

APCOTHANE HBPU FINISH

Polyurethane

PRODUCT DESCRIPTION

Two component high build, high solid, polyurethane coating

FEATURES AND RECOMMENDED USE

- Finish coat in epoxy / polyurethane systems
- Good resistance to atmospheric exposure
- Good resistance to water and saline atmosphere
- Gives tough, abrasion resistant finish on curing

TECHNICAL DATA

Colour	Range
Gloss	Matt to egg-shell
Volume Solids	Approx. 64%
Recommended DFT / Coat	75 - 125 microns
Theoretical Coverage Capacity	8.5 Sq.mtr/ ltr @ 75 microns DFT 5.1 Sq.mtr/ ltr @ 125 microns DFT
Drying time at 30°C	Surface Dry : 60 minutes Hard Dry : 8 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 8 hours Max. : Unlimited, provided surface is cleaned from all contamination.
Method of Application	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 volume solids indicated are as per ASTM D 2697 air drying method.
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

Blast Cleaning

- Suitable epoxy primer, epoxy/polyurethane undercoat; dry & free from all surface contamination. Apcothane HBPU Finish must be applied with the specified over-coating interval of the primer/ under-coat
- In case of aged epoxy coating, the surface should be 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 HBPU Finis is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, 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	30 minutes
Pot Life at 30°C	3 hours

Application

Air Spray	
Recommended thinner	T 213
Volume of thinner	5 - 25 %
Nozzle orifice	1.5 - 3.00 mm
Nozzle pressure	0.3- 0.4 MPa (= approx 3-4 atm ; 43-57 p.s.i.)
Cleaning thinner	T 213
Airless Spray	
Recommended thinner	T 213
Volume of thinner	0 - 15%
Nozzle orifice	0.41 - 0.48 mm
Nozzle pressure	20-24 MPa (= approx. 200-240 atm ; 2800-3400 p.s.i.)
Cleaning thinner	T 213
Brush / Roller	
Recommended thinner	T 213
Volume of thinner	0 - 10 %

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

- Maximum film build up is best achieved by airless spray. Application by air spray or brush may require multiple coats to attain maximum film build
- A minimum of 75 microns/ coat is recommended for proper hiding by spray application, however pastel shades and certain shades in red, yellow and orange will require 2 coats to give complete hiding especially when applied over dark undercoats
- As common to all the finish paints, minimum 2 coat application is recommended to provide adequate hiding and uniformity when applied by brush. However pastel shades and certain shades in red, yellow and orange may require 3 coats to give complete hiding especially when applied over dark undercoats at lower DFT range. 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 HBPU Finish must be thinned with the recommended thinner only. Usage of alternate thinners will affect the curing process
- Premature exposure to condensation and rain may cause color and gloss change

Overcoating

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

PACK SIZE	20 ltrs (Base: 18.18 ltrs & Hardener: 1.82 ltrs)
STORAGE	Shelf Life: Atleast 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: 370 ± 30 g/ ltr (depending on shades) as per USA-EPA Method 24 Product Weight: 1.5 ± 0.05 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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