Issue Date: Aug 2020
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Corroless ACO Spray Grade

(formerly Acothane Spray Grade)

Product Description	**A high build, solvent free, two pack polyurethane** coating for spray application onto steel pipes and field joints.
Features & Use	• Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance • Use for the protection of steel and concrete structures in aggressive environments e.g. internal and external protection of pipelines, field joints, offshore splash zones, bridge protection, chemical plants
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 • 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	0.5 mm	0.5 mm	2.0 m^2/litre
Typical	5 mm	5 mm	0.2 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 mm DFT		+10°C	+20°C	+30°C	+40°C
Dust Free		50 min	30 min	15 min	10 min
Hard Dry		8 hr	4 hr	3 hr	2 hr
Stackable		16 hr	8 hr	7 hr	7 hr
Full Cure		7 days	7 days	6 days	5 days

Drying and recoating times are related to the surface temperature

Colours	Cream, Grey and a limited range of other shades
Mix Ratio/ Product Code	**10SGR** (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	5 min at 20°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 • **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	Twin feed equipment required
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** See below • Twin component hot airless spray required with instant purge capability due to very short pot life – please consult Axalta Coating Systems for advice • Note that the use of the Sulzer cartridge spraying system or other low-pressure spraying systems is not permitted for Drinking water applications requiring WRAS approvals
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 – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous • Curing rate will be retarded below 10°C • Backfilling or immersion can normally be carried out as soon as the coating is Hard Dry • Spark/Holiday testing: maximum 5KV after the coating is hard dry • Corroless ACO Spray Grade has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice
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.