

Corroless ACO Brush Grade

(formerly Acothane Brush Grade)

Issue Date: Aug 2020
Issue: 4
Page 1 of 2

Product Description	A highly specialised, high build, solvent free, two pack polyurethane coating for steel and concrete, for brush application.				
Features & Use	<ul style="list-style-type: none"> Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance High build, solvent free Use for the protection of steel and concrete structures in aggressive environments, such as the internal and external protection of pipelines, offshore splash zones, bridge protection and chemical plants 				
Approvals/ Certification	<ul style="list-style-type: none"> Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection BS6920 factory and site application and WRAS water fittings directory (for specific shades) Meets the performance requirements of BS EN 10290 and AWWA C222 Malaysian SPAN approved Some approvals held in the former name of 'Acothane' 				
Finish	Sheen				
Volume Solids	100%				
VOC Content	0 g/litre				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	1.0 mm	1.0 mm	1.0 m ² /litre	
	Typical	1.5 mm	1.5 mm	0.67 m ² /litre	
Corroless ACO Brush Grade should be applied at approximately 0.5mm per coat. Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 1 mm DFT		+10°C	+20°C	+30°C
	Dust Free		4 hr	1½ hr	1 hr
	Hard Dry		12 hr	6 hr	3 hr
	Overcoating	Minimum	4 hr	1½ hr	1 hr
		Maximum	24 hr	24 hr	24 hr
Drying and recoating times are related to the substrate temperature					
Colours	WRAS shades: RAL5005 (GB861), Light Green (GB206) Other shades: Grey, Black, Cream				
Mix Ratio/ Product Code	10BGR (base) and 10ACT (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight				
Pot Life	25 min at 25°C				
SG	1.29 kg/lit mixed				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 24 months if stored as above in unopened containers				
Flash Point	Above 60°C				

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Issue Date: Aug 2020
Page 2 of 2

<p>Surface Preparation</p>	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams Steel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u> Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer 														
<p>Mixing</p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.</p>														
<p>Thinner / Cleaner</p>	<p>Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)</p>														
<p>Application Conditions</p>	<p>Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.</p>														
<p>Application Methods</p>	<table border="1"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>No</td> <td>No</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		No	No	Yes	Yes				
Method	Airless Spray	Conventional Spray	Brush	Roller											
	No	No	Yes	Yes											
<ul style="list-style-type: none"> This product is specifically designed for brush or roller application. Other Corroless ACO grades are available for spray application Corroless ACO Brush Grade should be applied at approximately 0.5mm per coat 															
<p>Product Notes</p>	<ul style="list-style-type: none"> Activator contains isocyanates – refer to Safety Data Sheet If maximum overcoating times are exceeded, abrading is required to provide adhesion for further coats In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous Corroless ACO Brush Grade has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice 														
<p>Health & Safety</p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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