

APCOTHANE 150

PRODUCT DESCRIPTION

Two components, high build, high solid, zinc phosphate based acrylic aliphatic polyurethane direct to metal coating

FEATURES AND RECOMMENDED USE

- Self-priming; eliminates the usage of primer
- Suitable as a touch up coat in projects for weld seams and damaged coating
- Good corrosion resistance and chemical resistance
- Excellent resistance to atmospheric exposure conditions, extended outdoor durability
- Good resistance to saline atmosphere from C1 to C4 environment Gives tough, abrasion resistant finish on curing with good gloss retention

TECHNICAL DATA

Colour	Range
Gloss	Semi-glossy
Volume Solids	68 ± 2%
Recommended DFT / Coat	75 - 150 µm
Theoretical Coverage Capacity	9.1 sq.mtr/l @ 75 µm 4.5 sq.mtr/l @ 150 µm
Drying Time at 30°C	Surface dry : 1 hour Dry to handle : 5 hours Hard dry : 8 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 5 hours Max. : Unlimited, provided surface is cleaned from all contamination
Method of Application	Air spray and Airless spray, Brush only for touch up

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, Colour and testing variances
The actual drying time/ overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc.
The information provided above is at 30° C and 65% relative humidity.

DIRECTIONS FOR USE

Surface Preparation

General:

- Surfaces must be dry, clean and free from contaminants
- Ensure removal of dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning
- Surface should be checked and treated in accordance with ISO 8504 prior to priming

General:

- Steel, abrasive blast clean to min. Sa 2.5 as per Swedish Standard. In case oxidation has occurred between blasting and application of Apcothane 150, the surface should be re-blasted
- A blasting profile of (Rz) 50-60 microns is recommended

A. Steel

For atmospheric exposure condition

New hot-rolled steel; blast cleaned to min Sa 2.5 of Swedish standard. Existing sound epoxy coating system (if any) should be sufficiently roughened, dried, and cleaned. High pressure, fresh water washing or scrubbing to remove loose paint and contamination. Intact areas to be roughened. Damaged and rusty areas to be de-rusted to minimum St3/St2 by power tool / hand tool cleaning.

Application Conditions

- Substrate temperature should be at least 3°C above dew point but not above 50°C
- Relative humidity should be below 85%
- Good ventilation is required in confined areas to ensure proper curing

Mixing

- Apcothane 150 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture
- Thinner should be added after mixing the components and post the induction time. Addition of too much thinner will lead to reduced sag resistance

Mixing Ratio (by volume)	Base : Hardener 10 : 1
Induction Time	15 minutes
Pot Life at 30°C	90 minutes

Application

Air Spray Recommended thinner Volume of thinner Nozzle Orifice Nozzle Pressure	T 131 10 - 25% 1.5 - 3.00 mm 0.3- 0.4 MPa (= approx 3-4 atm; 43-57 p.s.i.)
Airless Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure	T 131 10 - 25% 0.53 - 0.68 mm (21 -27 thou) 20 -24 MPa (= approx. 200-240 atm; 2800 -3400 p.s.i)
Brush / Roller (only for touch up) Recommended thinner Volume of thinner	T 131 0 - 5% depending on atmospheric conditions

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment immediately after use with Thinner T 131. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap
- All surplus material and empty containers should be disposed of in accordance with appropriate regional legislation

Product Characteristics

- The sheen and finish are dependent on the application method. The best finish is achieved by conventional spray application.
- Maximum film build-up is best achieved by airless spray. Application by air spray or brush may require multiple coats to attend maximum film built.
- Minimum 75 microns per coat is recommended for proper hiding by spray application.
- Brush application will leave brush marks with limited flow and levelling of the film. The gloss, sheen and finish would depend on the surface and application method.
- Apcothane 150 must be thinned with the recommended thinner only. Usage of alternate thinners will affect the drying and curing process.
- Premature exposure to condensation and rain may cause change in color and gloss.
- This product is not recommended for use in immersion condition. Extended exposure to strong chemicals and spillage is also not recommended.

Overcoating

- Apcothane 150 can be top coated on most epoxy and polyurethane primers/ undercoats as recommended by Asian Paints PPG representative. Apcothane 150 can be top-coated with itself.
- When overcoating after weathering or ageing, ensure the surface is free from all contaminations before application of Apcothane 150. Adhesion on such aged surface largely depend on the extent of secondary surface preparation.

PACK SIZE	20 L
STORAGE	Shelf Life: At least 12 months @ 30°C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash Point: Base - Not less than 24°C Hardener - Not less than 24°C VOC: 287±10 gm/ltr (depending on shades) as per USA-EPA Method 24 Product Weight: 1.33 ± 0.04 kg/ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.
- Please refer our Material Safety Data Sheet prior to using the product.

Disclaimer: To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new data-sheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

'APCOTHANE' is Trademark of Asian Paints Ltd | Licensed user: Asian Paints PPG Pvt. Ltd.

Head Office: Asian Paints PPG Private Limited, Plot No-5, Gaiwadi Industrial Estate, S.V. Road, Goregaon (W), Mumbai 400 062. Tel No: 022-62182700, CIN: U24110MH2011PTC220557, Email: customer-care.apppg@asianpaintsppg.com, Website: www.asianpaintsppg.com