

Dulux Acrathane IF Two Pack High Gloss

AUDI1102




Specifications	AS/NZS 3750.5
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Description
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 does not pose a health threat when used in accordance with occupational health guidelines.

Features And Benefits	
<ul style="list-style-type: none"> • Excellent anti graffiti coating • Good abrasion resistance and toughness • High gloss finish 	<ul style="list-style-type: none"> • Excellent weathering and chemical resistance • Isocyanate free • Lower gloss finishes achievable with Dulux Flattening Base

Uses
ACRATHANE IF has good gloss and colour retention making it suitable for mobile equipment. Due to its excellent chemical resistance it is suitable to use as the topcoat in chemical plants, oil platforms and refineries.

Performance Guide			
Weatherability	Good gloss and colour retention on exterior exposure.	Salts	Unaffected by splash and spillage of neutral and alkaline salt solutions.
Heat Resistance	Up to 100°C dry heat.	Water	Excellent resistance to fresh and salt water but not suitable for immersion.
Solvents	Resists splash and spillage of most organic solvents.	Abrasion	Good when fully cured.
Acids	White and colours are suitable for splash and spillage of mild acids.	Alkalis	Good resistance to splash and spillage of most common alkalis.

Typical Properties			
Classification	Two Component Catalysed Acrylic	Finish	High gloss
Colour	Broad colour range including Dulux Colour Atlas and AS2700 colours	Components	2
Flash Point	16°C	Pot Life	6 hours (4L, 25°C)
Shelf Life	1 year if stored in suitable conditions	Mixing Ratio (V/V)	Part A : 4 Part B : 1
Thinner	Brush - Duthin 040 (965-42166), Spray - Urethane Thinner (965-63023)	Suitable Substrates	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF.
Line/Shade	<ul style="list-style-type: none"> • White/Light Base 446-63001 • Deep Base 446-63002 • Clear Base 446-63003 • LF Golden Yellow 446-39141 • Black 446-00070 • Clearcoat Gloss 446-30900 • Sparkling Aluminium 446-81814 • Hardener 976-51087 	Primers	Most Dulux two pack primers. Refer to precaution section.
Product Code	PC218		
Application Methods	 Air Spray  Airless Spray  Brush		
Application Conditions		Min	Max
	Air Temperature	10°C	45°C
	Substrate Surface Temperature	10°C	45°C
	Relative Humidity		85%
	Solids By Volume	43	
		Min	Max
	Wet Film Per Coat (microns)	115	165
	Dry Film Per Coat (microns)	50	70
	Recoat Time (min)	8 Hours	INDEFINITE
	Theoretical Spread Rate (m²/L)	8.7	6.1
Typical Properties Notes	*When applying over epoxy primers and intermediates ensure that the application is carried out within 24 hours of applying the epoxy.		

Typical Systems

Typical System EXTERIOR STEEL

Preparation Guide Abrasive blast AS1627.4 Class 2.5

Coat	Product	Spread Rate (m ² /L)	WFT (micron)	DFT (micron)
1st Coat	Zincanode 402	6.4	155	75
2nd Coat	Duremax GPE - Pc255	5.7	175	125
3rd Coat	Acrathane IF	7.2	140	60
Minimum System DFT				260

Typical System INTERIOR STEEL

Preparation Guide Abrasive blast AS1627.4 Class 2.5

Coat	Product	Spread Rate (m ² /L)	WFT (micron)	DFT (micron)
1st Coat	Durepon P14 Primer	7.0	140	75
2nd Coat	Acrathane IF	7.2	140	60
Minimum System DFT				135

Typical System ALUMINIUM or FIBREGLASS

Preparation Guide Clean, degrease and abrade surface.

Coat	Product	Spread Rate (m ² /L)	WFT (micron)	DFT (micron)
1st Coat	Luxepoxy 4 White Primer	8.6	125	50
2nd Coat	Acrathane IF	7.2	140	60
Optional	Acrathane IF	7.2	140	60
Minimum System DFT				170

Notes For a reduced gloss finish, refer to the DULUX FLATTING BASE Product Data Sheet

Application Guide

Application Method	Conventional, Airless or Air Assisted Spray
Brush/Roller	Suitable for small areas only. Where larger areas are to be coated, 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. Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels and application technique. The effect achieved by brush and roller will differ greatly from that obtained by spray application. When brushing and rolling additional coats may be required to attain the specified thickness.
Conventional Spray	Thin up to 200ml/litre with Dulux Urethane Thinner (965-63023) to aid atomisation. Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels, film build, spraying technique and gun set-up. Typical Set-up: Graco Delta Gun 1.4mm (239542) Pressure at Pot: 70-100 kPa (10-15 p.s.i.) Pressure at Gun: 380-410 kPa (55-60 p.s.i.)
Airless Spray	Standard airless spray equipment such as a Graco 30:1 President 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.
Precautions	This is an industrial product designed for use by experienced Protective Coatings applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux Representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux Australia. Freshly mixed material must not be added to material that has been mixed for some time. 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. All surfaces to be coated must be totally free of moisture and contaminants. Note – When applying Sparkling Aluminium, colour and appearance are dependent on thinning levels, film build, application method and technique. Control of these parameters is especially important when coatings are used on broad, flat areas.
Clean Up	Clean all equipment with Dulux Urethane Thinner (965-63023) immediately after use.

Overcoating

The surface must be free of oil, grease and other contaminants. Abrasive blast cleaned surfaces must be primed within 4 hours and before recontamination. Ensure that in all circumstances epoxy primers and intermediates are topcoated within 24 hours of applying the epoxy. Do not overcoat before the minimum overcoat interval or wrinkling may occur. If the maximum overcoat interval is exceeded then the surface must be lightly abraded to ensure maximum intercoat adhesion. Aged coating should be tested for lifting by a method suitable to the coating thickness, for example 'X' cut or crosshatch methods. If it lifts, remove it. Remove all loosely adhering chalk and dust by high-pressure water wash at 8.3 to 10.3 MPa (1,200 - 1,500 p.s.i.) Abrasion may be required depending on surface condition.

Health And Safety	
Safety Precautions	Read Data Sheet, Safety Data Sheet and any precautionary labels on containers.
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 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.
Using	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 spray painting, users should comply with the provisions of the respective State Spray Painting Regulations.
Flammability	This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight 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
In the case of emergency, please call 1800 033 111	

Transport And Storage			
Packaging	Available in 4 litre and 20 litre packs	Transportation	1.13 kg/litre (Average of components)
Dangerous Goods Part A			
Class	3	UN Number	1263
Dangerous Goods Part B			
Class	3	UN Number	1263

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