

Corroless ACO Brush Grade HB

(formerly Acothane Brush Grade HB)

Issue Date: March 2021

Issue: 6

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Product Description	A highly specialised, solvent free, two pack polyurethane coating for steel and concrete, for brush application with additional build properties.			
Features & Use	- Increased build properties compared to standard Brush Grade - 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, such as the internal and external protection of pipelines, offshore splash zones, bridge protection and 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	1.0 mm	1.0 mm	1.0 m ² /litre
	Typical	1.5 mm	1.5 mm	0.67 m ² /litre
	Corroless ACO Brush Grade HB should be applied at approximately 1.5mm per coat. 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
	Dust Free		1½ hr	1 hr
	Hard Dry		6 hr	4 hr
	Overcoating	Minimum	1½ hr	1 hr
		Maximum	24 hr	24 hr
	Drying and recoating times are related to the substrate temperature			
Colours	Cream (GV301) and special shades to order			
Mix Ratio/ Product Code	10BGHB (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			
SG	1.29 kg/lit 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. <u>Do not polish the steel surface</u> 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
	- This product is specifically designed for brush or roller application. Other Corroless ACO grades are available for spray application - Corroless ACO Brush Grade HB should be applied at approximately 1.5mm per coat				
Product Notes	Activator contains isocyanates – refer to Safety Data Sheet - If maximum overcoating times are exceeded, abrading is required to provide adhesion for further coats - In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous - Corroless ACO Brush Grade HB 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.				

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