

Corroless ACO Twin Pack Repair Kit

(formerly Acothane Twin Pack Repair Kit)

Product Description	A solvent free, two pack polyurethane mastic repair kit for the repair of small defects in pipeline coatings.					
Features & Use	<ul style="list-style-type: none">• Packaged in a polythene bag, divided by a plastic clip, and sealed in an aluminium foil pack• For small area repairs to most types of pipe coatings, including FBE, 3LPE, 3LPP and polyurethanes• Outstanding mechanical properties and rapid cure characteristics together with excellent adhesion to most pipe coating materials.					
Approvals/ Certification	<ul style="list-style-type: none">• Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection• Meets the performance requirements of BS EN 10290 and AWWA C222• Malaysian SPAN approved• Approvals held in the former name of ‘Acothane’					
Finish	Sheen					
Volume Solids	100%					
VOC Content	0 g/litre					
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage		
	Typical	0.5 mm	0.5 mm	0.07 m²/pack		
	Typical	5 mm	5 mm	0.007 m²/pack		
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 1 mm DFT		+10°C	+20°C	+30°C	+40°C
	Dust Free		40 min	15 min	5 min	3 min
	Hard Dry		1½ hr	40 min	20 min	5 min
	Overcoating		40 min	15 min	5 min	3 min
	Full Cure		7 days	6 days	5 days	4 days
	Drying and recoating times are related to the surface temperature					
Colours	Beige					
Mix Ratio/ Product Code	10ATP Base 3 parts by volume Hardener 1 part by volume					
Pot Life	approx. 5 min at 25°C					
SG	1.31 kg/lt mixed					
Storage Conditions	Store in dry, cool conditions and protect from frost					
Shelf Life	Minimum 48 months if stored as above in unopened containers					
Flash Point	Above 60°C					

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Surface Preparation	<ul style="list-style-type: none">All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seamsSteel: blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u>Overlap onto existing Corroless ACO coating: remove any loose material to establish a firm edge. Feather sound coating and abrade surface to provide a key. Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disk grinding etc.)Concrete: remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of <16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer				
Mixing	Remove outer foil wrapper. Remove plastic clip. Mix the contents of the pack by thoroughly working the components in the plastic bag together for at least 2 minutes. Remove corner of bag and dispense. See Corroless ACO Twin Pack Mixing Instructions				
Thinner / Cleaner	Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
Application Conditions	Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.				
Application Methods	Method	Airless Spray	Conventional Spray	Brush	Roller
		See below			
	<ul style="list-style-type: none">Use plastic divider or spatula to apply				
Product Notes	<ul style="list-style-type: none">Activator contains isocyanates – refer to Safety Data SheetIn-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuousOvercoating - abrading will be required if overcoating after 24 hoursCorroless ACO Twin Pack has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice				
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.				

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