FERROTHANE

High Solids Polyurethane

DEFINITION

Surface tolerant polyurethane coating, applicable in thick films. FERROTHANE can be used as MONOLAYER or as TOPCOAT for epoxy systems.

INTENDED USES

Substrate(s) : MAINTENANCE
NEW WORK

Exposure(s) :

PRINCIPAL CHARACTERISTICS

Applicable on:
- Old coats in good condition
- Steel prepared Sa 2 1/2
- Steel already coated, having been selectively stripped with Ultra High Pressure water.

Allows thick layers up to 220 µm to be applied with an airless spray gun.
Presents excellent retention of appearance.
High filling power.

Over 1500 colours possible with our "Industry" tinting machine system.

CERTIFICATIONS / APPROVALS

ACQPA
☑

COMPATIBILITY

PREVIOUS COAT(S)*	SUBSEQUENT(S) COAT(S)*
Itself EPODUX PRIMER 61-134 v01 EPODUX HV PC EPODUX BR 100 FERROCOTE CHIMICOTE CHIMICOTE ST PRIMODUX H MONOCOCHE SR 75 MONOPRIMER 58-86 ANTIROUILLE MAT 55-17 ...	Itself POLYSTRIA v01.

*For any product not mentionned in compatibility lists, contact our technical support.

TECHNICAL DATA

NUMBER OF COMPONENTS	2
GLOSS LEVEL	Satin
COLOURS	according to RAL/AFNOR colour model, contact us for
MIXING RATIO	weight : 90/10 volume : 87/13
SPECIFIC GRAVITY	1,36 +/- 0,05 g/cm³
SOLIDS CONTENT	weight : 73,0 +/-2% volume : 58,0 +/- 3%
TYPICAL THICKNESS (DRY)	100 µm
RECOMMENDED WET FILM THICKNESS	170 µm
THEORETICAL SPREADING RATE	5,8 m²/l for 100 µm dry
AFNOR RATING NFT 36 005	AFNOR NFT 36 005 rating Family I Class 6a
VOC (Directive 2004/42/EC)	Cat. A/j : 500 g/L (2010) 500 g/L VOC
VOC IN INDOOR AIR	
PACKAGING	4L - 15L

Specific gravity, solid content by volume and by weight are given for mix A+B, without thinner and on the white base for all topcoat. Liquid characteristics of products are given at 20°C.

DRYING TIME – OVERCOATING INTERVAL

FILM THICKNESS 0 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
10°C	6 hours	10 hours	16 hours	48 hours	Non critical.
20°C	3 hours	6 hours	8 hours	24 hours	Non critical.

FILM THICKNESS 0 µm dry	POT LIFE	DRYING TIME		OVERCOATING INTERVAL	
		Touch dry	Hard dry	Minimum	Maximum
30°C	1 hour 30	3 hours 30	5 hours	12 hours	Non critical.

Introduce thinner may affect pot life. Dilution, relative humidity and aeration could affect drying time.

FERROTHANE

INSTRUCTIONS

All surfaces must be clean, dry and contamination-free before painting.

SURFACE PREPARATION

SUBSTRATE(S) :	RECOMMENDED
MAINTENANCE	HP washing followed by scraping / brushing of corroded areas to P3 degree according to ISO 8501-2: 1994. Carry out touch-up on these areas with a suitable primer to reconstruct the thicknesses (see chapter COMPATIBILITY).
NEW WORK	C1 and C2 atmospheres: Abrasive blasting to Sa 2½ according to ISO 8501-1: 2007. From C3 atmosphere : Application on compatible epoxy primer.

APPLICATION CONDITIONS

MIXING	The product is sold as pre-prepared kits. For the hardener portion in the base coat container and mix without creating air bubbles. The minimal recommended temperature of the mixture must be at least 15°C, or a thinner may be required in order to achieve adequate viscosity. Please note that an excessive amount of thinner may induce a dripping phenomenon.		
INDUCTION TIME	15 mn		
WEATHER CONDITIONS	Room temperature Relative humidity	: :	The temperature should be between 5°C and 40°C 85% maximum
TEMPERATURE	Of substrate Of product	: :	Between and +5°C and +40°C and at least 3°C higher than the dew point in order to eliminate any risk of condensation.
TECHNICAL NOTE	Do not keep the spraying equipment loaded for longer than the pot-life of the product. Rinse the equipment with the 62-162 thinner and clean thoroughly with a cleaning solvent. The container containing the prepared and unused mixture must not be hermetically sealed. In case of prolonged interrupted use, it may be preferable to prepare a new kit.		

Early exposure to condensation or rain could provide a change of gloss and/or shade.

APPLICATION

APPLICATION EQUIPMENT	DILUTION*	NOZZLE	PRESSURE AT NOZZLE	MINIMUM PUMP RATIO	REMARKS
AIRLESS SPRAY	5 to 15 %	0.017-0.021 (inches)	150-200 bars	-	Report pump Min : 45/1
AIR SPRAY CONVENTIONAL	0 to 20 %	depends on the equipment used.	3-5 bars	-	Thickness achievable after several passes
BRUSH	0 to 20 %	-	-	-	-
ROLLER	0 to 20 %	-	-	-	-
THINNER	-		CLEANING SOLVENT	-	-

* Dilution rate % are indicative and should be adapted to atmospheric conditions and site specific conditions. Excess of thinner could involve sagging effect and lost of opacity.

HEALTH AND SAFETY

Flash point	:	BASE between 23°C and 55°C HARDENER between 23°C and 55°C
Shelf life	:	DLUO : 2 years minimum in original full, sealed packaging . Store in a cool, ventilated place.
Precautions	:	Refer to the current material safety data sheet(SDS).
Transport and labelling	:	Refer to SDS according to European directives.
Waste Managment	:	Soiled Industrial wastes. For more information, please refer to SDS.