

ACRATHANE® IF

Isocyanate Free High Gloss Catalysed Acrylic Finish

PC 218

- FEATURES**
- EXCELLENT ANTI GRAFFITI COATING
 - GOOD WEATHERING AND CHEMICAL RESISTANCE
 - GOOD ABRASION RESISTANCE AND TOUGHNESS
 - 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 excellent chemical resistance, it is suitable as the topcoat 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

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

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two Component Catalysed Acrylic		APPLICATION CONDITIONS			
FINISH	High Gloss			Min	Max	
COLOUR	White, Golden Yellow, Black, full range of tinted colours and MTO factory made colours. Also available in Clearcoat†. Also available in Sparkling Aluminium†		Air Temp.	10°C	45°C	
COMPONENTS	Two		Substrate Temp.	10°C	45°C	
VOLUME SOLIDS	43% (White)		Relative Humidity		85%	
VOC LEVEL	<520 g/L (White, untinted)		FILM THICKNESS (MICRONS)			
FLASH POINT	15°C			Min	Max	Recommended
POT LIFE	6 hours (4 litre kit, 25°C)		Wet film per coat (µm)	115	165	140
MIXING RATIO V/V	Part A : 4	Part B : 1	Dry film per coat (µm)	50	70	60
THINNER –BRUSH	965-42166 Duthin® 040		SUITABLE SUBSTRATES	Suitably primed steel, aluminium, zinc coated steel, concrete, fibreglass or MDF		
THINNER –SPRAY	965-63023 Dulux® Urethane Thinner		PRIMERS	Most Dulux® two pack epoxy primers (must be applied within 24 hours of applying the epoxy)		
PRODUCT CODE	446-63001	White/Light Base	APPLICATION METHODS	Conventional, airless spray or air assisted spray		
	446-63002	Deep Base				
	446-63003	Clear Base				
	446-39141	Golden Yellow				
	446-00070	Black				
	976-51087	Hardener				

† See separate Product Data Sheets

DRYING CHARACTERISTICS AT 60 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
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.

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

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

SURFACE PREPARATION	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.
APPLICATION	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.
BRUSH/ROLLER	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.
CONVENTIONAL SPRAY	Thin up to 200ml/litre with Dulux® Urethane Thinner (965-63023) to aid atomisation.
AIRLESS SPRAY	Typical Set-up Graco AirPro Pressure at Triton 308: 70-100 kPa (10-15 p.s.i.) Pressure at Gun: 380-410 kPa (55-60 p.s.i.) 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.
PRECAUTIONS	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.
CLEAN UP	Clean all equipment with Dulux® Urethane Thinner (965-63023) immediately after use.
OVERCOATING	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.
SAFETY PRECAUTIONS	Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEETS are available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au
STORAGE	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.
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 spraying, users must comply with their 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, CO ₂ 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.

COMPANY INFORMATION

Dulux Protective Coatings a division of

DuluxGroup (Australia) Pty Ltd
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DuluxGroup (New Zealand) Pty Ltd
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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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