

APCOTHANE HB PU FINISH SD / APCOTHANE 674 H



PRODUCT DESCRIPTION

Two component high performance, acrylic aliphatic polyurethane coating

FEATURES & RECOMMENDED USE

- Designed as a finish coat in epoxy/ polyurethane systems
- Excellent weather resistance in coastal and industrially polluted exposure conditions
- Very good gloss and colour retention characteristics
- Very good resistance to chemicals and water
- Good aged recoatability
- Good mechanical properties

TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 50%
Recommended DFT / Coat	35 - 50 μ m
Theoretical Coverage Capacity	14.3 sq.mtr/ ltr @ 35 μ m DFT 10.0 sq.mtr/ ltr @ 50 μ m DFT
Drying time at 30°C	Surface Dry : 2 hours Hard Dry : 16 hours Full cure : 7 days
Over coating 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

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 HB PU Finish SD/ Apcothane 674 H 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 HB PU Finish SD / Apcothane 674 H 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 8 : 1
Induction Time	15 minutes
Pot Life at 30°C	3 hours

Application

Air Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle Pressure	T 213 5 - 15% * 1.50 - 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 213 0 - 10% * 0.28 - 0.33 mm 10 -13 MPa (= approx. 100-130 atm; 1400-1800 p.s.i)
Brush / Roller Recommended thinner Volume of thinner	T 213 0 - 5% *

**Note: Depending on recommended thickness & application condition*

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's 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 two coat application is recommended to provide adequate hiding and uniformity specially when applied by brush
- Apcothane HB PU Finish SD / Apcothane 674 H 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 colour and gloss
- This product is not recommended for use in immersion condition. Extended exposure of strong chemicals, solvents, spillage may result in discoloration

Over-coating

- Apcothane HB PU Finish SD / Apcothane 674 H can be top coated on most epoxy and polyurethane primers /undercoats as recommended by Asian Paints PPG representative.
- When over-coating after weathering or ageing, ensure the surface is free from all contaminations before application of Apcothane HB PU Finish SD / Apcothane 674 H. Adhesion on such aged surface largely depends on the extent of secondary surface preparation

PACK SIZE	20 L (Base – 17.78 L, Hardener – 2.22 L)
STORAGE	Shelf Life: At least 6 months at 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. 440 gm/ltr (depending on shades) as per USA-EPA Method 24 Product Weight: 1.05 kg/ ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapour 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. Limited.

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:** customercare.apppg@asianpaintsppg.com, **Website:** www.asianpaintsppg.com