

APCOTHANE CF 672 HS

Polyurethane

PRODUCT DESCRIPTION

Two component high solid, low VOC acrylic aliphatic glossy polyurethane coating

FEATURES AND RECOMMENDED USE

- Designed as a finish coat in epoxy/ polyurethane systems
- VOC compliance and high solids
- Excellent resistance to atmospheric exposure conditions
- Good resistance to water and saline atmosphere
- Provides tough, abrasion resistant finish with excellent colour & gloss retention

TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 75%
Recommended DFT / Coat	75 - 100 microns
Theoretical Coverage Capacity	10.0 sq.mtr/ ltr @ 75 microns DFT 7.5 sq.mtr/ ltr @ 100 microns DFT
Drying Time at 30°C	Surface Dry : 5 hours Hard Dry : 18 hours Full Cure : 7 days
Over coating interval at 30°C	Min. : 18 hours Max. : Unlimited, provided surface is cleaned from all contamination
Method of Application	Brush , Air spray & Airless spray

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

Primed Surfaces:

- Suitable epoxy primer, epoxy/polyurethane undercoat; dry & free from all surface contamination. Apcothane CF 672 HS 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 672 HS 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 (by volume)	Base : Hardener 4 : 1
Induction Time	15 minutes
Pot Life at 30°C	3 hours

Application

Air Spray	
Recommended thinner	T 213
Volume of thinner	10 - 25 %
Nozzle orifice	1.5 - 3.0 mm
Nozzle pressure	0.3-0.4 MPa (= approx. 3 – 4 atm; 43 – 47 p.s.i.)
Airless Spray	
Recommended thinner	T 213
Volume of thinner	0 - 5%
Nozzle orifice	0.53 - 0.68 mm
Nozzle pressure	15 – 19 MPa (= approx. 150-190 atm; 2100 -2700 p.s.i.)
Brush / Roller	
Recommended thinner	T 213
Volume of thinner	5 - 15%

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipments immediately after use with Thinner T213. 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 finish is achieved by conventional spray application.
- Maximum film thickness in one coat is best achieved by airless spray technique. Application by conventional spray may require multiple cross spray pattern to achieve maximum film build. For brush application, minimum 2 coat application is recommended to provide adequate hiding and uniformity.
- Apcothane CF 672 HS 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. Prolonged exposure of strong chemicals and spillage may result in discoloration.

Overcoating

- Apcothane CF 672 HS can be top coated over most epoxy and polyurethane primers/ undercoats as recommended by Asian Paints PPG representative. Apcothane CF 672 HS can be top-coated with itself.
- When overcoating after weathering or ageing, ensure the surface is free from all contaminations before application of Apcothane CF 672 HS. Adhesion on such aged surface largely depends on the extent of secondary surface preparation.

PACK SIZE	20 ltrs (Base: 16 ltrs. & Hardener : 4 ltrs)
STORAGE	Shelf Life: Atleast 6 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: Approx. 240 gm/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.27 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.

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