

Product Datasheet

Resicoat® R4-ES for Electrostatic Spray Application on Preheated Surfaces Code: HJF42R

Product Description

Resicoat® R4 is a high quality thermosetting epoxy powder coating for the corrosion protection of valves and fittings, manufactured from cast iron or steel. The powder coating is available to be applied in one layer on a preheated surface by electrostatic spray application. Typical film thickness achieved is in the range of 250 – 500 µm. The resultant thermoset epoxy has a high mechanical resistance with excellent electrical insulation properties. Drinking water approvals are available to confirm the coatings suitability, as a hygienic and environmental friendly coating. The outstanding adhesion of Resicoat® R4 epoxy powders to the metal substrate provides long term protection of the coated component. It ensures a reliable conservation to the function and value of the parts for the common water and gas distribution network. The applicator of Resicoat® R4 benefits from a modern and environmentally friendly process. It is possible to overcoat Resicoat® R4 with polyester powder and liquid coatings to achieve UV protection.

Powder Properties

	Typical value	Method
Binder System	Epoxy resin	
Density	1.45 – 1.55 g/cm ³	ASTM D5965
Gel time at 392° F (200° C)	25 – 40 sec.	ASTM D4217
Particle size distribution	D10 = 10 – 15 µm D90 = 135 – 160 µm	Malvern ISO 8130-1
Storage stability	6 months at ≤ 74 °F (23 °C)	
Safety precautions	See Material Safety Datasheet (MSDS)	

Application Data

Preheating temperature object	392 – 428 °F (200 – 220 °C) object temperature
Post cure conditions object	The coating is self curing, if the wall thickness of the steel/cast iron is greater than 8 mm. If the wall thickness of the steel/cast iron is less than 8 mm, additional curing of 3 to 8 minutes at 392 °F (200 °C) object temperature is required.

- 1. Pre-cleaning**
The surface must be free of oil, grease, salt, and other impurities.
- 2. Blasting**
Molding sand, rust and sharp edges must be removed with angular steel grit. The graphite from the cast iron must be removed from the blasting material according NACE No.2/ SSPC-10/Sa 2.5. Recommended anchor profile of ≥60 µm should be stored max. 4 hours before pre-heating (dust-free and dry).
- 3. Pre-heating**
This form of heating produces a uniform, defined temperature in the component. Any oxidation should be avoided.
- 4. Coating application**
Immediately after preheating, the coating process starts without losing any object temperature. The coating is done in the shortest possible time in a single pass with no interruption

	Typical value	Method
Coating Process	5. Coating cure	
	Curing is achieved by the heat contained in the object. If the heating capacity of the work piece is sufficient. To confirm fully curing, MIBK is dropped for 30 sec. on the film surface with no visible change.	
Material Properties	Color	blue
	Recommended film thickness	10 – 14 mils (250 – 350 µm)
	Flow	smooth
	Gloss at 90° angle	70 – 90 units DIN 67530
	Cross cut test	Gt 0 DIN EN ISO 2409
	Impact resistance	> 5 Joule DIN 30677-2
		> 2.26 Joule ASTM D2794 20 inchpound
		> 18 Joule ASTM G14 modified 1/8 in (3.2 mm) steel plate
	Abrasion resistance	ASTM D4060 CS-17, 1000 g, 1000 cycles
	Dielectric strength	< 40 mg ≥ 30 kV/mm IEC 60243-1
	Volume resistivity (DC voltage)	1.1 x 10 ¹⁵ ASTM D257
	Elongation	> 5 % DIN 30671
	Indentation resistance	
	48 h, 158 °F (70 °C)	< 30 % DIN 30677-2/DIN EN 14901
	24 h, 140 °F (60 °C)	< 10 % ASTM G17
	Compressive strength	> 100 MPa ASTM D695
	Shear adhesion	> 35 MPa ASTM D1002
	Heat aging in air (90 d), water	fulfilled DIN EN 14901
	Thermal stability under heat aging	pass AS/NZS 4158:2003
	Weathering (Xenon test), 100 d	pass ASTM D2596-99
	Hardness	F Pencil
	Strain polarization	pass WIS 4-52-01
	Cathodic disbonding	
	30 d, 74 °F (23 °C)	≤ 10 mm DIN 30677-2, GSK
	Hot water immersion	
	90 d, 158 °F (70 °C)	pass AWWA C550-05
	Adhesion	> 20 MPa ASTM D4541
	Adhesion after 7 d, 194 °F (90 °C) water	≥ 16 MPa ISO 4624, GSK
	Tensile strength	approx. 500 kg/cm ³ ASTM D2370
	Penetration	< 5 % ASTM G17

		Typical value	Method
Material Properties	Disinfectant resistance according DVGW work sheet W 291 (chlorine dioxide, sodium hypochlorite)	no change of surface, no chalking The following migration test with demineralised water showed no defects of the film. The concentration of the examined parameters in the tested water were below the limits of the epoxy guideline for ancillaries for pipes DN > 300 mm (in main trunks).	after 10 test stages à 15 h
	Water condensation test (Cleveland test), 21 d	no change	ASTM D4585
	Salt spray resistance, 2000 h	no blistering, no loss of adhesion	BS 3900:F4
	Salt spray test, 4000 h	no under-rusting on the cut	DIN EN ISO 9227 (steel substrate)
	Water absorption, 100 d, 74 °F (23 °C)	pass	AS/NZS 3862
	Chemical resistance (pH 3 – 13, 23° C)	fulfilled	EN 598
Conformities	<ul style="list-style-type: none"> • AWWA C116 • AWWA C550-05 • EN 14901 • ISO 12944-2, table 1 (standard does not include powder coating systems) It is assumed that Resicoat® R4 is suitable to meet the high atmospheric corrosivity category C4 (typically in industrial areas and coastal areas with moderate salinity) and the very high atmospheric- corrosivity - categories C5-I (industrial) and C5-M (marine) if applied as a holiday-free coating at a film thickness > 400 µm. A sufficient film thickness is highly required to ensure good edge coverage. For gloss and color stability a UV-resistant polyester topcoat has to be applied. 		
Drinking Water Approvals	US: ANSI/NSF 61 Drinking Water System Components – Health Effects, NSF DE: UBA-Coatings Guideline, Approval no.: C-138801-06, Hygiene Institut DE: DVGW directive work sheet W 270, Approval no. W-211795-11, Hygiene Institut UK: BS 6920, Approval No. 1112500, WRAS		
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Disclaimer: This Product Data Sheet is based on the present state of our knowledge and on current laws. The data referring to Powder Properties, Application Data and Physical Tests is based on lab based samples. Factors such as quality or condition of the substrate may have an effect on the use and application of the product. It remains the responsibility of the user to test thoroughly if the product is applicable for the intended use. The use of the product beyond our recommendation releases us from our responsibility, unless we have recommended the specific use in writing. It is always the responsibility of the user to take all necessary steps to fulfil the demands set out in the local rules and legislation. We are not liable for any application-technological advice. The Product Data Sheet shall be updated from time to time. Please ensure you have the latest version before using the product. All products and Product Data Sheets are subject to our standard terms and conditions of sale (GCS). You can receive the latest copy of GCS via internet or our post address. Brand names mentioned in this Product Data Sheet are trademarks of or are licensed to the AkzoNobel group.

Resistance against chemical substances of Resicoat® R4 at room temperature

Acetic acid	10 %	2 years	no change
Ammonia	10 %	2 years	no change
Ammonia	36 %	1.5 years	no change
Antifrogen L	50 %	1 year	no change
Antifrogen N	50 %	1 year	no change
Benzol		1 month	no change
Bore oil		1 year	no change
Butanol		6 months	no change
Carbon tetra chloride		1 year	no change
Caustic soda solution	10 %	2 years	no change
Caustic soda solution	50 %	2 years	no change
Chlorine cleanser and disinfectant		1.5 years	no change
Citric acid		2 years	no change
Deicer Safeway KF HOT		1 year	no change
Deicer Safeway SF (solid)		1 year	no change
Deicer Safewing MP II 1951		1 year	no change
Dichromatic potassium	10 %	1 year	no change
Diesel		2 years	no change
Engine oil SAE 20		1 year	no change
Ethanol		1 year	no change
Ethyleneglycole		1 year	no change
Formaldehyde	37 %	6 months	no change
Formic acid	5 %	2 years	no change
Formic acid	10 %	1.5 years	no change
Glycerol		1 year	no change
Glysantin		1 year	no change
Hydrochloric acid	concentrated	1 week	no change
Hydrochloric acid	10 %	2 years	no change
Hydrochloric acid	25 %	1.5 years	no change
Hydrofluoric acid	1 %	1 day	no change
Hydrogen peroxide	3 %	1 year	no change
Hydrogen peroxide	10 %	1 year	faded

Lactic acid	10 %	1 week	no change
Methanol		1 week	no change
Methyl tert-butyl ether (MTBE)	100%	6 months	softening
Nitric acid	10 %	1.5 years	no change
Nitric acid	25 %	1 year	no change
Oxalic acid	5 %	6 months	no change
Palm oil	at 90° C	7 days	no change
Petrol		2 years	no change
Petroleum		1 year	no change
Phosphoric acid	10 %	2 years	no change
Phosphoric acid	50 %	2 years	no change
Potassium hydroxide	10 %	1 year	no change
Potassium hydroxide	25 %	1 year	no change
Potassium hydroxide	50 %	1 year	no change
Propanol		1 year	no change
Sea water		2 years	no change
Sodium acetate	10 %	1 year	no change
Sodium carbonate	20 %	1 year	no change
Sodium hypochlorite (15 % Cl ₂)		10 weeks	no change
Sodium chloride	2 %	1 year	no change
Sodium chloride	20 %	1 year	no change
Sodium formiate	10 %	1 year	no change
Suds	1 %	1 year	no change
Sulphuric acid	2 %	2 years	no change
Sulphuric acid	20 %	2 years	no change
Sulphuric acid	50 %	2 years	no change
Tartaric acid	5 %	1 year	no change
Toluol		1 year	no change
Turpentine oil		1 year	no change
Urea	10 %	1 year	no change
Urine		1 year	no change
Xylol		1 year	no change

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