

ACOTHANE SPRAY GRADE

PRODUCT DESCRIPTION

High build solvent-free two pack polyurethane with outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance.

USES

Protection of steel and concrete structures in aggressive environments e.g. internal and external protection of pipelines, offshore splash zones, bridge protection, chemical plants.

TECHNICAL PROPERTIES

Colour	Cream, Grey, restricted additional colours		
Finish			
Curing Agent	Acothane Activator		
Mix Ratio	3 Base : 1 Activator by volume		
Specific Gravity	Base: 1.31 Activator: 1.22 Mixed: 1.29		
Volume Solids	100%		
Recommended Film Thickness	Can be applied at 0.5 mm – 5.0 mm in one continuous wet on wet application, specified thickness is dependent upon service conditions		
Theoretical Spreading Rate	1 m ² /litre @ 1 mm		
Application Method	Plural component hot airless spray		
Flash Point	200°C		
VOC	0 g/litre		
Drying Times	10°C	20°C	30°C
Touch Dry		30-45 mins.	
Hard Dry		4 hours	
Stackable		8 hours	
Full Cure		14 days	

At lower temperatures, curing rate will be slower.

CERTIFICATION/APPROVALS

Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection
 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
 WRAS Water Fittings Directory Reference 0712527
 Meets the performance requirements of BS EN 10290

RECOMMENDED SYSTEMS

Steel: Direct to prepared surface
 Concrete: Seal with Acothane LV Sealer

SURFACE PREPARATION

- Steel:** Ensure surfaces are free from grease, oil salts etc. Grit blast to minimum BS 7079 standard SA 2 ½ - surface profile depth 75-100 microns.
Mechanical tools may also be used providing a surface profile of minimum 75 microns can be achieved. **Do not polish the steel surface.**
Acothane is a surface tolerant coating and will accommodate a degree of surface blooming and flash rusting.
Contact Spencer Coatings Technical Department if clarification is required.
- Concrete:** Remove all laitance and other contaminants by most appropriate method e.g. blast cleaning. Ensure the concrete is dry to a reading of less than 16% on the Wood Moisture Equivalent (WME) scale of the Protimeter Surveymaster SM Moisture Meter or similar instrument. Seal with LV Sealer.

PRODUCT APPLICATION

- Mixing** 3 : 1 by volume. Pot life 5 mins. @ 20°C.
- Thinners** Do not thin.
- Brush**
- Roller**
- Conventional Spray**
- Airless Spray** Approved twin component hot airless spray machine
- 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

Supplied in full 20 litre and 200 litre drums of Base and Activator at a ratio of 3:1, giving 80 litres and 800 litres respectively.

PACK WEIGHTS

20lt Base: 28.0kg 200lt Base: 282.0kg
20lt Activator: 26.2kg 200lt Activator: 264.0kg

STORAGE CONDITIONS

Shelf life: 12 months when stored in original sealed containers at temperatures between 5°C and 30°C.

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°C to 70°C depending on solution
Dry -20°C to 120°C continuous

TEST DATA

<u>TEST</u>	<u>SPECIFICATION</u>	<u>RESULT</u>
Bond Strength	DIN 53232 (Primed and Unprimed Steel) DIN 53151 (Cross cut)	150 kg/cm ² 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	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 GBE/CW6	Pass 2% strain @ 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.