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## ACOTHANE BRUSHING GRADE

### PRODUCT DESCRIPTION

A two pack solvent-free polyurethane coating material, designed for brush application to pipe girth welds to effect complete corrosion protection in water immersion, soil burial or atmospheric exposure limitations.

### USES

Rapid drying and curing characteristics, allowing early completion of coating to recommended film thickness.

### TECHNICAL PROPERTIES

<b>Colour</b>	Grey, Cream, Light Green		
<b>Finish</b>			
<b>Curing Agent</b>	Acothane Activator		
<b>Mix Ratio</b>	3 Base : 1 Activator by volume		
<b>Specific Gravity</b>			
<b>Volume Solids</b>	100%		
<b>Recommended Film Thickness</b>	1.0 - 1.5 mm depending on service conditions. (3 coats @ 1 mm)		
<b>Theoretical Spreading Rate</b>	3 m <sup>2</sup> /litre @ 330m		
<b>Application Method</b>	Brush		
<b>Flash Point</b>	200°C		
<b>VOC</b>	0 g/litre.		
<b>Drying Times</b>	<b>10°C</b>	<b>20°C</b>	<b>30°C</b>
Touch Dry		2 hours	
Hard Dry		12-16 hours	
Full Cure		14 days	
Minimum Overcoat		2 hours	
Maximum Overcoat		24 hours	

*At lower temperatures, curing rate will be slower.*

### CERTIFICATION/APPROVALS

### RECOMMENDED SYSTEMS

### SURFACE PREPARATION

**Steel:** Ensure surfaces are clean, dry and free from oil, grease, salts and other contaminants. Grit blast to minimum BS 7079 standard SA 2 ½, to give a recommended surface profile depth of 75 - 100 microns.

## PRODUCT APPLICATION

<b>Mixing</b>	Activator must be added to base and thoroughly mixed ensuring an even mix throughout the 'pot'. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating on walls has cured. Pot life - approx. 25-30 minutes @25°C.
<b>Thinners</b>	Do not thin.
<b>Brush</b>	After mixing use immediately.
<b>Roller</b>	
<b>Conventional Spray</b>	
<b>Airless Spray</b>	
<b>Air Assisted Airless Spray</b>	
<b>Cleaner</b>	Thinner No.4
<b>Cleanup Considerations</b>	All equipment should be cleaned immediately after use with Thinner No.4 It is advisable that equipment should be cleaned/flushed during the course of application, the frequency of which will depend on the volume of material used and timescale over which applied. Ensure all waste materials (including packaging) are disposed of in accordance with local regulations.

## HEALTH, SAFETY & ENVIRONMENTAL

This product must be used in accordance with the Material Safety Data Sheet supplied by Spencer Coatings Limited.  
The user must observe local health, safety and environmental regulations when using this product.  
Consult Spencer Coatings Limited if there are any concerns over the suitability of this product.

## PACK SIZES

1 litre

## PACK WEIGHTS

## STORAGE CONDITIONS

Shelf life: 12 months

## LIMITATIONS

Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be done only when the temperature of the steel surface is at least 3°C (5°F) higher than the dew point. Application at temperatures below 1°C (33°F) must be watched carefully since the possible presence of ice in the pores of the surface could result in poor adhesion and reduced corrosion protection.

**Temperature:** At Application : Preferably above 0°C - surfaces free from ice/condensation  
In Service : Immersion 0 to 70°C depending on solution  
Dry -20 to 120°C continuous

<u>TEST</u>	<u>SPECIFICATION</u>	<u>RESULT</u>
Bond Strength	DIN 53232 (Primed and unprimed steel)	15 N/mm <sup>2</sup>
	DIN 53151 (Cross cut)	Glass G1
Water Vapour Permeability	DIN 52615	0.005 metric/perm. cm
Shrinkage	-	Negligible
Impact	ASTM 2794 – 69/14	20 N.M.
Tensile Strength	DIN 53504-13	20 N/mm <sup>2</sup>
Elongation	ASTM D2370	20-35%
Abrasion Resistance	ASTM 4060, CS17, 1 kg. load, 1000 cycles	<100 mg. loss
Shore Hardness	-	'D' 80 approx.
Flexibility	British Gas PS/CW6	Pass 2% strain at 5°C
Cathodic Disbonding	British Gas GBE/CW6 (28 days @ 20°C) 1500 mv (calomel) 1.5 mm DFT Thickness	Pass

## **DISCLAIMER**

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It is the user's responsibility to ensure that this sheet is current prior to using the product.