

APCOFINE 910



PRODUCT DESCRIPTION

Two component high build, high solid, super durable polysiloxane coating

FEATURES & RECOMMENDED USE

- High performance acrylic modified isocyanate free topcoat designed to provide dual benefits of corrosion protection and weatherability
- Excellent gloss & colour retention
- Excellent corrosion resistance
- Good chemical resistance towards splash & spillage
- Can be applied directly over inorganic zincs

TECHNICAL DATA

Colour	Range
Gloss	Glossy
Volume Solids	Approx. 70 ± 3%
Recommended DFT / Coat	75 - 125 µm
Theoretical Coverage Capacity	9.33 sq.mtr/l @ 75 µm 5.60 sq.mtr/l @ 125 µm
Drying time at 30°C	Surface dry : 4 hour Hard dry : 5 hours Full cure : 7 days
Over coating interval at 30°C	Min. : 5 hours Max. : 5 days, provided surface is cleaned from all contamination

The data given is for guideline only. The physical values are subject to normal manufacturing tolerances, colour 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

DIRECTIONS 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

Blast Cleaning

- Steel, abrasive blast clean to min. Sa 2.5 Swedish specification prior to priming
- Surface should be clean, free from oil and grease before abrasive blasting
- A blasting profile of (Rz) 40-75 µm is recommended

Primed Surfaces

- Apcofine 910 is recommended over anti-corrosive coating scheme. Apcofine 910 is recommended over inorganic/organic zinc primers and epoxy/polyurethane intermediates. All surfaces to be coated should be clean, dry and free from contaminants
- Ensure that the zinc primed surfaces are free from zinc salts. Ensure zinc primers are fully cured before over coating. To minimise pinholes while top coating over zinc primers, apply a mist coat as the first pass of the subsequent coat, let the entrapped air escape and then apply full coat
- The over coating intervals on re-recommended primers and intermediates are dependent upon actual primer/intermediate used

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

- Apcofine 910 is supplied in two packs. Stir the base and hardener separately. If settling is observed in the base, 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 excessive thinner will lead to reduced sag resistance

Mixing Ratio (By volume)	Base : Hardener 9 : 1
Induction Time	15 minutes
Pot Life at 30°C	2 hours

Application

Application: Brush / Roller Recommended thinner Volume of thinner	T - 131 0 - 5 %
Air Spray Recommended thinner Volume of thinner Nozzle Orifice Nozzle Pressure Cleaning Thinner	T - 131 0 - 15 % 1.5 - 3.00 mm 0.3- 0.4 MPa (= approx 3-4 atm; 43-57 p.s.i.) T - 131
Airless Spray Recommended thinner Volume of thinner Nozzle orifice Nozzle pressure Cleaning Thinner	T - 131 0 - 10 % 0.41 - 0.53 mm (16 – 21 Thou) 16 - 20 MPa (= approx. 160-200 atm ; 2300 -2800 p.s.i) T - 131

Cleaning

- Do not allow the product to remain in hoses, gun or spray equipment. Clean all equipment's immediately after use with Thinner T - 131. 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

- When applying by air spray / brush, it may be necessary to apply multiple coats to achieve the total specified dry film
- Level of sheen and surface finish is dependent on application method. Best results in terms of gloss and appearance will be always obtained with conventional air spray application
- As common with all polysiloxane coatings, special care must be taken when applying multiple coats of Apcofine 910 to ensure that a continuous wet film is applied. Failure to do so may result in pin holing which will downgrade appearance and performance
- Condensation occurring during or immediately after application may result in matt finish and an inferior film.
- Pot life time must not exceed even though the material may be still liquid and appear usable. Failure to comply with this will result in film with inferior performance
- The product is not recommended for use in immersion condition
- The coating has been designed to give best protection when applied under controlled application parameters & as per given system recommendation

Note: It is recommended to mix a complete unit in the proportion supplied and can be used with in the pot life specified

PACK SIZE	10 L (Base: 9 L & Hardner: 1 L)
STORAGE	Shelf Life: At least 12 months at 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: 290 ± 25 gm/l (depending on shades) as per USA-EPA Method 24 Product Weight: Approx. 1.25 ± 0.05 kg/l (depending on shades)

SAFETY INFORMATION

- As a general safety measure, inhalation of solvent vapours 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 data-sheet. 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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