ACRATHANE® IF
Isocyanate Free High Gloss Catalysed Acrylic Finish

**FEATURES**
- EXCELLENT ANTI GRAFFITI COATING
- GOOD WEATHERING AND CHEMICAL RESISTANCE
- GOOD ABRASION RESISTANCE AND TOUGHNESS
- TINTABLE – AVAILABLE IN OVER 5,000 COLOURS

**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 suited to on-site application.

ACRATHANE® IF has good gloss and colour retention and therefore used for mobile equipment. Due to its excellent chemical resistance, it is suitable as the topcoat in chemical plants, oil platforms and refineries. ACRATHANE® IF is also widely used as a graffiti resistant finish on public spaces and infrastructure.

**SPECIFICATIONS**

**RESISTANCE GUIDE**

<table>
<thead>
<tr>
<th>WEATHERABILITY</th>
<th>SOLVENTS</th>
<th>WEARABILITY</th>
</tr>
</thead>
<tbody>
<tr>
<td>Good gloss and colour retention on exterior exposure</td>
<td>Resists splash and spillage of most organic solvents</td>
<td></td>
</tr>
<tr>
<td>HEAT RESISTANCE</td>
<td>WATER</td>
<td>Good resistance to splash and spillage of most common alkalis</td>
</tr>
<tr>
<td>Up to 100°C dry heat</td>
<td>Excellent resistance to fresh and salt water but not suitable for immersion</td>
<td></td>
</tr>
<tr>
<td>SALTS</td>
<td>ALKALIS</td>
<td>Good when fully cured</td>
</tr>
<tr>
<td>Unaffected by splash and spillage of neutral and alkaline salt solutions</td>
<td>Good resistance to splash and spillage of most common alkalis</td>
<td></td>
</tr>
<tr>
<td>ABRASION</td>
<td>SUITABLE SUBSTRATES</td>
<td>Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF</td>
</tr>
<tr>
<td>Suitable for splash and spillage of mild acids</td>
<td>Suitable for splash and spillage of most common alkalis</td>
<td></td>
</tr>
</tbody>
</table>

**TYPICAL PROPERTIES AND APPLICATION DATA**

**CLASSIFICATION**
Two Component Catalysed Acrylic

**FINISH**
High Gloss

**COLOUR**
White, Golden Yellow, Black, full range of tinted colours and MTO factory made colours, Also available in Clearcoat®, Also available in Sparkling Aluminium®

**COMPONENTS**
Two

**VOLUME SOLIDS**
43% (White)

**VOC LEVEL**
<520 g/L (White, untinted)

**FLASH POINT**
15°C

**POT LIFE**
6 hours (4 litre kit, 25°C)

**MIXING RATIO V/V**
Part A : 4 Part B : 1

**THINNER – BRUSH**
965-42166 Dulux® Urethane Thinner

**THINNER – SPRAY**
965-63023 Dulux® Urethane Thinner

**PRODUCT CODE**
446-63001 White/Light Base
446-63002 Deep Base
446-63003 Clear Base
446-39141 Golden Yellow
446-00070 Black
976-51087 Hardener

**SPREADING RATE ASSUMING NO LOSSES**
7.2 square metres per litre equals 60 μm dry film thickness

**APPLICATION CONDITIONS**

<table>
<thead>
<tr>
<th>APPLICATION METHODS</th>
<th>SUITABLE SUBSTANCES</th>
<th>PETROLATUM PRIMERS</th>
</tr>
</thead>
<tbody>
<tr>
<td>Primers</td>
<td>Most Dulux® two pack epoxy primers</td>
<td>(must be applied within 24 hours of applying the epoxy)</td>
</tr>
<tr>
<td>Conventional, airless spray or air assisted spray</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**FILM THICKNESS (MICRONS)**

<table>
<thead>
<tr>
<th>FILM THICKNESS (MICRONS)</th>
<th>Min</th>
<th>Max</th>
<th>Recommended</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet film per coat (μm)</td>
<td>115</td>
<td>165</td>
<td>140</td>
</tr>
<tr>
<td>Dry film per coat (μm)</td>
<td>50</td>
<td>70</td>
<td>60</td>
</tr>
</tbody>
</table>

**DRYING CHARACTERISTICS AT 60 μm DRY FILM THICKNESS**

<table>
<thead>
<tr>
<th>DRYING CHARACTERISTICS AT 60 μm DRY FILM THICKNESS</th>
<th>OVERCOAT</th>
</tr>
</thead>
<tbody>
<tr>
<td>Temperature</td>
<td>Humidity</td>
</tr>
<tr>
<td>10°C</td>
<td>50%</td>
</tr>
<tr>
<td>15°C</td>
<td>50%</td>
</tr>
<tr>
<td>25°C</td>
<td>50%</td>
</tr>
</tbody>
</table>

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

‡ When applying over epoxies, ensure that the application is carried out within 24 hours of applying the epoxy.
**ACRATHANE® IF**

### TYPICAL SYSTEMS

<table>
<thead>
<tr>
<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEEL</td>
<td>Very high corrosivity (AS2312.1 Cat C5) System ACC05</td>
<td>Abrasive blast AS1627.4 Class 2.5</td>
<td>1st Coat Zincanode® 402</td>
<td>75 μm</td>
</tr>
<tr>
<td>STEEL</td>
<td>Low corrosivity (AS2312.1 Cat C2) System ACC2</td>
<td>Abrasive blast AS1627.4 Class 2.5</td>
<td>1st Coat Durepon® EZP Acrathane® IF</td>
<td>75 μm</td>
</tr>
<tr>
<td>CONCRETE</td>
<td>Exterior/Interior</td>
<td>Remove release agents and other surface contaminants</td>
<td>1st Coat Durebild® STE Acrathane® IF</td>
<td>125 μm</td>
</tr>
<tr>
<td>ALUMINIUM</td>
<td>Exterior/Interior</td>
<td>Clean, degrease and abrade surface</td>
<td>1st Coat Luxepoxy® 4 White Primer Acrathane® IF (Optional)</td>
<td>50 μm</td>
</tr>
</tbody>
</table>

**NOTE:** If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity.

### SURFACE PREPARATION

Specifiers should follow the surface preparation guidelines from the data sheet for the primer selected. The surface must be free from grease, oil, dirt, rust and other contaminants. If applying over an epoxy primer, ensure that the Acrathane® IF is applied within 24 hours, otherwise the epoxy must be thoroughly sanded to provide a key.

### APPLICATION

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

### BRUSH/ROLLER

Suitable for small areas only. Application can be improved by thinning with up to 100 ml/litre with Dulux® 040 (965-45168). When brushing or rolling additional coats may be required to attain the specified thickness.

Thin up to 200ml/litre with Dulux® Urethane Thinner (965-63023) to aid atomisation.

### AIRLESS SPRAY

**Typical Set-up**

- Graco AirPro Pressure at Triton 308: 1.4mm (239542)
- 70-100 kPa (10-15 p.s.i.)
- 380-410 kPa (55-60 p.s.i.)
- 5:1

**Pressure at Gun:**

- Standard airless spray equipment such as a Graco Xtreme 30: 1 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® Consultant for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the written consent of Dulux® Australia. Freshly mixed material must not be added to previously mixed material. 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. The surface to be coated must be totally free of moisture and contaminants. Ensure that in all circumstances Acrathane® IF is applied over epoxy primers and intermediates within 24 hours of applying the epoxy. Do not use this product without consulting a Dulux® Protective Coatings Consultant.

### CLEAN UP

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

### OVERCOATING

Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating. Epoxy must be abraded if recoated outside the recoat window.

### SAFETY PRECAUTIONS

Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEETS are available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au.

### STORAGE

Store as required for a flammable liquid Class 3 in a bunded 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 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 foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.

### FLAMMABILITY

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. 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.