

Product Datasheet

Resicoat® R4-FB for Fluidized Bed Application on Preheated Surfaces Code: HNC01R

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 applied in one layer on a preheated surface by fluidized bed 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 an UV protection.

Powder Properties

	Typical value	Method
Binder System	Epoxy	
Density	1.30 – 1.40 g/cm ³	ISO 8130-2
Gel time at 200° C	30 – 45 sec.	modified ISO 8130-6
Particle size distribution	< 63 µm = 30 – 50 % < 200 µm > 99 %	Malvern ISO 8130-1
Storage stability	6 months from delivery date at ≤ 23° C	

Application Data

Preheating temperature object	190 – 235° C object temperature
Post cure conditions object	self curing if wall thickness of steel/cast iron is > 8 mm

Coating Process

1. Pre-cleaning	The surface must be free of oil, grease, salt, and other impurities.
2. Blasting	Moulding 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.
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		Typical value	Method
	Color	black	
	Recommended film thickness	250 – 300 µm	
	Flow	smooth	
	Gloss at 60° angle	70 – 90 units	DIN 67530
	Cross cut	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
		< 40 mg	
	Dielectric strength	≥ 30 kV/mm	DIN 30677-2
	Volume resistivity (DC voltage)	1.1 x 10 ¹⁵	ASTM D257
	Elongation	> 5 %	DIN 30677-2
	Indentation resistance 48 h, 70° C	< 30 %	DIN 30677-2/DIN EN 14901
	24 h, 60° C	< 10 %	ASTM G17
	Compressive strength	> 100 MPa	ASTM D695
	Shear adhesion	> 35 MPa	ASTM D1002
	Heat aging in air (90 days), water	fulfilled	DIN EN 14901
	Thermal stability under heat aging	pass	AS/NZS 4158:2003
	Weathering (Xenon test), 100 days	pass	ASTM D2596-99
	Hardness (Buchholz)	> 100	DIN EN ISO 2815
	Strain polarization	pass	WIS 4-52-01
	Cathodic disbonding, 30 days, 23° C	≤ 10 mm	DIN 30677-2, GSK
	Hot water immersion 90 days, 70° C	pass	ASTM C550-05
	Adhesion after 7 days, 90° C water	≥ 16 MPa	ISO 4624, GSK
	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 days	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 days, 23°C ± 2	pass	AS/NZS 3862
	Chemical resistance	fulfilled	EN 598

Conformities**ASTM C550-05**

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.

Approvals**Drinking water:**

DE: UBA-Coatings Guideline, Approval no.: K-235947-13, Hygiene Institut

DE: DVGW directive work sheet W 270, Approval no. W-211795-11, Hygiene Institut

FR: DGS/VS 4 No99/217, AFNOR XP P41-250-1-3, No. de dossier: 10 MAT LY 052, LSEHL

UK: BS 6920, Approval No. 1112500, WRAS

BE: Pidpa/Hydrocheck 011, Certificat R4 Black, Belgaqua

Gas:

Test of resistance to gas according G 260, Report no.: 06/069/5123/3, DVGW

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GK

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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
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
Glystantin		1 year	no change
Hydrochloric acid	Concentrate	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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