# **APCOTHANE CF 675**

**Polyurethane** 



# PRODUCT DESCRIPTION

Two component, aliphatic polyurethane coating

# FEATURES AND RECOMMENDED USE

- Designed as a finish coat in epoxy/ polyurethane systems
- Good resistance to atmospheric exposure
- Good gloss and colour retention
- Good mechanical properties
- Good aged recoatability
- Easy application by brush and spray

# TECHNICAL DATA

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|---|--|
| Colour  | Range  |
| Gloss   | Glossy   |
| Volume Solids   | Approx. 45%  |
| Recommended DFT / Coat  | 25 - 35 microns  |
| Theoretical Covering Capacity   | 18.0 sq.mtr/ ltr @ 25 microns<br>12.9 sq.mtr/ ltr @ 35 microns                       |
| Drying Time at 30°C   | Surface dry : 1 hour<br>Hard dry : 16 hour<br>Full cure : 7 days                     |
| Overcoating interval at 30°C  | Min. : 16 hours Max. : Unlimited, provided surface is cleaned from all contamination |

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.

# DIRECTION FOR USE

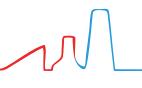
# **Surface Preparation**

# 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

# **Primed Surfaces**

- Suitable epoxy primer, epoxy/polyurethane undercoat; dry & free from all surface contamination. Apcothane CF 675 must be applied with the specified over-coating interval of the primer/ under-coat.
- In case of aged epoxy coating, the surface should be clean & sufficiently roughened prior to painting



# **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 CF 675 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 excessive thinner will lead to reduced sag resistance.

| Mixing Ratio<br>(by volume) | Base : Hardener<br>14 : 1 |
|-----------------------------|---------------------------|
| Induction Time              | 15 minutes                |
| Pot Life at 30°C            | 2 hour                    |

# Application

| Air Spray Recommended thinner Volume of thinner Nozzle Orifice Nozzle Pressure     | T 213<br>5 - 15 %<br>1.5 - 3.00 mm<br>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 213<br>0 - 10 %<br>0.28 - 0.33 mm ( 11 – 13 Thou)<br>10 -13 MPa (= approx. 100-130 atm; 1400-1800 p.s.i) |
| Brush / Roller<br>Recommended thinner<br>Volume of thinner                         | T 213<br>0 - 5 %   |

# Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T 213. 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 off in accordance with appropriate regional legislation.

# **Product Characteristics**

- The gloss, sheen and finish are dependent on the application method. The best gloss and finish is achieved by conventional spray application.
- Minimum 2 coat application is recommended to provide adequate hiding and uniformity specially when applied by brush
- Apcothane CF 675 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 of strong chemicals, solvents,

- Apcothane CF 675 can be top coated on most epoxy and polyurethane primers/ undercoats as recommended by Asian Paints PPG representative. Apcothane CF 675 can be top-coated with itself.

  When overcoating after weathering or ageing, ensure the surface is free from "Apcothane CF 675. Adhesion on such accedance of the surface is free from the surfa

| PACK SIZE                 | 20 ltrs (Base : 18.67 ltrs & Hardener : 1.33 ltrs)   |
|---------------------------|--|
| STORAGE                   | Shelf Life: Atleast 12 months @ 30°Cfor original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations                              |
| REGULATORY<br>INFORMATION | Flash Point: Base: Not less than 24°C, Hardener: Not less than 24°C  VOC: 470 ± 25 gm/ ltr (depending on shades)as per USA-EPA Method 24  Product Weight: 1.08 ± 0.1 kg/ ltr (depending on shades) |

# SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapors 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.

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