



Rhinofleet[®] AC HS

2K polyurethane-acrylic enamel

6075 - line

Description

- 2-pack acrylic-modified polyurethane high performance topcoat

Properties

- Superior weather resistance and light fastness
- High solids, providing high film build per coat
- Excellent gloss retention

Typical Applications

- Steel fabrications (e.g. cranes)
- Truck and bus refinishing

General Data

- Weather resistance Excellent
- Solvent resistance Resists splashes of most common solvents; not recommended for continuous immersion
- Chemical resistance Good
- Abrasion resistance Good
- Suitable primers 2K Hi Fill Primer, Rhinamel[®] CC Primer, Rhinogrip[®] Etch Primer, Epoxycoat

Specifications (at 25°C and 50% relative humidity)

- Resin type..... Acrylic-modified polyurethane
- Mixing ratio..... 4 : 1
- Solids content..... 55% (by volume)
- Typical film thickness (per coat)..... 40 microns (dry)
70 microns (wet)
- Theoretical coverage..... 14m² / L @ 40 microns dry film thickness (dependant on colour)
- Touch dry..... 2 - 3 hours
- Hard dry..... 16 hours
- Full cure..... 7 days
- Recoating..... after 16 hours
- Pot life..... 2 hours (depending on temperature and level of thinner added)
- Gloss..... Gloss
- Colour..... Extensive colour library and easy colour matching with Coloryte[®] Industrial Tint System
- Shelf life..... minimum 12 months (in cool, dry conditions; unopened containers)

Surface Preparation

- Bare steel surfaces must be degreased, then subjected to abrasive blasting (to AS 1627.4 Class 2½) or abrasion with a suitable power cleaning tool (e.g. disc sander)
- Not suitable for application directly to bare metal. Refer to recommendations Coatings Systems below.

Mixing recommendation

- Mix only the quantity required for the job
- Mix Pack A with Pack B in the ratio 4:1
- Stir thoroughly with a broad paddle or mechanical mixer to ensure even mixing of the two parts
- Thin up to 20% by volume with Wagon Paints' T1 PU Spray Thinner (see Application directions), and stir as above

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Application

- May be spray applied using airless or conventional air spray equipment
- Small areas may be coated by brush or roller
- **Airless Spray** nozzle size.....0.33 - 0.38 mm
nozzle pressure.....2200 - 3000 psi (15 - 20mPa)
volume of thinner.....up to 10%
- **Air Spray** nozzle size.....1.8 - 2.2 mm
nozzle pressure.....55 - 70 psi (350 - 450kPa)
volume of thinner..... up to 20%
- **Cleaning solvent** T1 PU Spray Thinner

Coating Systems

Substrate	Primer	Undercoat*	Topcoat
Aluminium	Rhinogrip® Etch Primer		Rhinofleet® AC HS
Galvanised Iron	Rhinogrip® Etch Primer	2K Hi Fill Primer	Rhinofleet® AC HS
Steel	Rhinogrip® Etch Primer	2K Hi Fill Primer	Rhinofleet® AC HS
Zincseal / Zinalume	Rhinogrip® Etch Primer		Rhinofleet® AC HS
Fibreglass		2K Hi Fill Primer	Rhinofleet® AC HS
Timber		2K Hi Fill Primer	Rhinofleet® AC HS

Rhinogrip Etch primer may be directly overcoated with Rhinofleet® AC HS to provide an economical and quick drying alternative to the traditional two pack epoxy undercoats. For optimum performance in severe environments, the use of a single coat of epoxy undercoat between Rhinogrip® Etch & Rhinofleet® AC HS is recommended.

***Rhinamel® CC Primer may be used in place of 2K Hi Fill Primer**

Caution:

Store Rhinofleet® AC HS Pack A & B in a cool, dry location. Do not allow water to contaminate the products.
Must not be applied over damp surfaces. Do not apply when the air/surface temperatures are below, or are likely to fall below, 10°C or the relative humidity is above 70%.

Safety precautions

- **Refer to the relevant Material Safety Data Sheets for Pack A and Pack B**
- Contents are flammable – keep away from all ignition sources
- Avoid contact with skin and eyes – when mixing, wear gloves and goggles
- When spraying, ensure adequate ventilation and wear appropriate protective clothing and equipment

Packaging Group II **UN No.** 1263 (Pack A); 1866 (Pack B)

Pack sizes 4 litre, 20 litre (Pack A)
1 litre, 5 litre (Pack B)

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These technical data and recommendations are based on tests and information believed to be accurate at the time of printing. They should not be construed as containing any warranty, either expressed or implied. Users should conduct their own tests to determine final suitability of this product.

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