

ACRATHANE[®] IF

Isocyanate Free High Gloss Catalysed Acrylic Finish

PC 218

- FEATURES**
- EXCELLENT ANTI GRAFFITI COATING
 - GOOD WEATHERING AND CHEMICAL RESISTANCE
 - GOOD ABRASION RESISTANCE AND TOUGHNESS
 - TINTABLE – AVAILABLE IN OVER 5,000 COLOURS
 - REDUCED GLOSS FINISH ACHIEVEABLE WITH THE DULUX FLATTING BASE

USES ACRATHANE[®] IF is a high gloss, two component, catalysed acrylic designed for long life. It is user friendly and can be recoated with itself after simply ensuring the surface is clean and has been lightly abraded. It is isocyanate free and does not pose a health threat when used in accordance with occupational health guidelines. ACRATHANE[®] IF has good gloss and colour retention making it suitable for mobile equipment. Due to its' excellent chemical resistance it is suitable to use as the topcoat in chemical plants, oil platforms and refineries.

SPECIFICATIONS AS/NZS 3750.5

RESISTANCE GUIDE

HEAT RESISTANCE	Up to 100°C dry heat.	ALKALIS	Good resistance to splash and spillage of most common alkalis.
WEATHERABILITY	Good gloss and colour retention on exterior exposure.	SALTS	Unaffected by splash and spillage of neutral and alkaline salt solutions.
SOLVENTS	Resists splash and spillage of most organic solvents.	WATER	Excellent resistance to fresh and salt water but not suitable for immersion.
ACIDS	White and colours are suitable for splash and spillage of mild acids.	ABRASION	Good when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two Component Catalysed Acrylic		APPLICATION CONDITIONS	Min	Max	
FINISH	High Gloss		Air Temperature	10°C	45°C	
COLOUR	White, LF Golden Yellow, Black, Clearcoat Gloss, a full range of tinted colours and MTO factory made colours.		Substrate Surface Temperature	10°C	45°C	
COMPONENTS	Two		Relative Humidity		85%	
SOLIDS BY VOLUME	43% (White)			Min	Max	Recom.
VOC LEVEL	<520 g/L (White, untinted)		Wet film per coat (microns)	115	165	140
FLASH POINT	16°C		Dry film per coat (microns)	50	70	60
POT LIFE	6 hours (4L, 25°C)		SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF.		
MIXING RATIO (V/V)	Part A : 4 Part B : 1		PRIMERS	Most two pack primers. Refer to precaution section on next page.		
THINNER	Brush	965-42166	APPLICATION METHODS	Conventional, airless spray or air assisted spray.		
	Spray	965-63023				
		446-63001				
		446-63002				
		446-63003				
		446-39141				
		446-00070				
		446-30900				
		446-81814				
		976-51087				

** See comments in application and precautions section over the page.

Drying characteristics at 60 microns dry film thickness

Temperature	Humidity	Touch	Handle	Full Cure	Overcoat	
					Min	Max*
10° C	50%	1.5 Hours	16 Hours	7 Days	16 Hours	Indefinite
15° C	50%	1 Hours	10 Hours	7 Days	10 Hours	Indefinite
25° C	50%	30 Minutes	7 Hours	7 Days	8 Hours	Indefinite

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

* When applying over epoxy primers and intermediates ensure that the application is carried out within 24 hours of applying the epoxy.

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 7.2 sq. metres per litre corresponds to 60 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

ACRATHANE® IF

TYPICAL SYSTEMS

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

SURFACE	PREPARATION GUIDE	SYSTEM		DRY FILM THICKNESS
STEEL	Abrasive blast AS1627.4 Class 2.5	1st Coat	ZINCANODE® 402	75 Microns
		2nd Coat	DUREMAX® GPE	125 Microns
		3rd Coat	ACRATHANE® IF	60 Microns
		1st Coat	DUREPON® P14	75 Microns
CONCRETE	Clean surface to remove contaminants. Diamond grind, track or light-shot blast. Remove dust.	2nd Coat	ACRATHANE® IF	60 Microns
		3rd Coat	ACRATHANE® IF (Optional)	60 Microns
		2nd Coat	ACRATHANE® IF	60 Microns
		3rd Coat	ACRATHANE® IF (Optional)	60 Microns
ALUMINIUM	Clean, degrease and abrade surface	1st Coat	LUXEPOXY® 4 White Primer	75 Microns
		2nd Coat	ACRATHANE® IF	60 Microns
		3rd Coat	ACRATHANE® IF (Optional)	60 Microns

For a reduced gloss finish refer to Product Data Sheet PC216 DULUX® FLATTING BASE.

SURFACE PREPARATION It is recommended that specifiers follow the guidelines for surface preparation from the data sheet for the primer selected. The primer surface must be free from grease, oil, dirt and other loosely adhering materials.

APPLICATION Stir each can thoroughly until the contents are uniform. Use of a power mixer is recommended. Ensure bases have been tinted to the correct colour before use - DULUX ASSUMES NO RESPONSIBILITY FOR THE APPLICATION OF AN INCORRECT COLOUR. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Box all containers before use to ensure colour consistency. Remix thoroughly before using.

BRUSH/ROLLER Suitable for small areas only. Where larger areas are to be coated, application can be improved by thinning with up to 100 ml/litre with DUTHIN® 040 (965-42166). When brushing and rolling additional coats may be required to attain the specified thickness. **Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels and application technique. The effect achieved by brush and roller will differ greatly from that obtained by spray application.**

CONVENTIONAL SPRAY Thin up to 200ml/litre with Dulux® Urethane Thinner (965-63023) to aid atomisation. **Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels, film build, spraying technique and gun set-up.**

<u>Typical Set-up</u>	Graco Delta Gun	1.4mm (239542)
	Pressure at Pot:	70-100 kPa (10-15 p.s.i.)
	Pressure at Gun:	380-410 kPa (55-60 p.s.i.)

AIRLESS SPRAY Standard airless spray equipment such as a Graco 30:1 President with a fluid tip of 15-17 thou (0.38-0.43mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not normally required but up to 100 ml/litre of Dulux® Urethane Thinner (965-63023) may be added to ease application.

PRECAUTIONS This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. All surfaces to be coated must be totally free of moisture and contaminants that may have been deposited on the surface. Ensure that in all circumstances epoxy primers and intermediates are topcoated within 24 hours of applying the epoxy. **Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels, film build, application method and technique. Control of these parameters is especially important when coatings are used on cladding or board wall areas. Do not use this product for this application without reference to a Dulux® Protective Coatings representative.**

CLEAN UP Clean all equipment with Dulux® Urethane Thinner (965-63023) immediately after use.

OVERCOATING Aged coating should be tested for lifting by a method appropriate for the coating thickness, for example 'X' cut or cross-hatch methods. If it lifts, remove it. The surface must be free of oil, grease and other contaminants. High-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) to remove loosely adhering chalk and dust. Abrasion may be required depending on surface condition.

SAFETY PRECAUTIONS **Read Data Sheet, Safety Data Sheet and any precautionary labels on containers.**

STORAGE Store as required for a flammable liquid Class 3 in a bonded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

HANDLING As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.

USING Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.

FLAMMABILITY This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.

WELDING Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

SAFETY DATA SHEET is available from Dulux Customer Service (Phone Australia 132 377 or New Zealand 0800 800 424) www.duluxprotectivecoatings.com.au

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427 Dulux, Zincode, Luxepoxy, Duthin, Acrathane, Duremax and Durepon are registered trade marks. DuluxGroup is a trade mark.	DuluxGroup (New Zealand) Pty Ltd 150 Hutt Park Road, Lower Hutt, NZ A.B.N. 55 133 404 118	PACKAGING Available in 4 litre and 20 litre packs TRANSPORTATION WEIGHT 1.13 kg/litre (Average of components)	DANGEROUS GOODS Part A: Class 3 UN 1263 Part B: Class 3 UN 1263
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