



Raven 405FS

DESCRIPTION

Raven® 405FS is a solvent-free 100% solids, ultra high build epoxy coating formulated for Fast Set and broad range chemical resistance. Designed for operating temperatures up to 200°F, 405FS's high-build ability allows it to be applied on vertical and overhead surfaces. The surface tolerance of 405FS allows it to be used as a structural lining in manholes, pipelines, tanks and other deteriorated structures.

TYPICAL USES

Surfaces where rehabilitation of an existing structure requires enhancement of the structural integrity and where exposure to concentrated acids and caustics may be expected, including:

- Tunnels and pipelines
- Clarifiers
- Digesters
- Tanks
- Secondary containment
- Manholes
- Wastewater facilities
- Floors and walls

COLOR

The Part A Resin is white; the Part B Curing Agent is blue. When mixed the product is light blue. Limited special colors are available on request.

SOLIDS BY VOLUME

100% solids by volume
Volatile Organic Compounds: 0.0 pounds per gallon

FILM THICKNESS

Raven 405FS is a 100% solids epoxy with zero shrinkage. Wet film thickness and dry film thickness are the same (i.e. 80 mils WFT = 80 mils DFT). Depending on substrate type and profile, a maximum of 125 mils per coat is recommended to prevent sagging. Recommended thickness will vary from 40 - 250 mils+ based on service conditions.

COVERAGE

Theoretical coverage is 20 square feet per gallon at 80 mils wet film thickness. Actual surface coverage will depend on substrate porosity and roughness. Good painting practices suggest application of two coats for quality assurance. A wet film thickness gauge may be used to determine actual coating coverage.

APPLICATION

Apply with trowel, putty knife, squeegee, brush, roller, airless or air-assisted spray or other suitable method. Optimal proportioning and mixing is achieved with the use of an RLS approved plural component airless spray system. For best results, apply this product to concrete when its temperature is stable or falling.

THINNING

Do not thin with solvents. If lower viscosity is needed, heat unmixed material by placing the containers in hot tap water until the desired flow properties are obtained. To heat larger quantities, drum heaters or inline heaters on specialized spray equipment may be used. Unmixed material should not be heated above 120°F.

COMPONENTS AND MIX RATIO

Part A Resin:Part B Curing Agent mix ratio is 3:1 by volume.

POWER MIXING

Individually power mix both Part A and Part B containers prior to measuring out 3 parts of Part A to 1 part of Part B by volume into a clean disposable pail. Completely mix combined A & B before transferring contents to a clean pail. Continue mixing while scraping the sides and bottom to obtain a thorough mix before application. Properly mixed material will be a uniform color without light or dark spots.

CLEAN UP

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

POT LIFE

The pot life is 10 minutes for ½ gallon at 72°F. The working life varies depending on the amount and temperature of epoxy mixed and the ambient temperature.

CURE TIME

Thin film set time varies with substrate temperature and application thickness. Generally, the coating will be tack-free in 1½ hours at 72°F and dry-hard in about 2 hours.

RECOAT TIME

This product may be recoated as soon as it becomes tacky but does not transfer to the finger. When applying multiple coats, do not allow more than 12 hours at 72°F substrate temperature to pass between coats, higher temperatures will shorten this window. Before recoating; inspect, clean and dry surface thoroughly to remove all contamination, including amine blush or condensation. If the recoat time is missed, clean and abrade surfaces prior to recoating.

SUBSTRATE TEMPERATURE

Minimum recommended substrate temperature: 35°F
Maximum recommended substrate temperature: 120°F

Raven 405FS

TEMPERATURE RESISTANCE

Maximum recommended dry temperature: 200°F. Wet temperature resistance depends on chemical concentration and exposure time.

SURFACE PREPARATION

Prior to coating, the substrate must be prepared in a manner that provides a uniform, clean, sound, neutralized surface suitable for the specified coating. The substrate must be free of all contaminants, such as oil, grease, rust, scale or deposits. In general, coating performance is proportional to the degree of surface preparation.

STEEL surfaces may require “Solvent Cleaning” (SSPC-SP 1) to remove oil, grease and other soluble contaminants. Chemical contaminants may be removed according to SSPC-SP 12/NACE No. 5. Identification of the contaminants along with their concentrations may be obtained from laboratory and field tests as described in SSPC-TU 4 “Field Methods for Retrieval and Analysis of Soluble Salts on Substrates”. Surfaces to be coated should then be prepared according to SSPC-SP 5/NACE No.1 “White Blast Cleaning” for immersion service or SSPC-SP 10/NACE No. 2 “Near White Blast Cleaning” for all other service. In certain situations, an alternate procedure may be to use high (>5,000 psi) or ultrahigh (>10,000 psi) pressure water cleaning or water cleaning with sand injection. The resulting anchor profile shall be 2.5-5.0 mils and be relative to the coating thickness specified.

CONCRETE AND MASONRY surfaces must be sound and contaminant-free with a surface profile equivalent to a

CSP2 to CSP5 in accordance with ICRI Technical Guideline No. 03732. This can generally be achieved by abrasive blasting, shot blasting, high pressure water cleaning, water jetting, or a combination of methods.

AVAILABLE PACKAGES

Available in 1 gallon kits (3 quarts of A in a 1 gallon pail & 1 quart of B), 1 gallon buckets (4 gallon kit), 5 gallon pails (20 gallon kit), 30 gallon drums (120 gallon kit) and 55 gallon drums (220 gallon kit). Kits are supplied in the correct proportions of A & B; these two components must be mixed together before use. Raven 405FS is available through Raven Certified Applicators.

SHELF LIFE AND STORAGE

Product shelf life is 1 year from purchase date in sealed, unmixed containers, stored 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 on the MSDS 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 Raven Lining Systems to obtain a copy of the Material Safety Data Sheet at 800-324-2810.

TYPICAL PROPERTIES⁽¹⁾

DESCRIPTION	METHOD	RESULT
Tensile Strength	ASTM D 638	7,600 psi
Tensile Ultimate Elongation	ASTM D 638	1.5%
Compressive Strength	ASTM D 695	16,000 psi
Flexural Strength	ASTM D 790	13,000 psi
Hardness, Shore D	ASTM D 2240	88
Adhesion, Concrete	ASTM D 7234	Substrate Failure

(1) Typical properties are to be considered as representative of current production and should not be construed as specifications.

Warranty and Disclaimer: Raven Lining Systems, Inc. (“Raven”) warrants its products to be free of manufacturing defects in accord with applicable Raven quality control procedures and that they meet the formulation standards of Raven. To the best of our knowledge the technical data contained herein is true and accurate on the date of publication and is subject to change without prior notice. If, within one year from purchase, any product is proven defective, Raven, at its sole option, will either replace the defective product or refund the purchase price. This warranty is void if the product is used contrary to Raven’s written directions.

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