

### Product Description

A two components non yellowing aliphatic polyurethane coating based on acrylic polyol and aliphatic polyisocyanate system without free isocyanate monomer in paint film.

### Features

- Excellent durability in wide range of corrosive environment.
- Easy to use – spray, brush, roller
- Excellent physical properties such as impact, toughness and abrasion resistance.
- Excellent weathering properties.
- Suitable for finish coat of anti corrosive coating system.
- Suitable to use as duplex system and can apply direct to single pack film galvanising metallic coating.

### Typical Uses

Suitable for use as finish coat in anti corrosive coating system in both new building, repair and maintenance system for concrete and steel structures, such as rooftop, roof tiles, silo storage tanks, accommodation of ships and off-shore structures, external of tanks and bridges.

### Physical Data

Color	:	As specified
Flash Points	:	Base : 23.0 °C Hardener : 29.5 °C
Volume Solid	:	60+/- 2%
VOC(as supplied)	:	400 g/L
Shelf Life @25°C / indoor	:	24 months

Typical Thickness : 40 ~ 80µ dried film.

Drying Time(at Dry Film Thickness 75µ)	Temperature	10°C	20°C	30°C
	Surface Dry	40mins	30mins	20mins
Hard Dry	12 hrs	8.0 hrs	6.0 hrs	
Painting interval:	Minimum	12 hrs	8 hrs	6.0 hrs
	Max. (self)	-	-	-
Pot Life		7.0 hrs	5.0hrs	3.0hrs
Theoretical coverage (at DFT 40- 80µ)		0.07~0.133 L/m <sup>2</sup> ; 14.3 ~ 7.5 m <sup>2</sup> /L		
Service temperature		-60 to 150°C (dry)		

### Application Data

Mixing ratio : Base : hardener = 83 : 17 ( by weight)  
Application Method : airless spray, roller, brush

Mixing Procedure : Add part B into part A and power mix for at least two minutes or until homogeneous.

Drying schedule : Drying by solvent evaporation and chemical cross linking. Higher film thickness, insufficient ventilation, or lower temperature will require longer drying time. Excessive humidity or condensation on the surface can interfere with the drying cause discoloration and may result in a surface haze. Any haze or contamination must be removed by water washing before recoating.

This product requires the substrate temperature to be above the dew point (+ 3~5 °C). Condensation due to substrate temperatures below dew point can cause flash rust on metal and adhesion will be affected.

### Application Procedure

Mix properly the paint before use.

- Flush equipment with polyurethane thinner before use.
- Mix the paint (part A and Part B accordingly to mixing ratio) thoroughly until homogeneous.
- Thin with Hana Thinner U only if necessary for workability.
- When applying by conventional spray, use adequate air pressure and volume for proper atomisation.
- Apply a wet coat in even parallel passes, overlap 50% to avoid holidays and pin hole.
- Excessive thickness can prolong drying and sagging.
- Clean up all equipment with thinner immediately after use.
- Keep containers tightly close and store in proper storage area.

### Condition of Application

Use brush or roller with 1/8" nap . Apply at sufficient thickness and avoid repeating rolling to have good levelling.

Temperature : Min 5 °C ; Max 50 °C  
Humidity : Maximum 85 % R.H.  
For Airless spray :-  
Tip Size : Graco 515, 615 or equivalent

Paint Output : 14.7 – 23.5 MPa (g)  
pressure  
Viscosity : 30 ~ 50 sec ( Ford Cup)  
Thinning : 0 – 15 % by volume

### Surface Preparation

**General :**

Surfaces must be clean and dry, all contaminants like dirt, dust , oil must be remove by appropriate method to ensure good adhesion.

**Abrasive blast clean**

Abrasive blast clean to Sa 2.5 (ISO-8501) or SSPC-SP6. In case of hydro blasting or hydro jetting to remove existing coating, ginger rust should be remove and blow dry before application. Surface profile must be a minimum of 50 microns.

**Shop primed steelwork**

Weld seam and damaged area should be cleaned to a minimum St3 or SSPC-SP3. The shop primed steelwork should be repair for any rust and free from any contaminant with suitable secondary surface preparation such as spot blast , sweeping or power tooling.

### Performance Data

Properties	Test Method	Evaluation
Adhesion Strength	ASTM D3359-09	24/25 5A
Salt Spray ( 5% NaCl solution)	ASTM B117	1500hrs , passed C5M , as system
Humidity (50 °C, 100% RH)	ASTM D1748	1000hrs , passed C5M , as system

### Safety Precaution and Clean-up

**Safety :** Read and follow the material safety data sheet (MSDS) before use. Employ normal safety precaution. Put on necessary personal protection equipment when handle and use this product.

**Ventilation :** when working in a confine workplace, thorough air ventilation must be used during and after application until the coating is cured. The ventilation system should be effective to prevent solvent vapour concentration from reaching lower explosion limit for the product

and to ensure exposure limit to the personnel to be below permissible exposure limit.

**Caution :** All electrical equipment and installations should be made and properly grounded. In area where explosion hazard exist, workmen should be used non-ferrous tools, conductive and non-sparkling shoes.

**Clean-up :** Use Hana Paint polyurethane thinner (Hana Thinner U) or hydrocarbon solvent for cleaning. Observe safety precaution when use the solvents. In case of spillage, absorb and dispose the material and used container according to local required regulation or through licence waste collector.

**Disclaimer**

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**Limited Warranty**

Whilst we endeavour to ensure that all advice we give about this product is correct and manufacture according to standard quality control system, however we have no control over either the quality or condition of the substrate or many other factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of the product or for any loss or damage arising out of the use of this product.