

Technical Data Sheet



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Data sheet Nr. 1010RLE

AVKOTE RLE

Product description	Rapid drying coating with high scratch resistance for substrates like PVCu, other Plastics and GRP. Test standard compliance: DIN 68861 Part 1B (Chemical Resistance) DIN 4102 B1 (Non Flammable)		
Binding Agent	Polyurethane Acrylic Resin		
Areas of Application	High-quality top-coat for PVC and metal surfaces.		
Form of Supply	Colours	RAL and BS colour cards Other Colours available on request	
	Gloss Level	Silk (30 - 45 gloss levels at 60 °)	
Hardener	Avkote Hardener 279		
Packing	Coating	1, 3 and 5 Litre disposable containers	
	Hardener	1 Litre disposable containers	

Technical Data


The data is valid for Avkote RLE white 80. The values can change for other colours.							
	Coating		Hardener		Mixture		
Specific Gravity (23 °C)	1.2	g/cm ³	1.0	g/cm ³	1.17	g/cm ³	
Solids content	52	± 2 Weight-%	46	± 2 Weight-%	Appr 51	Weight-%	
Organic Solvent Content.	48	± 2 Weight-%	54	± 2 Weight-%	Appr 49	Weight-%	
VOC Content (CH / EU)	57	%	570	g/lt	56	%	560 g/lt
Shelf life at 20 °C	12 Months		6 Months in well shut containers				
Theoretical Coverage	96	g/m ²	10.4	m ² /kg for	30	µm dry layer thickness	

Safety Data	Coating	Hardener
Flash point	27 °C	0 °C
Transport ADR/RID	Class: 3 VP: III	Class: 3 VP: III
Poison classification (EU)		
VVS disposal code (EU/CH)	08, 08 01, 08 01 11	08, 08 01, 08 01 11



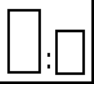
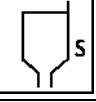

Application Recommendations




Substrate	No. of Coats	Product	Dry Film thickness	Data sheet
PVCu (PVC-Profiles) & GRP	1 x Top Coat	Avkote RLE	30-50 µm	1010RLE
Other Plastics	Please refer to our technical department.			
Aluminium and galvanised substrate	1 x Primer	Aquakote AK Primer or Avkote 2250 Primer	30 - 50 µm 40 - 60 µm	7106 EA9000
	1 x Top Coat	Avkote RLE	30 - 50 µm	1010RLE
Steel	1 x Primer	Aquakote AK Primer or Avkote 2250 Primer	30 - 50 µm 40 - 60 µm	7106 EA9000
	1 x Top Coat	Avkote RLE	30 - 50 µm	1010RLE
For further application proposals please ask our technical department.				

Preparation

 Substrate	Preparation instructions
PVCu (PVC-Profiles)	Clean with Avkote 153b Cleaner first then with Avkote 154 Cleaner. Apply Avkote RLE.
GRP	Clean with Avkote 154 Cleaner. Apply Avkote RLE.
Other Plastics	Please refer to our technical department.
Aluminium and galvanised substrate	Ensure metal is clean and grease free. Apply Primer. Sand as required. Apply Avkote RLE Top coat.
Steel	

Processing

 Preventative measures	We recommend the wearing of protective clothing even if not stipulated by law. The national and regional health and safety regulations for work hygiene and equipment are to be observed. Pay attention to our safety data sheet Nos. 539300RLE and 279H00.
 Stir	Before use ensure contents are stirred together well with hardener if applicable.
 Mixing Ratio	4 : 1 by volume with Avkote 279 hardener
Pot life at 20 °C	Minimum 8 hr. according to tone
 Thinners	Thinned ready to roller or brush.
 brush	Yes

	Roll	Mohair Roller recommended																				
	Evaporation time	Prior to drying at temperatures over 40 °C allow an evaporation time of 15 minutes.																				
	Drying time	For 50 µm dry coating at 65 % of relative humidity																				
	At 20 °C	<table> <tr> <td>Tack-Dry</td> <td>after:</td> <td>20</td> <td>Minutes</td> </tr> <tr> <td>Touch – Dry</td> <td>after:</td> <td>20</td> <td>Minutes</td> </tr> <tr> <td>Dried (Can be sanded)</td> <td>after:</td> <td>2</td> <td>Hour</td> </tr> <tr> <td>Suitable for re-coating</td> <td>after:</td> <td>2</td> <td>Hours</td> </tr> <tr> <td>Completely Dry</td> <td>after:</td> <td>7</td> <td>days</td> </tr> </table>	Tack-Dry	after:	20	Minutes	Touch – Dry	after:	20	Minutes	Dried (Can be sanded)	after:	2	Hour	Suitable for re-coating	after:	2	Hours	Completely Dry	after:	7	days
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Important references

Specific restrictions	Relative humidity max. 80 %		
Minimum application- and drying temperature	15	°C	Do not apply at temperatures below the dew point
Coating removal	Sand blast and/or paint stripper		
Equipment cleaning	Clean immediately after use with Gun Wash Thinners.		

Important Recommendations

	For buildings situated near the sea or in a heavily polluted area or city a clear coat must be applied to protect against the influence of salt air and pollution.
	For pastel coloured coating of surfaces subject to heavy use, such as structural elements, working surfaces etc., it is recommended to clear coat with an Avkote Varnish to improve resistance to marking.
	Please observe our Material Safety Data Sheets for all products used as well as the instructions on the tin label.

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