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Corroless ACO Mastic Grade TG

(Formerly Acothane Mastic Grade TG)

Product Description	**A solvent free, two pack polyurethane mastic** for steel, for application at higher temperatures.
Features & Use	• Use for the coating of field joints, repair of damaged coatings, filling of holes and cracks, on steel pipelines and other steel structures • This TG grade is specifically developed for use at higher ambient temperatures and on hot substrates
Approvals/ Certification	• Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection • 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	0.75 mm	0.75 mm	1.3 m^2/litre
Typical	1.5 mm	1.5 mm	0.67 m^2/litre

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated

Drying Times

Applied to 1.0 mm DFT		+20°C	+30°C	+40°C
Dust Free		1 hr	45 min	30 min
Hard Dry	(Back Fill)	4 hr	2 hr	1 hr
Overcoating		1 hr	45 min	30 min
Full Cure		7 days	6 days	5 days

Drying and recoating times are related to the surface temperature

Colours	Cream
Mix Ratio/ Product Code	**10AMS-TCR** (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, approx. 8 min at 40°C
SG	1.29 kg/lt 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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Surface Preparation

- 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. Do not polish the steel surface
- **Overlap onto existing Corroless ACO coating:** remove any loose material to establish a firm edge. Feather sound coating and abrade surface to provide a key. Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disking etc.)
- **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

Mixing

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.

Thinner / Cleaner

Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)

Application Conditions

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.

Application Methods

Method	Airless Spray	Conventional Spray	Brush	Roller
	No	No	Yes	Yes

- Designed for application by brush, roller, putty knife, trowel or spatula

Product Notes

- **Activator contains isocyanates** – refer to Safety Data Sheet
- Overcoating - normally after 1 hour and within 24 hours of initial application. Abrading will be required if overcoating after 24 hours
- In-service temperature limits: Wet – 0ºC to 70ºC depending on solution; Dry – minus 20ºC to + 120ºC continuous
- Corroless ACO Mastic TG has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice
- Can be used in operations requiring fast cure, e.g. lay barge, weld coating and encapsulation of anode connectors, coating repair prior to trenching/backfilling. Corroless ACO Mastic Standard should be used for less speed-critical coating operations and at lower temperatures (e.g. below 25ºC)

Health & Safety

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.