

ACOTHANE TU SPRAY GRADE (LT) TX

PRODUCT DESCRIPTION

Highly thixotropic solvent-free rapid cure two pack tar modified urethane, with outstanding physical properties in terms of flexural strength, tensile strength, impact, abrasion and penetration resistance etc.

USES

Pipeline rehabilitation and field joint coating using line-travel and automatic girth weld coating equipment where increased anti-sag properties are required due to film build requirements or high substrate temperatures.

TECHNICAL PROPERTIES

Colour	Black		
Finish			
Curing Agent	Acothane Activator		
Mix Ratio	4 : 1 by volume		
Specific Gravity			
Volume Solids	100%		
Recommended Film Thickness	1.0-2.5 mm depending on service requirements. Can be applied at 0.5 –5.0 mm.in one continuous wet on wet application.		
Theoretical Spreading Rate	1 m ² /litre @ 1mm thickness. Suggested practical : 0.75 m ² /litre/1 mm thickness (will vary depending upon complexity of the structure being coated and nature of the substrate)		
Application Method	Approved twin component hot airless spray machine		
Flash Point	200°C		
VOC	0 g/litre.		
Drying Times	10°C	20°C	30°C
Touch Dry		5-10 mins.	
Hard Dry		4-5 hours	
Minimum Overcoat		2 mins.	
Maximum Overcoat		24 hours	
Ultimate cure 14 days @ 25°C.			
At low temperature cure rate will be slower.(re-coatable without surface preparation on uncontaminated coating)			

CERTIFICATION/APPROVALS

RECOMMENDED SYSTEMS

SURFACE PREPARATION

- Steel:** Ensure surfaces are clean, dry and free from contaminants. Grit blast to BS 7079 standard SA 2 ½ to an amplitude of 50 – 100 microns. Coating application should proceed before the occurrence of visible deterioration of the prepared surface.
- 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 U-Coat 501 and re-coat in accordance with data sheet U8.

PRODUCT APPLICATION

- Mixing** Pot life 55-65 secs. @ 60°C (120 g. mass)
- Thinners**
- Brush**
- Roller**
- Conventional Spray**
- Airless Spray** Approved twin component hot airless spray machine
- Air Assisted Airless Spray**
- Cleaner** Thinner No.4 is a recommended cleaning/purging fluid, where flash point of 23°C can be tolerated. DOP may be used as purge fluid when spraying if high flash point material is necessary. Flash point 208°C.
- 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

STORAGE CONDITIONS

12 months unopened in moderate, dry storage conditions.

LIMITATIONS

Pot life 55-65 secs. @ 60°C (120 g. mass)

Note: Due to short pot life, this material should only be applied using specially designed equipment capable of instant purging.

Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above dew point. Application at temperatures below 1°C (33°F) must be carefully monitored since the possible presence of ice on the surface (or in the pores in the case of concrete) will result in poor performance.

Temperature: At Application: Preferably 0°C ambient
 In Service: Immersion 0 to 80°C depending on solution
 Dry -20 to 110°C continuous

This material contains coal tar pitch products and is not designed for use on applications in direct contact with foodstuffs, drugs or potable water.

<u>TEST</u>	<u>SPECIFICATION</u>	<u>RESULT</u>
Bond Strength	ISO 4624(Grit Blasted Steel)	>10 Mpa @ 23°C
Water Vapour Permeability	DIN 52615	0.005 metric/perm.cm.
Shrinkage	-	Negligible
Impact	ASTM 2794 – 69/14	10 N.M.
Tensile Strength	DIN 53504	10-13 N/mm ²
Elongation	ASTM D2370	20-35%
Shore Hardness	-	'D' 65-70 approx.
Penetration	DIN 30671	Under 30%
Flexibility	British Gas PS/CW6	Pass 2% strain at 5°C
Cathodic Disbonding	(i) DIN 30671 (30 days @ 23°C) 1 mm thickness (ii) DIN 30671 (2 days @ 65°C) 1 mm Thickness (iii) British Gas PS/CW6 (28 days @ 20°C) 1.5 mm Thickness	Pass Pass 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.