

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

Colour	Grey, Cream, Light Green		
Finish			
Curing Agent	Acothane Activator		
Mix Ratio	3 Base : 1 Activator by volume		
Specific Gravity			
Volume Solids	100%		
Recommended Film Thickness	1.0 - 1.5 mm depending on service conditions. (3 coats @ 1 mm)		
Theoretical Spreading Rate	3 m ² /litre @ 330m		
Application Method	Brush		
Flash Point	200°C		
VOC	0 g/litre.		
Drying Times	10°C	20°C	30°C
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

BS6920: Part 1: 2000 "Specification" – Complying with the requirements for Water Regulations Advisory Scheme tests on water quality and is suitable for use with cold water

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

Mixing	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.
Thinners	Do not thin.
Brush	After mixing use immediately.
Roller	
Conventional Spray	
Airless Spray	
Air Assisted Airless Spray	
Cleaner	Thinner No.4
Cleanup Considerations	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 ²
	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 ²
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

The information given in these specifications and technical advice - whether verbal, or in writing or by way of trials is for guidance only and is given in good faith, but without warranty. This also applies where proprietary rights or third parties are involved. Any person using Spencer products without first making further enquiries as to the suitability of the products for the intended purpose and testing the products to assess their fitness for the purpose does so at their own risk. The application, use and processing of the products are beyond our control and are therefore your own responsibility, and we can accept no liability for the performance of the products arising out of such use, beyond the value of the goods delivered by us. The information contained in these data sheets 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 ensure that this sheet is current prior to using the product.