



RAINBOW

RAINBOPRIME 806

Universal Epoxy Coating

PRODUCT NUMBER
TYPE
CHARACTERISTICS

RAINBOPRIME 806

The two pack, anticorrosion primer based on epoxy resin, hardener with rust-resistant pigment.

1. General purpose epoxy primer/coating in protective coating systems for steel and non ferrous metals.
2. Good adhesion to steel and galvanized steel.
3. Cures at temperatures down to 5°C.
4. Good water and corrosion resistance.
5. Good flow and wetting properties.
6. Good adhesion to non ferrous metals.
7. Suitable for touching up of weld seams and damages of epoxy coatings during construction.
8. Suitable on wet blast cleaned substrates (damp or dry).

GLOSS
VOC
COLORS
SPECIFIC GRAVITY
DRYING & CURING TIME
(Curing table)

Eggshell

Max. 319 g/L

Various other colors

Above 1.4 kg/L

Substrate temp.	5 °C	10 °C	15 °C	20 °C	30 °C	40 °C
Touch dry	12.0 hrs	6.0 hrs	4 hrs	2.5 hrs	2.0 hrs	1.5 hrs
Dry to handle	16 hrs	12 hrs	8.0 hrs	6.5 hrs	5.0 hrs	4.5 hrs
Full cure (Ballasting interval)	14 days	12 days	9 days	7 days	5 days	4.5 days

Above information is for DFT 160µm . Adequate ventilation must be maintained during application and curing.

OPTIMUM FILM THICKNESS
VOLUME SOLID
Maximum DFT

Wet 133 ~ 267µ (Micron) Dry 100 ~ 200µ (Micron)

75 ±2%

DFT of 1500µm may occur, due to multi-layer overlapping, Yung Chi must be consulted in case of DFT fall outside this recommendation

THEORETICAL COVERAGE
OVERCOATING TABLE

4.43 m²/L for DFT 160µm

Surface should be dry and free from any contamination

(EPOXY system for DFT 160µm)

Substrate temp.	5 °C	10 °C	20 °C	30 °C	40 °C
Minimum interval	16 hrs	12 hrs	6.5 hrs	5.0 hrs	4.5 hrs
Max interval (exposed to direct sunshine)	3 months	2.5 months	2 months	1.5 months	1 months
Max interval (not exposed to direct sunshine)	6 months	5 months	4 months	3 months	1.5 months

MIXING RATIO

Base : Hardener = 86.3 : 13.7 (by weight)

4 : 1 (by volume)

POT LIFE (at application viscosity)

15 °C	20 °C	30 °C
10 hrs	6 hrs	4 hrs

THINNER

No.1005 Epoxy Thinner (SP-12)

APPLICATION METHOD &
THINNER RATE

The mixing temperature 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.

	Thinner use	Volume of Thinner	Nozzle Orifice	Nozzle Pressure
Airless Sprayer	No.1005 Epoxy Thinner (SP-12)	0-5%	0.53-0.73mm(0.021-0.029)	150MPa(2130p.s.i)
Air Spray	No.1005 Epoxy Thinner (SP-12)	0-10%	1.5-2mm	0.3-0.4MPa(43-57p.s.i)
Brush & Roller	No.1005 Epoxy Thinner (SP-12)	0-5%		

EPDM3030806X V1.8

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RAINBOW

RECOMMENDED SPEC.
SHELF LIFE
NOTE

Please refer the painting specification
Minimum 2 years under normal storage condition.

1. **For immersion exposure:**

- Steel or steel with not approved zinc silicate shop primer; blast cleaned (dry or wet) to ISO-Sa2½, blasting profile 30-75 µm.
- Coated steel; hydrojetted to VIS WJ2 L (blasting profile 30-75 µm).

2. **IMO-MSC.215(82) Requirements for Water Ballast Tanks:**

- Steel; ISO 8501-3:2006 grade P2, with all edges treated to a rounded radius of minimum 2 mm or subject to three pass grinding.
 - Sa 2½ on damaged shop primer and welds. Sa 2 removing at least 70% of intact shop primer, if the Shop primer is not IMO PSPC Type approved to be compatible with this main coating. If the Shop primer is IMO PSPC Type approved to be compatible with this main coating, intact shop primer may be retained. The retained shop primer shall be cleaned by sweep blasting, high-pressure water washing or equivalent method.
 - After erection, butts St 3 or better or Sa 2½ where practicable. Small damages up to 2% of total area: St 3. Contiguous damages over 25 m² or over 2% of the total area of the tank, Sa 2½ shall be applied. Coating in overlap shall be feathered. The blasting profile shall be 30-75µm.
 - Dust quantity rating "1 for dust size class "3", "4" or "5", lower dust size classes to be removed if visible on the surface to be coated without magnification (ISO 8502-3:1992).
 - Water soluble salt limit equivalent to NaCl, after blasting / grinding shall be no more than 50 mg/m² of sodium chloride.
 - NDFT 320µm in with 90/10 rule. There shall be a minimum of two stripe coats and two spray coats, except that the second stripe coat, by way of welded seams only, may be reduced in scope where it is proven that the NDFT can be met by the coats applied, in order to avoid unnecessary over-thickness.
 - Stripe coats shall be applied by brush or roller. Roller to be used for scallops, ratholes, etc., only.
3. **For atmospheric exposure conditions:**
- Steel; blast cleaned to ISO-Sa2½, blasting profile 30-75 µm.
4. Substrate temperature should be above 5°C and at least 3°C above dew point during application and curing.
5. Maximum relative humidity during application and curing is 85%.
6. Permitted flash rust grade after water jet rust removal:Light(L)

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