



Raven 150

DESCRIPTION

Raven® 150 is a two component, solvent-free, 100% solids epoxy adhesive bonding intermediate for thermomelt plastics (including PVC, plasticized vinyl sheet linings and ABS plastic).

TYPICAL USES

Formulated for interfacing thermomelt plastic materials such as pipe, pipeliners, sheet liners, etc. and Raven protective coatings.

COLOR

Light gray is the standard product color.

SOLIDS BY VOLUME

100% solids by volume.

Volatile Organic Compounds: 0.0 lbs/gallon

FILM THICKNESS

Raven 150 is recommended to be applied a minimum wet film thickness of 20 mils, and an average thickness of 60 mils.

THEORETICAL COVERAGE

25 sq. ft. per gallon at 60 mils thickness. Actual surface coverage will depend on surface irregularities. Trials are recommended to determine the actual coverage required to yield a desired film thickness for each individual type of installation.

APPLICATION METHOD

Brush, squeegee, trowel or hand application. For specific information on application and Certified Applicators, contact RLS.

THINNING

Do not thin with solvents; loss of adhesion and solvent entrapment can result.

CLEAN-UP

To clean tools, use acetone, xylene or MEK. To clean skin, immediately wash thoroughly with soap and water – refer to the Material Safety Data Sheet for additional information on health and safety.

POT LIFE

45 minutes for 1 gallon at 75°F.

30 minutes for 2 gallons at 75°F.

The amount of pot life and working life will vary depending on the quantity of epoxy mixed, ambient temperature and the container in which the mixed material is held. Contact RLS for additional information.

CURE & RECOAT TIME

Raven 150 sets quickly (2-5 hours) and can reach full cure within 7 hours at 70°F. Therefore, topcoat Raven 150 with the specified Raven Epoxy immediately after installation while the 150 is still tacky. If this window is missed, dry specified surfaces thoroughly and prepare by abrading the 150 surface and cleaning prior to application of the Raven Epoxy topcoat. For more information, contact RLS.

SURFACE TEMPERATURE

Minimum recommended: 40°F

Maximum recommended: 100°F

SURFACE PREPARATION

All contaminants including oil, grease, wax, form release, sealers, salts, or other contaminants must be removed from surfaces to receive 150. This may be accomplished through one or a combination of the following methods: detergent water cleaning, hot water (steam) cleaning, and/or solvent cleaning. Detergent cleaning should be followed by thorough rinsing with potable water. Allow surface to dry completely or dry with lint free rags.

Thermomelt plastics may require solvent cleaning to remove bond-inhibiting materials such as mold release compounds, processing aids or other nonpolar contaminants from the surface of the plastics. Acetone, methyl ethyl ketone (MEK), PVC cleaner or similar solvents may be used. After loose dirt and contaminants have been removed, wipe or scrub the specified surfaces with clean lint-free rags wetted with solvent. Allow solvent cleaned areas to dry by evaporation thoroughly.

WARNING: Many solvents are hazardous. Care must be taken when using solvents in cleaning. Special safety precautions must be followed especially with regard to ventilation, ignition sources, respiratory protection, eye protection and skin contact. Refer to solvent MSDS for necessary information.

SURFACE PREPARATION (continued)

PROFILE: After contaminants have been removed, create a surface profile for enhanced adhesion. Abrasive blasting, power tools, hand tools, or flame treatment (mild scorch) may be used.

WARNING: Flame treatment can be hazardous, especially in confined spaces and after solvent-cleaning. Solvents must be completely evaporated and purged from structure prior to flame treatment. Manufacturers of the thermomelt plastics should be contacted to determine precautions necessary when utilizing flame treatment on their materials. Proper ventilation, respiratory protection, personal protective equipment and other recommended measures should be utilized in compliance with appropriate regulations for safety.

AVAILABLE PACKAGES

1 quart and 2-gallon kits. Kits include components for proper mix ratio. Raven 150 is available through Certified Applicators.

COMPONENTS AND MIX RATIO

Part A, Resin. Part B, Hardener. 1:1 by volume.

Component containers need to be mixed prior to metering if contents have settled. Meter one part of Part A to one part of Part B by volume into a clean container. Completely mix combined components before transferring contents to a clean container. Continue mixing in the clean container before application, scraping the sides frequently to attain a thorough mix.

VISCOSITY

Part A: 3,000-5,000 cps, Brookfield RVF.
Part B: 500-1,000 cps, Brookfield RVF.

SHELF LIFE AND STORAGE

Shelf Life: 1 year in sealed, unmixed containers at room temperature. Store in a sheltered area between 60°F and 80°F (15°C and 27°C).

SAFETY

Consult the Material Safety Data Sheet for this product concerning health and safety information before using. Strictly follow all notices on the Material Safety Data Sheet and container label. If you do not fully understand the notices and procedures provided or if you cannot strictly comply with them, do not use this product. Actual safety measures are dependent on application methods and work environment. Contact RLS to obtain a copy of the Material Safety Data Sheet at 800-324-2810.

PERFORMANCE TESTING

DESCRIPTION	METHOD	RESULTS
Flexural Strength	ASTM D790	7,000 psi
Compressive Strength	ASTM D695	6,600 psi
Tensile Strength	ASTM D638	4,000 psi
Tensile Ultimate Elongation	ASTM D638	3.7%
Hardness, Shore D	ASTM D2240	80
Taber Abrasion, CS17 wheel	ASTM D4060, 1000 g load/1000 cycles	<150 mg
Adhesion	ASTM D4541, Steel (SSPC SP-10) Concrete	>2,390 psi Substrate Failure

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