to 30°C |
|---------------------|----------------|
| Component "A" | 2 year |
| Component "B" | 1 year |

Note: After lasting storage primer shall be stirred thoroughly until its precipitation is spread over the suspension homogeneously. Precipitation in primer does not change its properties or worsen its quality.

After the expiration date has passed, it is necessary to check the quality of the paint material.

SAFETY

Use with adequate ventilation. Do not inhale aerosol. Avoid contact with skin. After contact with skin, wash immediately with detergent, soap and water. In case of contact with eyes, rinse immediately with water and seek medical advice immediately.

For detailed information on the health and safety protection for use of this product see Safety Data Sheet (SDS).

IMPORTANT NOTE

The above-mentioned information is given according to our laboratory tests and practical application experience.

The manufacturer takes into consideration the fact that the material can be used out of control; the manufacturer cannot give guarantees except of the material quality.

The manufacturer has the right to improve the product and change the above-mentioned data without preliminary notification.

THE PRESENT TECHNICAL DATA SHEET REPLACES ALL PREVIOUS EDITIONS.



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