ACRATON® OT

epoxy

A two components substrate tolerant high solid epoxyprimer/coating, pigmented with zincphosphate and aluminium.

- Especially developed for substrates which cannot of may not be blasted.
- Strong penetration in the still present rust layer.
- Apply in thick layers.
- Application and hardening is possible at relatively high humidity up to 90%.
- Good elasticity and mechanical resistance.

Application as primer and/or coating on steel constructions when maintaining, which cannot be blasted.

- Even after long lasting outdoor exposure can it be recoated with two components and physically drying coatingsystems.
- When exposed direct to sunlight, coating will chalk.

Product information

Finish	Semi-gloss
Colour	Limited numbers of aluminium-colours.
Mass density	approx. 1.45 kg/L (mixed product)
Solids content by volume	ca. 75 volume % (mixed product)
VOC	approx. 215 gr./L (volatile organic compound)
Recommended film thickness	100-200 µm d.f.t. per layer 135-270 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 100 µm d.f.t. 7.5 m²/L
Practical spreading rate	Depending on several factors like shape of object, profile of surface, method of application, application circumstances and experience. A few guiding principles are: Brush/roller 85-90% of the theoretical spreading rate Spraying 50-70% of the theoretical spreading rate
Flashpoint ISO 1523	Base 35°C Hardener 2V41 29°C Thinner FGM 631 26°C Thinner WTD 107 14°C
Dry temperature resistance	120°C
Durability	At least 12 months, provided that it has been stored in closed original packing at a dry and cool spot.

Drying times

For d.f.t. up to 200 µm

	30°C	20°C	10°C
Dust dry	1½ hour	3 hours	4 hours
Transportable	10 hours	24 hours	48 hours
Complete hardening	5 days	8 days	14 days
Recoatable:			
Minimum interval	8 hours	10 hours	24 hours
Maximum interval*	5 days	10 days	1 month

* This period can be extended by cleaning and sanding the coating prior to application of the next layer.

Film thickness, ventilation, temperature and relative humidity are of great influence on the drying times.

Application instructions

Mixing ratio	Volume:	Base – hardener 2V41	80:20
	Weight:	Base – hardener 2V41	87:13

Mixing instructions

Base and hardener should be mixed and applied at temperatures above 10°C.
At lower temperatures extra thinner is needed, which gives a slighter resistance against sagging and which will delay hardening.
The components should be mixed homogeneously,
with a mechanical blender. Pay attention to the side and bottom of the can.

Induction time

At 20°C not necessary
At 10°C at least 15 minutes

Pot life after mixing

20 litre packing:
approx. 3 hours at 10°C
approx. 2 hours at 20°C
approx. 1 hour at 30°C

Optimal application circumstances

During application and curing the temperature should be above 5°C.

During application and hardening in closed and small spaces,
it is necessary to refresh the air continually to remove the solvent vapours,
this because of curing, health and safety.

Usage information

	Airless-spray	Airspray	Brush/roller
Type of thinner	FGM 631 / WTD 107	FGM 631 / WTD 107	FGM 631 / WTD 107
Recommended thinner (depending on application and equipment)	0 – 5 vol. %	5 – 10 vol. %	0 – 5 vol. %
Nozzle orifice	0.48 – 0.53 mm 0.019 – 0.021 inch	2,0 – 2.5 mm	
Nozzle pressure	170 – 200 bar	3 – 4 bar	
Maximum attainable d.f.t.	250 µm	200 µm	100 µm
Cleaning of tools	Thinner FGM 631 / WTD 107		

Surface conditions

Steel

Maintenance:
Clean the surface thoroughly with a suitable cleaning preparation
or by steam cleaning.

Remove salts and other water-soluble impurity by spraying
with clean tap-water under high pressure.

Remove rust a.o. by (water)blasting Sa 2½ or derust mechanical until St. 2-3.
Apply the recommended paint system on a clean surface.

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Product Characteristics

No coating work shall be carried out when the temperature of the surface is less than 3°C above dewpoint and when the substrate temperature is below 5°C.

Due to the presence of solvents, applying this product in confined spaces, adequate ventilation has to be ensured.

At low temperature and under humid conditions, amine blushing can occur, which can effect the intercoat adhesion negatively. Prior to the application of the next layer, the previous layer must be checked for this phenomena.

Discoloration or loss of gloss or other surface defects, can occur during drying and curing by condensation and or early water spotting. In particular bright and ''full'' colours.

This coating product is based on epoxy technology. It is recommendable that it should be overcoated with a durable finish.

Maximum film build in one coat is best attained by airless spray. Application by other techniques, it may be necessary to apply multiple coats in order to achieve the total specified dry film thickness.

Safety description

See safety data sheet

Ventilation rules

Minimum required quantity of air to comply with:

	MAC	10 % LEL
Acraton OT	1300 m³/L	50 m³/L
Thinner FGM 631	3995 m³/L	160 m³/L
Thinner WTD 107	4085 m³/L	168 m³/L

MAC = Maximum Accepted Concentration
LEL = Lower Explosion Limit
Also consult the safety information sheets

Pretreatment / Labeling / Technical Terms (downloadable from www.zandleven.com)

A 1 Labeling of paint products in the European Community
A 2 Physical data
A 4 General guidelines for steelpreservation
A 5 General guidelines for the application of Acraton plastics
A 6 Pretreatment of construction steel