ACRATON® GLASSCOAT epoxy

A two component, high solid, glass flake reinforced epoxy coating

- Applicable for C4 t/m C5 – IM3 according ISO 12944.
- Excellent barrier properties
- chemical resistant against a wide range of chemicals
- excellent abrasion resistant
- in particular applicable under severe circumstances like splash zone etc

Application: in aggressive industrial and marine environment

- When exposed to sunlight, the coating will chalk

Product information

Finish	Semi-gloss
Colour	Redbrown, grey
Mass density	approx. 1.34 kg/L (mixed product)
Solids content by volume	approx. 90 volume % (mixed product)
VOC	approx. 122 gr./L (volatile organic compound)
Recommended film thickness	150-250 µm d.f.t. per layer 165-275 µm w.f.t. per layer (undiluted)
Theoretical spreading rate	At 200 µm d.f.t. 4.5 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 45 °C Hardener 2V9 >70 °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/curing properties at substrate temperature:

For d.f.t. up to 200 µm	30 °C	20 °C	10 °C
Dust dry	3 hours	4 hours	8 hours
Transportable	12 hours	24 hours	24 hours
Fully cured	2 days	3 days	5 days
Recoatable:			
Minimum interval	10 hour	12 hours	24 hours
Maximum interval *	3 days	5 days	7 days

*) This period can be extended by sanding the surface thoroughly

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

Application instructions

Mixing ratio	Volume:	Base – hardener 2V9	75:25
	Weight:	Base – hardener 2V9	83:17
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.		
Induction time	At 20°C not necessary At 10°C at least 10 minutes		
Pot life after mixing	20 litre packing:	appr. 90 min. at 10°C appr. 45 min. at 20°C	
Optimal application circumstances	Temperature : 15 – 25°C Humidity : 40 – 75%		

Technical and esthetical properties can change when the product has been applied under different conditions.

Usage information

	Airless-spray	Brush/roller
Type of thinner	FGM 631 / WTD 107	FGM 631 / WTD 107
Recommended thinner (depending on application and equipment)	0 – 5 vol. %	0 – 10 vol. %
Nozzle orifice	0.48 – 0.59 mm 0.019 – 0.024 inch	
Nozzle pressure	200 – 220 bar	
Maximum attainable d.f.t.	250 µm	200 µm
Cleaning of tools	Thinner FGM 631 / WTD 107	

Surface conditions

Obtaining the highest possible quality of the applied product it is very important that the substrate is prepared carefully and correctly. The required surface roughness and a dry and clean substrate are the main parameters. Prior to application of the paint , the substrate must be examined according to the ISO standard 8504:2000.

Steel	Initial: Abrasive blasting according to ISO standard 8501-1:1988 Sa 2½. Roughness profile Ra 10-12 µm Rz 50-60 µm. Surface should be clean and dry. Repair and 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 mechanically until St. 2-3. Apply the recommended paint system on a clean surface. ▪ Mechanical or hand derusting gives less quality than (water)blasting and will result in less protection of the applied paint system.
Concrete	Sweep blasting in order to remove previous coating and Or by etching according suppliers instructions. Wash the substrate with water. Crack etc should be filled with a suitable filler.

ACRATON® GLASSCOAT epoxy

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℃.

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 information

See safety data sheet

Ventilation precaution

Minimum required quantity of air to comply with:		
	MAC	10 % LEL
Acraton Glasscote	500 m³/L	20 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 data sheets

Pretreatment / Labelling / 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