

Rocathaan Hotspray PA 270-FR

Description and application

Highly reactive and solvent-free hotspray coating, based on aromatic polyurea. Due to its quick-curing, any shape can be coated seamlessly.

Developed as a protection and sealing material for industrial applications. The product has a very low curing shrinkage and a low exothermic characteristic.

Article number and packaging

19270-20	41,5 kg set
19270-200	467,5 kg set
	4,5 kg Prokol Hotspray Color Pasta

Properties

- Stays elastic with low as well as high temperatures
- Low curing shrinkage
- Low exothermic characteristic.
- Resistant to low and high temperatures

Elongation	± 220% (DIN 53504)
Tensile strength	± 7,3 MPa (DIN 53504)
Shore hardness	A85 ± 5 (DIN 53505, ASTM D2240)
TG value	1,000
Fire class	B2 (DIN 4102-1)

Properties liquid product

Colour	Available in RAL colours, see colour overview. <i>Other colours are available on project basis and on request.</i>
Density	1,18 kg/l mixed product
Volume solids	100%
VOC quality	0 g/l
Flash point	>100 °C
Shelf life	At least 12 months after the date of production, if stored in unopened packaging between 15 – 20 °C.

Application information

Is processed with multi-component (hotspray) high pressure equipment using a suitable spray gun. This equipment must be adjusted for the product to be sprayed and capable of supplying sufficient pressure. The spray temperature and layer thickness strongly influence the reaction time, curing and treatment.

Reaction time	12 - 15 seconds
Tack free	30 - 120 seconds
	<i>Depending on the set values and the surface.</i>
Spraying temperature	• A (Base) 85 °C • B (Hardener) 85 °C • Hose 78 – 82 °C
Spraying pressure	- AP Gun 180 – 200 bar - CS Gun 140 – 160 bar
Usage	1,12 kg/m ² /mm <i>On form-retaining surfaces 2 mm and on bitumen and polyurethane foam 2.5 mm. The applied layer thickness determines the final properties and must be adjusted to the purpose.</i>
Mixing chamber	Oval pattern
Mixing ratio	1:1 in volume
Surface temperature	+5 °C and +30 °C
Open time*	With the same product: Almost directly and max. within 24 hours Solvent free: min. 24 and max. 36 hours Solvent-containing: min. 3 and max. 36 hours. <i>Open times can decrease as the temperature rises. When exceeding the open time, the existing layer must be sanded and provided with a suitable primer.</i>
Chemical resistant*	After 7 x 24 hours
Mechanical resistant*	After 2 x 24 hours
Dilution	Not permitted
Cleaning agent	Roca Cleaner N6500-P (equipment)
Rinsing agent	Roca Cleaner TC-N

* At 20 °C and 65% RH surface.
** At 1 kg and 20 °C product.



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Mixing instructions

The temperature of the materials in the drums need to be at least 15 °C with a maximum of 35 °C.

If the materials are too cold, use the heaters of the spraying equipment to heat them up.

Be aware! Start by mixing the A (base) component intensively for 20 minutes before starting heating and circulating the materials through the pump. Use a Twistork-helix mixer to obtain a homogeneous mixture.

The mixing time depends on the size of packaging. A 200 liter drum, used for the first time or after a longer storage period, should be mixed intensively for 45 minutes. Following this, short and thorough mechanical mixing at every turn is sufficient.

Non-homogenous mixed products lead to deviating features in the end-result subsequently. In addition, after a few weeks or months, amine or isocyanate residues can also get into the coating.

Notes during application

Do not inhale spray mist. Ensure respiratory equipment designed for the conditions is worn while spraying.

The reaction temperature of the product partly depends on the surface temperature. If thicker layers are desired, first providing the surface with a thin layer is advised. The reaction heat that is created during this process makes it possible to apply several layers one after the other.

2-component products may only be applied when the relative humidity is less than 85%. Condensation on the surface reduces the adhesion. The minimum environment and surface temperature is +5° C and the temperature of the surface to be treated and the uncured product must be 3° C above the dew point. See the dew point table.

Surface and circumstances

In general

The surface needs to be dry and have a closed structure without pores. With most surfaces, an appropriate primer or webbing will be necessary. In that case, read the technical product sheet of the product in question.



Moisture content surface

- cement-bound : < 4% CM (parts by weights)
- plaster-bound : < 0,5% CM (parts by weights)

There are various types of surfaces. Some of which have their own individual pre-treatment requirements. If in doubt, getting in contact with your supplier is advised.

For detailed information regarding pre-treatment of the surfaces, please see the "surface pre-treatment" information sheet.

Bituminous roofing

A surface must be clean, dry, free of grease and free of loose parts. In some cases, a primer may be necessary. Refer to the primer table.

Wooden surfaces

Wooden surfaces need to be closed in nature. Pressed materials are preferred, as they can hardly contain any moist. In some cases, a primer may be necessary. Refer to the primer table.

Mineral surfaces

The surface must be healthy, with a minimum compression strength of 25 MPa and a minimum adhesion strength of 1,5 MPa. The surface must be clean and free of grease. All loose components must be removed. Concrete and anhydrite needs to be at least 28 days old.

Any cement skin must be removed. Monolithic floors must be sanded and any dust must be removed. Surfaces with dirt pickup, or loose sand-cement screeds (e.g. bomb ice) can be removed, for example by blasting and making the surface dust-free.

Clean contaminated and greasy surfaces (oil and grease), preferably with a steam cleaner, using a suitable cleaning agent. Rinse well with clean tap water. If this does not result in a clean, load-bearing surface, blasting should be performed.

A primer, gel or screed will be necessary. In that case, read the technical product sheet of the product in question.

Metal surfaces

Metal surfaces need to be blasted Sa 2,5, 75 -80 microns and treated with a primer with anti-corrosion properties.

* At 20 °C and 65% RH surface.
** At 1 kg and 20 °C product.



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Important

Projects and applications can vary greatly. Always contact your supplier if you have doubts about a certain application, choice of material or surface treatment.

All the technical information given in this technical information sheet is based on laboratory tests. Information can change, depending on the conditions.

Legal notification

The information and, in particular, the recommendations concerning the application and final use of Prokol products is issued in good faith based on Prokol's current knowledge and experience of products that are correctly stored, handled and applied under normal conditions.

In practice, the differences in materials, surfaces and local conditions are such that no guarantee can be given concerning the marketability or suitability for a certain objective, nor can any liability arise from any legal relationship based on this information, nor from any written recommendations or other advice that is given. The property rights of third parties must be respected.

Prokol guarantees that its products are free from manufacturing faults. Multi-component products are a finished product once the components have been mixed and processed. When mixed and processed correctly, the product will achieve the specifications given. Prokol can only guarantee the product when surfaces are processed and pre-treated correctly.

All orders are accepted under the current sales and delivery conditions. Users must always refer to the most recent product safety information sheet and product information sheet for the product concerned.

Copies of the most recent editions are provided upon request and are available at www.prokol.com.

The publication of this product information sheet makes all previous product information sheets for this product invalid.

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