

Product ID: Rapi-Liner® 110 – High Build Epoxy Novolac DTM

Document Date: 27 Mar 2019

Product Description & Suggested Uses:

RCT 110 Liner is a two component Novolac modified Epoxy liner designed for Direct to Metal applications where excellent corrosion and chemical resistance is required. RCT 110 ingredients are all food grade and meet FDA 21 CFR 175.300 for direct food contact. Typical uses include Hopper & Tank Car linings for; Flour, Sugar, Plastic Pellets, Grain, Corn Syrup & Calcium Carbonate Slurries.

Mixing and Thinning/Reducing Instructions:

Mix RCT 110 Liner 1:1 by volume with RCT 01 1228 AM Hardener. Agitate each component thoroughly before combining and then agitate mixture. No reduction is necessary. If reducing or thinning is required, please contact your Rapid Cure Technologies (RCT) technical service representative for instructions.

Directions for Use :

Surface must be clean, dry, sound and free of dirt, dust, grease, oils, residues, waxes, water, foreign particles, and any other contaminants that may interfere with coating adhesion and intimate contact with substrate. Prepare the substrate by abrasive blasting to a profile of 2.0-4.0 mils per NACE SSPC - SP10. Metal surface must be 5 degrees above the dew point temperature.

RCT 110 Liner is designed to be applied with airless spray @ 3000-4000 psi and 0.017-0.030 tips. Pot life is 4 hours @ 75 degrees and significantly reduced at elevated temperatures.

Clean-up:

Clean all equipment immediately after use with MEK or other RCT approved solvents. Use clean solvent only. In case of spill, absorb and dispose of in accordance with local, State, and/or Federal regulations.

Storage & Shelf Life:

Store indoors in original, tightly sealed container out of direct sunlight between 40°F (5°C) and 100°F (38°C), 0% to 90% relative humidity. Warranted shelf life is 12 months from date of manufacture (DOM) in original unopened and properly stored container.

Typical Mixed Properties:

Color	Light Blue, Salmon, White
Type	Epoxy-Novolac/Amine
Viscosity (25°C)	90-95 (KU's)
Specific Gravity (25°C)	1.30-1.40
Density (25°C)	10.80-11.66 lbs/gal
% Solids (by Volume)	80-82%
% Solids (by Weight)	85-87%
VOC	0.1-0.15 lbs/gal
VOC (less water/exempt)	0.1-0.12 lbs/gal
Flash Point	-15°C (5°F)
Gloss	Full
Recommended DFT	8-12 mils (200-300 um)
Maximum DFT	18 mils (450 um)
Coverage	1325 ft ² @ 1.0 mil
Dry @ 75 degrees F	3-4 hrs touch 6-7 hrs handle 96 hrs in service as a Liner
Force Cure	160-200°F for 2hrs In service – 24 hrs
Recoat	Within 96 hrs

Packaging:

RCT 110 Liner is available in one 1-gallon cans, five 5-gallon pails and 55-gallon steel drums. For additional packaging options, please contact your local Rapid Cure Technologies representative.

Safety Information:

Avoid contact with skin and use good ventilation. Wear chemically resistant gloves (nitrile are recommended) and chemical safety glasses. If skin contact is made, wash immediately with soap and water. Do not use solvents to clean skin. Refer to Safety Data Sheet for further safety and handling information.

FOR PROFESSIONAL USE ONLY
NOT FOR RESIDENTIAL USE
KEEP OUT OF REACH OF CHILDREN

Product ID: Rapi-Liner® 110 – High Build Epoxy Novolac DTM

Document Date: 27 Mar 2019

Physical Performance Properties:

Test	Test Method	Result
Adhesion	ASTM D3359	5A
Pencil Hardness	ASTM D3363	4H-5H
Abrasion resistance	ASTM D4060	1000 cycles, 100 mg loss
Bend – Flexibility	ASTM D522	Passes 1.5 inch radius bend
Impact	ASTM D2794	40 in/# Direct
Salt Fog	ASTM B117	3000 hours
Humidity	ASTM 4585	3000 hours
Heat Resistance	NACE SPO302	Dry Continuous – 400F Dry Intermittent – 500F Immersed Continuous- 140F Immersed Intermittent – 200F
Thermal Shock Resistance w/ Crude Oil	NACE SPO302	10 cycles of 24 hours @ 325F followed by 24 hours @ -40F No adhesion loss, cracking or flaking