

# RELEST® Wind Process Coat N Beige

## Polyurethane

### PRODUCT DESCRIPTION

**Product Code: Base (RLA511, I373-2050) / Hardener (RLA616, I385-3203)**

A two component, solvent-free polyurethane process coating for rotor blade production.

### INTENDED USES

Used in the manufacture of moulded rotor blades to provide a pore-free and sandable surface for subsequent coatings.

### PRACTICAL INFORMATION FOR RELEST WIND PROCESS COAT N BEIGE

<b>Colour</b>	Translucent
<b>Gloss Level</b>	Not applicable
<b>Volume Solids</b>	99%
<b>Typical Thickness</b>	250 microns (10 mils) dry equivalent to 253 microns (10.1 mils) wet
<b>Theoretical Coverage</b>	280 g/m <sup>2</sup> at 250 microns and stated volume solids; corresponds to approx. 3.54 m <sup>2</sup> /kg
<b>Practical Coverage</b>	Allow appropriate loss factors
<b>Density</b>	1.12 g/cm <sup>3</sup> (Mixed)
<b>Method of Application</b>	Roller

#### Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
40°C (104°F)	*	*	60 minutes	5 days

\* not applicable

### REGULATORY DATA

<b>Flash Point (Typical)</b>	Part A 99°C (210°F); Part B 99°C (210°F)		
<b>Product Weight</b>	1.12 kg/l (9.3 lb/gal)		
<b>VOC</b>	VOC (Base)	1.25 g/kg EU Solvent Emission Directive (Council Directive 2010/75/EU)	
	VOC (Hardener)	1.02 g/kg EU Solvent Emission Directive (Council Directive 2010/75/EU)	
	VOC (Mixed)	1.16 g/kg EU Solvent Emission Directive (Council Directive 2010/75/EU)	

See Product Characteristics section for further details

## Protective Coatings

# RELEST® Wind Process Coat N Beige International®

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### SURFACE PREPARATION

The rotor blade mould plus applied mould release agents should be clean, dry and free of dirt, dust, grease or other contamination.

The mould temperature should be between 40°C and 80°C (104°F - 176°F) prior to application of RELEST Wind Process Coat N Beige.

Where overcoating is not expected to take place within the overcoating interval, the RELEST Wind Process Coat N Beige surface should be protected from dust, dirt or other contamination.

### APPLICATION

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<b>Mixing</b>	<p>Thoroughly mix the Part A and Part B with a mechanical stirrer, avoiding aeration as much as possible. Transfer the mixture to another clean container and remove any residues remaining in the mixing vessel with a filling knife, adding to the mixture and stir again.</p> <p>Due to the short working pot life of this product, it is advised to mix small quantities to ensure maximum productivity.</p>						
<b>Mix Ratio</b>	<p>Using Part B RELEST Hardener PUR 3203 (I385-3203): 100 part(s) : 61 part(s) by volume 100 part(s) : 66 part(s) by weight</p> <p>Viscosity (base): 33000 mPas; thixotropic; rotational measurement</p>						
<b>Working Pot Life</b>	<table><tr><td>20°C (68°F)</td><td>23°C (73°F)</td><td>35°C (95°F)</td></tr><tr><td>10 minutes</td><td>8 minutes</td><td>5 minutes</td></tr></table> <ul style="list-style-type: none"><li>The figures quoted above have been determined at: 20°C / 30% RH   23°C / 65% RH   35°C / 85% RH</li></ul>	20°C (68°F)	23°C (73°F)	35°C (95°F)	10 minutes	8 minutes	5 minutes
20°C (68°F)	23°C (73°F)	35°C (95°F)					
10 minutes	8 minutes	5 minutes					
<b>Roller</b>	Recommended						
<b>Thinner</b>	DO NOT THIN						
<b>Work Stoppages</b>	Stoppages should be avoided due to the product's short pot life.						
<b>Clean Up</b>	<p>Clean all equipment immediately after use with RELEST Thinner PUR 132.</p> <p>All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.</p>						

# RELEST® Wind Process Coat International®

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#### PRODUCT CHARACTERISTICS

For recommendations regarding release agents and tested infusion resins please contact your local representative.

RELEST Wind Process Coat N Beige should be applied by roller to moulds which have been heated to a minimum of 40°C (104°F) and which have been coated with a suitable mould release agent. It is important that aeration of the product during application is avoided.

Application of RELEST Wind Process Coat N Beige after the pot life has elapsed is not recommended, as this may lead to air pockets, textural difference and cracking in the final film.

RELEST Wind Process Coat N Beige temporarily protects the composite from UV radiation.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

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#### SYSTEMS COMPATIBILITY

Please contact your local representative for further information.

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### ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at [www.international-pc.com](http://www.international-pc.com):

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

### SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult your local representative for further advice.

**Warning: Contains isocyanate.**

### PACK SIZE

Base Weight	Volume	Pack	Hardener Weight	Volume	Pack
10kg	9.29L	10L	6.6kg	5.96L	12L
200kg	185.79L	205L	220kg	189.64L	203L

### SHIPPING WEIGHT (TYPICAL)

Base Gross Weight	Hardener Gross Weight
11.4kg	7.54kg
220kg	241.6kg

### STORAGE

Shelf Life	18 months at 25°C (77°F) Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.
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### Important Note

*The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.*

*This Technical Data Sheet is available on our website at [www.international-marine.com](http://www.international-marine.com) or [www.international-pc.com](http://www.international-pc.com), and should be the same as this document. Should there be any*