

Resichem 501 ARXL

- High build solvent-free epoxy coating
- Contains hardened ceramic fillers
- Abrasion resistant lining for metallic & concrete

Cure Times

At 20°C (68°F) the product will have the following cure times:

Usable life	60 mins
Minimum overcoating	10 hrs
Maximum overcoating	36 hrs
Water/ sea water immersion	3 days
Chemical immersion	7 days

Coverage Rates

The mixed product will give the following coverage rates –

3.6ltrs (0.9 US gallon) –
9m² at 400 microns
96ft² at 16mil

17ltrs (4.5 US gallon) –
42.5m² at 400 microns
457ft² at 16mil

Colour

Base component –
Light Grey or Black
Activator component – Amber

Over-coating times

Minimum - the material can be over-coated as soon as it is touch dry, approximately 10 hours at (20°C (68°F)).
Maximum - the over-coating time should not exceed 36 hours.

Typical applications

Internal pipe surfaces
Tank internals
Chutes
Hoppers
Sumps
Process vessel
Separators
Chemical pits
Fans & fan housings
Turbine blades & housings

Technical specifications and characteristics

Mixing ratios	By weight	3.4 to 1
	By volume	2 to 1
Density	Base:	1.72
	Activator	1.03
	Mixed	1.49

Surface Preparation

Metallic Substrates

1. All oil and grease must be removed use an appropriate cleaner such as MEK.
2. All surfaces must be abrasive blast cleaned to **ISO 8501/4 Standard SA2.5 (SSPC SP10/ NACE 2)** 75 micron (3mil) profile.
3. Use an angular abrasive.
4. Degrease and clean using MEK or similar type material.
5. All surfaces must be coated before gingering or oxidation occurs.

Existing Concrete

1. Contaminated surfaces must be pressure washed.
2. Once dry, lightly blast clean or scarify do not expose the aggregate.
3. Clean all dust and debris from the surface and prime with Resichem 503 SPEP (low viscosity epoxy primer).
4. Apply 503 SPEP primer at 150 microns (6mil) WFT.
5. Leave to cure for 3 hours (20°C/68°F) before overcoating.

New Concrete

1. Allow new concrete to cure for a minimum of 21 days and treat to remove any surface laitance.
2. Check the moisture content of the concrete prior to coating (8% moisture content or below).
3. Lightly scarify the surface taking care not to expose the aggregate.
4. Clean all dust and debris from the surface and prime with Resichem 503 SPEP (low viscosity epoxy primer).
5. Apply 503 SPEP primer at 150 microns (6mil) WFT.
6. Leave to cure for 3 hours (20°C/68°F) before overcoating.

Mixing and Application

STEP 1

Ensure you have 1 x base unit, 1 x activator unit, 1 x spatula and drill and paddle mixer.



STEP 2

Pour the entire contents of the activator container into the base container.



STEP 3

Mix thoroughly, taking to care to ensure any unmixed base component is scraped down from the edges of the container using a spatula. Continue mixing until a streak free, uniform material is achieved.



STEP 4

Apply to the correctly prepared Substrate @400 Microns using airless spray unit, minimum pump size 45:1. Heated & insulated lines are necessary to maintain a constant 20-25°C (68-75°F) temperature. Spray pressure 3000-3500psi, tip size 19-23 Thou.



STEP 5

Allow to cure for minimum of 10 hours (20°C/68°F) or until touch dry and then apply the 2nd coat if required.

