

**Technical Data Sheet
RF-SERIES COLOR PASTE CONCENTRATES**

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**Resin Formulators
Technical Data Sheet
Epoxy Resin
RF-SERIES COLOR PASTE CONCENTRATES**

Description

RF-Series color paste dispersions are smooth, workable pastes comprised of the highest-quality pigments dispersed in a standard epoxy resin. They are 100 percent reactive. This virtually eliminates effects on physical properties and, together with high pigment concentrations, enables the user to achieve consistent coloration. Benefits include high pigment loading for excellent color control and economy of use.

Some of the features and benefits are:

Epoxy resin base	No plasticizers
High Color concentrate	Excellent color control
Fine grind for dispersion ease	Economy of use

RF-Series COLOR PASTE CONCENTRATES: Handling Properties, Typical

Property	RF-Series Concentrate
Colors	See Chart
Specific Gravity: @ 77°F (25°C)	1.25 - 1.90
Density, Lbs. per gallon	10.43 - 15.86
Viscosity, cps @ 77°F (25°C)	SemiThixotropic to Thixotropic Paste
Shelf Life	12 months

RF-Series COLOR PASTE CONCENTRATES

In the following table is a list of standard color paste concentrates.

RF 118	Dark Green	RF 135	Green
RF 119	Dark Blue	RF 136	Blue
RF 120	Dark Brown	RF 137	Violet
RF 130	BLACK	RF 138	Gray
RF 131	Brown	RF 139	WHITE
RF 132	Red	RF 140	Non Carbon Black
RF 133	Orange	RF 141	Candy Apple Red
RF 134	Yellow	RF 144	Olive Drab

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General Instructions for Use

In general, the pigments used for the various RF-Series color paste concentrates are a high specific gravity material; it will tend to settle over time. Mix the RF-Series color concentrate at least once during the day when the material is being used. If mixing is difficult, the color concentrate can be warmed slightly to 60°C (140°F). In addition, the epoxy resin incorporating the color concentrate can be warmed slightly also. **(CAUTION: Do not warm One-Component Epoxies as this may start an exothermic reaction)**

Weigh 1-10% by weight color paste concentrate per 100 parts epoxy resin according to the desired color strength and/or opacity needed. *NOTE: In general a 5% addition of the color concentrate to the epoxy resin is the accepted amount for most applications.* Mix thoroughly until the epoxy resin is uniform in color with no lumps and color striations. Add the appropriate curing agent at the proper mix ratio only after the color concentrate has been thoroughly mixed into the epoxy resin. Use a non-reactive container (polyethylene, polypropylene, or metal de-rimmed can) as a mixing container. Avoid paper cups unless they are polyethylene lined on the inside. If de-airing; container should be about five times larger than the volume of the mixed material. Mix components thoroughly, preferably with a metal spatula, scraping the sides and bottom of container to incorporate all material.

For bubble / entrapped air-free material; remove the air entrapped during mixing by placing the container of mixed material into a vacuum chamber. During the de-airing process, the level of mixed material will rise then drop with strong bubble breaking action. Do not allow the contents to rise over the top of the container. Allow the material to de-gas (de-air) for no more than 5 minutes. Release vacuum. If working time allows, transfer material to a clean container. ***NOTE: During transfer, do not scrape sides or bottom of the container used for mixing as this may still contain residual amounts of poorly mixed material and can leave a tacky surface or areas of uncured material in the part being cast.***

SAFETY INFORMATION: PROTECT THE EYES FROM EXPOSURE TO THIS PRODUCT.

RF-Series Color Concentrates contains an epoxy resin. The uncured resin may cause eye and skin irritation or allergic dermatitis. RF Curing Agents contains a polyamine or polyamide curing agent which can cause severe skin and eye burns. If heated, vapors may be irritating to the respiratory tract. In case of eye contact, flush with plenty of water for 15 minutes. Get medical attention immediately. Keep the material off the skin. In case of skin contamination, wash with a mild soap and water. Do not use solvents to remove curing agent from the skin. Wash before using the rest room, eating, or smoking. Read and follow the instructions in the material safety data sheets supplied with these materials.

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