Technical Data Sheet

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Product name

ACRYLINE TOPCOAT SB

POLYURETHANE TOPCOAT(APU RANGE)

PRODUCT DESCRIPTION

A two-component polyurethane acrylic finish.

INTENDED USES

- Finish coating for cars, buses, trucks, trailers, tippers, cranes, earth moving equipment and farm machinery.

FEATURES AND BENEFITS

- High performance topcoat with excellent gloss, colour retention and UV durability .
- Good mechanical and chemical resistance.
- Resistance to weathering

PRODUCT INFORMATION

Appearance	High Gloss
Colours	White(APU 35), Black(APU 20), Clear(APU 10)
Volume Solids	± 35% (typical) (dependent on colour)
Recommended DFT	Min: 50µm, Max: 60µm. (Cumulative dry film thickness)
Recommended WFT	Min: 140µm, Max: 175µm. (Cumulative wet film thickness)
Theoretical spreading rate	5.8m²/L at 60µm DFT at stated volume solids
Practical spreading rate	The practical spreading rate will vary depending on the porosity and profile of the substrate as well as the application techniques & tools used.
VOC	<800g/L(typical)
Flash Point	<23°C(typical)

Viscosity	55 – 65seconds (typical) DIN Cup No.4

APPLICATION DETAILS

Mixing Ratio	2 parts base(APU RANGE) to 1 part curing agent(APU 202,203,204) by volume
Mixing	Stir both components separately with a power mixer until homogenous. Add the curing agent to the base and mix thoroughly together. Mix only in proportions shown above.
Method	Airless and conventional spray Airless spray: Nozzle orifice: 0.013" – 0.017" Nozzle pressure: 100 – 140bar Air assisted airless spray: Nozzle orifice: 0.013" – 0.017" Nozzle pressure: 70 – 100bar Pressure pot spray: Nozzle orifice: 1.5 – 1.7mm Nozzle pressure: 3.0 – 4.0bar Pot pressure: 1.0 – 2.0bar Conventional spray: Nozzle orifice: 1.5 – 1.7mm Nozzle pressure: 3.0 – 4.0bar HVLP spray: Nozzle orifice: 1.4 – 1.5mm Nozzle pressure: 1.8 – 2.0bar

Application environment			
	Surface Temperature	Min*: 10°C	Max: 40°C
	Ambient Temperature	Min*: 10°C	Max: 40°C
	Relative Humidity	Min*: 10%	Max: 85%

*or 3°C min. above dew point

Thinning	ACRYLINE THINNER(ATH 301,302,303).Max 10 %.
Cleaning	FLOWLINE THINNER(KNT 1)

Drying Time		
	Flash off	10min at 23°C
	Touch dry	1h at 23°C
	Overcoating(Min)	1h at 23°C
	Overcoating(Max)	48h at 23°C
	Dry to handle	12h at 23°C
	Full Cure	7 Days
	Accelerated Drying	30min at 60°C(panel temperature)

Pot Life 4h at 23°C

STORAGE AND PACKAGING

Store away from direct sun, heat, open flames, sparks and severe cold.
Shelf Life: 36 months(base)
12 months(curing agent)
Dual Packs: 5L in 5L container(base)
1L in 1L container(curing agent)

SURFACE PREPARATION

Ensure that surfaces are dry, sound, and free from dust, dirt, grease, and oil before painting.

MILD STEEL

- Degrease with ACRYLINE PRE-CLEANER SB(ATH 310) and rinse with fresh water until water break free surface.
- To remove rust, mill scale and other contaminants abrasive blast clean to Grade Sa 2½ of ISO 8501-1:2007 with a blast profile of 30 – 50µm.
- Alternatively wire brush to Grade St 3 of the same standard. This is not as effective and may result in a shorter maintenance-free period.
- Alternatively sand substrate with 80 – 120 grit paper to a smooth finish.
- Prime surfaces with ACRYLINE ETCH PRIMER SB(APU 107), ACRYLINE PRIMER SB(APU 104), ACRYLINE 2K PRIMER(APU 108)

PHOSPHATED STEEL,GALVANISED STEEL AND ALUMINIUM

- Degrease with ACRYLINE PRE-CLEANER SB(ATH 310) and rinse with fresh water until water break free surface.
- Sand substrate with Scotch Brite pads
- Alternatively sand substrate with 280 – 320 grit paper to a smooth finish.
- Prime surfaces with ACRYLINE ETCH PRIMER SB(APU 107), ACRYLINE PRIMER SB(APU 104), ACRYLINE 2K PRIMER(APU 108)

POLYPROPYLENE and PLASTIC – NEW

- Bake for two cycles 30min at 60°C to exude release agents.
- Remove all contamination with MASTERMIX PRE-CLEANER(PTK 310)by using the spray on wipe off method.
- Abrade surfaces with P5000 - 800 grit sandpaper to provide a key.
- Leave overnight or bake for 40min at 60°C.
- Prime surfaces with MASTERMIX PLASTIC PRIMER(PTK 186)

APPLICATION INFORMATION

- Thin as required and apply to achieve the required dry film thickness.
- Apply light successive overlapping coats to prevent material running or sagging. Ensure each coat is allowed to dry before applying the next. Layer the coating to achieve the necessary dry film thickness.
- Use air fed respirator during application
- For professional use only.
- Not suitable for use over thermoplastic acrylic lacquers and synthetic air drying enamels.
- Applicators must ascertain the most suitable needle, Fluid tip, and air cap for the article being coated. Air and atomising pressures must be set to produce the optimum delivery efficiency and quality of finish.
- Dry primer surface preparation - Ensure the surface is completely dry. Then lightly and evenly sand to smooth surface with fine-grit sandpaper (400 grit) or a sanding sponge.
- Clean surface by removing dust from sanding using either vacuum or a tack cloth or a damp, lint-free cloth.
- Remove oil, grease and dirt and any other contaminants with ACRYLINE PRE-CLEANER SB(ATH 310)
- Once the surface is smooth, clean, and fully dry, apply topcoat.

SAFETY PRECAUTIONS

- Always keep paint out of reach of children.
- Ensure good ventilation during application and drying.
- If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner.
- Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention.
- Harmful if swallowed. Seek medical attention and do not induce vomiting.
- Do not smoke while painting.
- Flammable. Store in a cool dry place away from heat and sparks.
- CATALYST contains isocyanate – use suitable respirator, particularly during spray application of the mixed material.
- Refer to Safety Data Sheet for complete information.

DISCLAIMER

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are

believed to be dependable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

NB: Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

NB: TO ORDER: Quote product name, product code number, packaging, and colour.

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