

ACOTHANE TWIN PACK

PRODUCT DESCRIPTION

Solvent-free two component urethane mastic packaged in a polythene bag divided by a plastic clip and sealed in an aluminium foil pack for the repair of small defects in pipeline coatings.

USES

Outstanding mechanical properties and rapid cure characteristics together with excellent adhesion to most pipe coating materials.

TECHNICAL PROPERTIES

Colour	Available in a limited colour range							
Finish								
Curing Agent								
Mix Ratio	3 : 1 by volume							
Specific Gravity								
Volume Solids	100%							
Recommended Film Thickness								
Theoretical Spreading Rate	190 cm ² @ 1 mm. thickness (25 g. twin pack) 30 in ² @ 40 mil thickness							
Application Method	Spread mixed material over prepared surface using a spatula							
Flash Point	Above 200°C (390°F)							
VOC	0 g/litre.							
Approx. Drying Times	5°C	10°C	20°C	30°C	40°C	50°C	60°C	70°C
	(41°F)	(50°F)	(68°F)	(86°F)	(104°F)	(122°F)	(140°F)	(158°F)
Touch Dry								
Hard Dry	6 hrs	4.5 hrs	90 mins.	35 mins.	25 mins.	15 mins.	10 mins.	6 mins.
Minimum Overcoat								
Maximum Overcoat								

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

SURFACE PREPARATION

Remove any surface contamination such as oil, grease and dirt by detergent washing, followed by fresh water rinse and drying. Remove all corrosion products from exposed metal by spot abrasive blast cleaning, angle grinder or hand abrading. Chamfer edges of repair area and thoroughly abrade onto sound coating.

PRODUCT APPLICATION

Mixing

Remove outer foil wrapper. Remove plastic clip. Mix the contents of the pack by working the components in the plastic bag together. Remove corner of bag and dispense. See Acothane Twin Pack mixing instructions.

Thinners

Brush

Roller

Use plastic divider or spatula as an applicator.

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

PACK WEIGHTS

10g. and 25g.

STORAGE CONDITIONS

Shelf life: 12 months

LIMITATIONS

<u>TEST</u>	<u>SPECIFICATION</u>	<u>RESULT</u>
Bond Strength	ASTM D4541 (Grit Blasted Steel)	15 N/mm ² (2175 psi)
Cathodic Disbondment	28 days @ 20°C (68°F) – 1500 mV calomel electrode 1.5 mm (60 mil thickness)	< 5 mm.
Elongation	ASTM D2370	20-35%
Abrasion Resistance	ASTM 4060, CS17, 1 kg. load, 1000 cycles	< 100 mg. loss
Flexibility	2% strain at 5°C (41°F)	Pass
Impact	ASTM 2794 – 69/14	10 N.M.(7.08 lb/ft)
Shore Hardness	-	‘D’ 80 approx.
Shrinkage	-	Negligible

DISCLAIMER

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