

# ACRATHANE® IF

## Isocyanate Free High Gloss Catalysed Acrylic Finish

PC 218

- FEATURES**
- GOOD WEATHERING AND CHEMICAL RESISTANCE
  - GOOD ABRASION RESISTANCE AND TOUGHNESS
  - PROTECTS AGAINST GRAFFITI
  - 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 chemical resistance, ACRATHANE® IF is suitable in chemical plants, oil platforms and refineries.

ACRATHANE® IF is also widely used as a graffiti resistant finish on public spaces and infrastructure.

**SPECIFICATIONS** AS/NZS 3750.5

### RESISTANCE GUIDE

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

### TYPICAL PROPERTIES AND APPLICATION DATA

<b>CLASSIFICATION</b>	Two Component Catalysed Acrylic		<b>APPLICATION CONDITIONS</b>		
<b>FINISH</b>	High Gloss			Min	Max
<b>COLOUR</b>	White, Golden Yellow, Black, full range of tinted colours and MTO factory made colours. Also available in Clearcoat†. Also available in Sparkling Aluminium†		<b>Air Temp.</b>	10°C	40°C
			<b>Substrate Temp.</b>	10°C	40°C
			<b>Relative Humidity</b>		85%
<b>COMPONENTS</b>	Two		<b>FILM THICKNESS (MICRONS)</b>		
<b>VOLUME SOLIDS</b>	43% (White)			Min	Max
<b>VOC LEVEL</b>	<520 g/L (White, untinted)				Recommended
<b>FLASH POINT</b>	15°C		<b>Wet film per coat (µm)</b>	115	165
<b>POT LIFE</b>	6 hours (4 litre kit, 25°C)		<b>Dry film per coat (µm)</b>	50	70
<b>MIXING RATIO V/V</b>	Part A : 4	Part B : 1			
<b>THINNER –BRUSH</b>	965-42166	Duthin® 040	<b>SUITABLE SUBSTRATES</b>	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF	
<b>THINNER –SPRAY</b>	965-63023	Dulux® Urethane Thinner	<b>PRIMERS</b>	Most Dulux® two pack epoxy primers	
<b>PRODUCT CODE</b>	446-63001	White/Light Base		If Dulux Flatting Base is being used and the 24 hour recoat window is exceeded, mechanical abrasion is not sufficient to achieve adhesion, an epoxy tie coat is required and the Acrathane IF with Flatting base MUST be applied within 24 hours	
	446-63002	Deep Base			
	446-63003	Clear Base			
	446-39141	Golden Yellow			
	446-00070	Black			
	976-51087	Hardener	<b>APPLICATION METHODS</b>	Conventional, airless spray or air assisted spray	

† See separate Product Data Sheets

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

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max <sup>1</sup>
10° C	50%	1.5 Hours	16 Hours	7 Days	16 Hours	Extended
15° C	50%	1 Hour	10 Hours	7 Days	10 Hours	Extended
25° C	50%	30 Minutes	7 Hours	7 Days	8 Hours	Extended

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

<sup>1</sup> When applying over epoxies, ensure that the application is carried out within 24 hours of applying the epoxy.

## SPREADING RATE ASSUMING NO LOSSES

**7.2 square metres per litre equals 60 µm dry film thickness**

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions and surface roughness.

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## TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM	DFT (µm)	
STEEL	Very high corrosivity (AS2312.1 Cat C5) System ACC6	Abrasive blast AS1627.4 Class 2.5	1 <sup>st</sup> Coat	Zincanode® 402	75 µm
			2 <sup>nd</sup> Coat	Duremax® GPE	200 µm
			3 <sup>rd</sup> Coat	Acrathane® IF	60 µm
STEEL	Low corrosivity (AS2312.1 Cat C2) System ACC2	Abrasive blast AS1627.4 Class 2.5	1 <sup>st</sup> Coat	Durepon® EZP	75 µm
			2 <sup>nd</sup> Coat	Acrathane® IF	60 µm
CONCRETE	Exterior/Interior	Remove release agents and other surface contaminants	1 <sup>st</sup> Coat	Durebild® STE	125 µm
			2 <sup>nd</sup> Coat	Acrathane® IF	60 µm
			3 <sup>rd</sup> Coat	Acrathane® IF (Optional)	60 µm
ALUMINIUM	Exterior/Interior	Clean, degrease and abrade surface	1 <sup>st</sup> Coat	Luxepoxy® 4 White Primer	50 µm
			2 <sup>nd</sup> Coat	Acrathane® IF	60 µm
			3 <sup>rd</sup> Coat	Acrathane® IF (Optional)	60 µm

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

NOTE: If using with Flating Base, a test piece must be prepared to confirm acceptable gloss and performance is achieved. Overcoating intervals must be strictly observed

<b>SURFACE PREPARATION</b>	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.			
<b>APPLICATION</b>	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.			
<b>BRUSH/ROLLER</b>	Suitable for small areas only. 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.			
<b>CONVENTIONAL SPRAY</b>	Thin up to 200ml/litre with Dulux® Urethane Thinner (965-63023) to aid atomisation.			
	Typical Set-up	Graco AirPro	1.4mm (239542)	
		Pressure at Triton 308:	70-100 kPa (10-15 p.s.i.)	
		Pressure at Gun:	380-410 kPa (55-60 p.s.i.)	
<b>AIRLESS SPRAY</b>	Standard airless spray equipment such as a Graco Xtreme 30:1 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.			
<b>PRECAUTIONS</b>	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.			
<b>CLEAN UP</b>	Clean all equipment with Dulux® Urethane Thinner (965-63023) immediately after use.			
<b>OVERCOATING</b>	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. Epoxies must be abraded if recoated outside the recoat window.			
<b>SAFETY PRECAUTIONS</b>	Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEETS are available from Customer Service (13 23 77) or <a href="http://www.duluxprotectivecoatings.com.au">www.duluxprotectivecoatings.com.au</a>			
<b>STORAGE</b>	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.			
<b>HANDLING</b>	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.			
<b>USING</b>	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 spraying, users must comply with their respective State Spray Painting Regulations.			
<b>FLAMMABILITY</b>	This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO <sub>2</sub> or dry chemical powder. On burning will emit toxic fumes.			
<b>WELDING</b>	Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.			

## COMPANY INFORMATION

Dulux Protective Coatings a division of  
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## PACKAGING, TRANSPORT AND STORAGE

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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