

# Corroless ACO Brush Grade

(formerly Acothane Brush Grade)

Issue Date: Mar 2019

Issue: 2

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<b>Product Description</b>	<b>A highly specialised, high build, solvent free, two pack polyurethane</b> coating for steel and concrete, for brush application.				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>Outstanding physical properties in terms of flexural strength, tensile strength, impact and abrasion resistance</li> <li>High build, solvent free</li> <li>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</li> </ul>				
<b>Approvals/ Certification</b>	<ul style="list-style-type: none"> <li>Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection</li> <li>BS6920 Factory and site application and WRAS water fittings directory</li> <li>Meets the performance requirements of BS EN 10290 and AWWA C222</li> <li>Malaysian SPAN approved</li> <li>Approvals held in the former name of 'Acothane'</li> </ul>				
<b>Finish</b>	Sheen				
<b>Volume Solids</b>	100%				
<b>VOC Content</b>	0 g/litre				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Typical</b>	1.0 mm	1.0 mm	1.0 m <sup>2</sup> /litre	
	<b>Typical</b>	1.5 mm	1.5 mm	0.67 m <sup>2</sup> /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					
<b>Drying Times</b>	Applied to 1 mm DFT	<b>+10°C</b>	<b>+20°C</b>	<b>+30°C</b>	
	<b>Dust Free</b>	4 hr	1½ hr	1 hr	
	<b>Hard Dry</b>	12 hr	6 hr	3 hr	
	<b>Overcoating</b>	Minimum	4 hr	1½ hr	1 hr
		Maximum	24 hr	24 hr	24 hr
Drying and recoating times are related to the substrate temperature					
<b>Colours</b>	Dark Grey and special shades to order				
<b>Mix Ratio/ Product Code</b>	<b>10BGR</b> (base) and <b>10ACT</b> (activator) Base 3 parts by volume 3.23 parts by Weight Hardener 1 part by volume 1 part by Weight				
<b>Pot Life</b>	25 min at 25°C				
<b>SG</b>	1.29 kg/lit mixed				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 24 months if stored as above in unopened containers				
<b>Flash Point</b>	Above 60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>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</li> <li><b>Steel:</b> 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></li> <li><b>Concrete:</b> remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of &lt;16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer</li> </ul>														
<p><b>Mixing</b></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><b>Thinner / Cleaner</b></p>	<p>Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)</p>														
<p><b>Application Conditions</b></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><b>Application Methods</b></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											
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<ul style="list-style-type: none"> <li>This product is specifically designed for brush or roller application. Other Corroless ACO grades are available for spray application</li> <li>Corroless ACO Brush Grade should be applied at approximately 0.5mm per coat</li> </ul>															
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li><b>Activator contains isocyanates</b> – refer to Safety Data Sheet</li> <li>If maximum overcoating times are exceeded, abrading is required to provide adhesion for further coats</li> <li>In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water</li> <li>In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous</li> <li>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</li> </ul>														
<p><b>Health &amp; Safety</b></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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