# ACRATON® WV-HB COATING epoxy

A two components waterborne high build epoxy coating pigmented with titanium white and inert extenders.
- After hardening excellent mechanical resistance.
- Resistant against water, polluted water, seawater, alkaline and weak acid solutions, mineral oil, aliphatic and aromatic solvents.

**Application** can be used as intermediate and/or finish layer for coating systems on steel and concrete in industrial and nuclear environment.
- No VOC, extremely suitable when solvents are not allowed because of health or safety regulations. When exposed direct to sunlight, coating will chalk.

## Product information

| | |
|---|---|
| Finish | Semi-gloss |
| Colour | Limited number of colours |
| Mass density | approx. 1.28 kg/L (mixed product) |
| Solid content | appox. 44% by volume (mixed product) |
| Recommended film thickness | 60 – 80 µm d.f.t. per layer |
| | 136 – 182 µm w.f.t. per layer (undiluted) |
| Theoretical spreading rate | At 80 µm d.f.t. 5.5 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 over 70°C |
| | Hardener 2V38 over 70°C |
| Dry temperature resistance | 120°C |
| Durability | At least 3 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 80 µm | **30°C** | **20°C** | **10°C** |
|---|---|---|---|
| Dust dry | ½ hour | 1 hour | 4 hours |
| Transportable | 8 hours | 16 hours | 48 hours |
| Complete hardening | 5 days | 8 days | 30 days |
| Recoatable: | | | |
| Minimum interval | 6 hours | 12 hours | 24 hours |
| Maximum interval* | 7 days | 14 days | 1 month |

*) This period can be extended by sanding and cleaning the surface.

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

## Application instructions

| | | |
|---|---|---|
| Mixing ratio | Volume: Base – hardener 2V38 | 75:25 |
| | Weight: Base - hardener 2V38 | 80:20 |
| Mixing instructions | Base and hardener should be mixed thoroughly and applied at a temperature over 10°C.<br>At a lower temperature, extra water is needed which gives a slighter resistance against sagging and which will delay hardening. | |
| Induction time | At 20°C: not necessary<br>At 10°C: at least 15 minutes | |
| Pot life after mixing | 20 litre packing: | Approx. 5 hours at 10°C<br>Approx. 3 hours at 20°C<br>Approx. 1 hour at 30°C |
| Application conditions | Do not apply at a temperature lower than 12 – 15°C<br>The surface should remain free from water and ice and the surface temperature should be at least be 3°C over dew point.<br>The relative humidity should be max 75% during application and drying. | |

## Usage information

| | Airless-spray | Airspray | Brush/roller |
|---|---|---|---|
| Type of thinner | water | water | water |
| Recommended thinner (depending on application and equipment) | 0-5 vol% | 0-5 vol% | 0-5 vol% |
| Nozzle orifice | 0.43-0.48 mm<br>0.017-0.019 inch | 1.5-2.5 mm | |
| Nozzle pressure | 150 – 180 bar | 3 – 5 bar | |
| Max. attainable d.f.t. | 80 µm | 60 µm | 60 µm |

Cleaning of tools: water andrins again with FGM 631

## Surface conditions

Steel

New steel:
Acraton WV-ZF primer, Monopox SF-HB, Monopox Micro zink, Monopox ZF-Universal of Monopox Metalcoat ZL 70

Repair and maintenance:
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 advised 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.

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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.

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 WV-HB Coating | 37 m3/L | 3 m3/L |

MAC = Maximum Acceptable Concentration
LEL = Lower Explosion Limit
Also consult the safety data 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 3 Persistencylist for Monopox HB systems
A 4 General guidelines for steelpreservation
A 5 General guidelines for the application of Acraton plastics
A 6 Pretreatment of construction steel