

APCOTHANE CF 678 FD

High Performance Polyurethane Topcoat



PRODUCT DESCRIPTION

Two component high build, high solid, acrylic aliphatic polyurethane finish with excellent weathering performance and fast drying characteristics.

FEATURES AND RECOMMENDED USE

- It is used as a topcoat on LPG Cylinders.
- Designed as finish coat for new construction and maintenance over most epoxy-polyurethane systems
- Excellent weather resistance in coastal and industrially polluted exposure conditions
- Excellent gloss and color retention
- Very good chemicals and water resistance
- Excellent mechanical properties

TECHNICAL DATA

Color	Range
Gloss	Glossy
Volume Solids	Approx. 54%
Recommended DFT/ Coat	40 - 50microns
Theoretical Covering Capacity	13.5 sq.mtr/l @ 40 microns 10.8 sq.mtr/l @ 50 microns
Drying Time at 30° C	Surface dry: 10 minutes Hard dry: 4 hours Full cure: 7 days
Overcoating interval at 30° C*	Min.: 4 hours Max.: Unlimited, provided surface is cleaned from all contamination
Method of Application	Air spray & Airless spray

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, color, and testing variances. The actual drying time/overcoat interval may be shorter or longer, depending on film thickness, ventilation, humidity, temperature etc. The information provided above is at 30°C and 65% relative humidity.

DIRECTION FOR USE

Surface Preparation

General:

- Surfaces must be dry, clean, and free from contaminants.
- Ensure removal of dirt, dust, oil, and all other contaminants that could interfere with adhesion of the coating. Oil and grease should be removed as per SSPC-SP1 solvent cleaning.
- Surface: should be checked and treated in accordance with ISO 8504 prior to priming.

Primed Surfaces:

- Suitable epoxy primer, epoxy/polyurethane undercoat; dry & free from all surface contamination. Apcothane CF 678 FD must be applied with the specified over-coating interval of the primer/under-coat.
- In case of aged epoxy coating, the surface should be sufficiently roughened prior to painting.

Application Conditions:

- Substrate temperature should be at least 3°C above dew point but not above 50°C.
- Relative humidity should be below 85%.
- Good ventilation is required in confined areas to ensure proper curing.

Mixing

- Apcothane CF 678 FD is supplied on two packs. Stir the base and hardener separately. If settling is observed in the base or hardener, loosen the settled material with the help of hand stirrer followed by power driven stirrer for quick homogenous mixing.
- Mix hardener gradually into the base under continuous stirring as per the mixing ratio. Once the unit has been mixed, it should be consumed within the working pot life. In case of part mixing (which should be avoided), close the lids of containers tightly to avoid contact with atmospheric moisture.
- Thinner should be added after mixing the components and post the induction time. Addition of too much thinner will lead to reduced sag resistance.

Mixing Ratio	: Base: Hardener
(By volume)	: 4: 1
Induction Time	: 15 minutes
Pot life at 30°C	: 2 hours

Application

Brush/Roller

Recommended thinner	: T 213
Volume of thinner	: 0 - 10 %

Air Spray

Recommended thinner	: T213
Volume of thinner	: 15 - 45 %
Nozzle Orifice	: 1.5 - 3.00 mm
Nozzle Pressure	: 0.3- 0.4 MPa (= approx. 3-4 atm; 43-57p.s.i.)

Airless Spray

Recommended thinner	: T 213
Volume of thinner	: 5 - 15 %
Nozzle orifice	: 0.28 - 0.33 mm
Nozzle pressure	: 10-13 MPa (= approx. 100-130 atm; 1400-1800p.s. i)

Cleaning:

- Do not allow the product to remain in hoses, gun, or spray equipment. Clean all equipment's immediately after use with Thinner T 213. It is recommended to periodically flush out spray equipment during the course of the working day. The frequency of cleaning will depend on amount sprayed, temperature and time gap.
- All surplus material and empty containers should be disposed of in accordance with appropriate regional legislation.

Product Characteristics

- DFT of 40-50 microns per coat can be achieved by brush application and more than 40-50 microns per coat can be achieved by spray application. For certain shades in red, yellow, and orange, by brush application, 2 coats may be required to give complete hiding especially when applied over dark undercoats.
- The gloss, sheen and finish are dependent on the application method. The best gloss and finish are achieved by conventional spray application.
- Apcothane CF 678 FD must be thinned with the recommended thinner only. Usage of alternate thinners will affect the curing process.
- Premature exposure to condensation and rain may cause color and gloss change.

OVERCOATING:

- Apcothane CF 678 FD can be applied on most epoxy primers and polyurethane/powder coating /undercoats as recommended by Asian Paints representative.
- Apcothane CF 678 FD can be top coated with itself.

PACK SIZE	20 ltr (Base: 16 ltr & Hardener: 4 ltr)
STORAGE	Shelf Life: at least 9 months @ 30° C for original unopened pack, subject to inspection thereafter. Store in a cool, dry place and in accordance with local regulations
REGULATORY INFORMATION	Flash point Base: Not less than 24°C Hardener: Not less than 24°C
	VOC 390-420 gm/ ltr (depending on shades) as per USA-EPA Method 24
	Product Weight 1.02-1.12 kg/ ltr (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapor or paint mist and contact of liquid paint with skin & eyes, should be avoided. Forced ventilation should be provided when applying paint in confined spaces or stagnant air. Even when ventilation is provided, respiratory, skin and eye protection are always recommended when spraying paint.
- Please refer our Material Safety Data Sheet prior to using the product.

Disclaimer:

To the best of our knowledge the information provided herein are true and accurate at the date of issuance. Since we have no control over the quality or condition of the substrate or the various factors affecting the use and application of the product, we do not accept any responsibility or liability arising out of use of the product. The company reserves the right to modify data contained herein without prior notice. Any change in data would normally be followed by issue of a new datasheet. The user should check with the nearest sales office of the company and confirm the validity of the information, prior to using the product.

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