

zandleven coatings

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℃

Hardener 2V41 $29 \,^{\circ}$ CThinner FGM 631 $26 \,^{\circ}$ CThinner WTD 107 $14 \,^{\circ}$ C

Dry temperature resistance 120 ℃

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 Dust dry Transportable Complete hardening Recoatable: Minimum interval Maximum interval*

30℃	20℃	10℃
1½ hour	3 hours	4 hours
10 hours	24 hours	48 hours
5 days	8 days	14 days
8 hours 5 days	10 hours 10 days	24 hours 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 ℃.

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 ℃

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 ℃.

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

Type of thinner
Recommended thinner
(depending on application
and equipment)
Nozzle orifice

Nozzle pressure Maximum attainable d.f.t.

Cleaning of tools

Airless-spray	Airspray	Brush/roller
FGM 631 / WTD 107	FGM 631 / WTD 107	FGM 631 / WTD 107
0 – 5 vol. %	5 – 10 vol. %	0 – 5 vol. %

0.48 – 0.53 mm	2,0 – 2.5 mm			
0.019 - 0.021 inch				
170 – 200 bar	3 – 4 bar			
250 μm	200 μm	100 μm		
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 ℃ 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 m ³ /L		
Thinner FGM 631	3995 m³/L	160 m ³ /L		
Thinner WTD 107	4085 m³/L	168 m³/L		

MAC = Maximum Accepted Concentration

LEL = Lower Explosion Limit

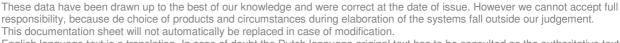
Also consult the safety information sheets

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









English language text is a translation. In case of doubt the Dutch language original text has to be consulted as the authoritative text.

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