

Rocathaan Hotspray PA 410

Description and application

Hotspray coating based on pure, aromatic polyurea. The longer flow time of this product allows to realize smoother surfaces.

The product is used as a coating for molds and other surfaces where a smooth surface is desired. Rocathaan Hotspray PA 410 is also suitable for coating metals, various closed grain wood varieties and for coating EPS, XPS and other hard types of insulation.

Article number and packaging

19410-20	40 kg set (already on colour)
19410-200	447,5 kg set (colourless product)
	4,5 kg Prokol Hotspray Color Pasta

Properties

- Pure polyurea
- Large layer thickness reach
- Relative long wet phase to reach a smooth surface

50% Modulus	4,5 MPa
100% Modulus	5,9 MPa
200% Modulus	8,3 MPa
Elongation	± 475% (DIN 53504)
Tensile strength	± 14,7 MPa (DIN 53504)
Shore hardness	A93 ± 5 (DIN 53505, ASTM D2240) D44 ± 5 (DIN 53505, ASTM D2240)
Wear resistance taber	64 mg 1000 cycles, 1000 g load, CS17
MU Value	1000
Fire class	B2 (DIN 4102)

Properties liquid product

Colour	Available in RAL colours, see colour overview. <i>Other colours are available on project basis and on request.</i>
Density	1,12 kg/l mixed product
Volume solids	100%
Flash point	>80 °C
Shelf life	At least 12 months after the date of production, if stored cool in unopened packaging and protected against frost.

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	1 – 2 minutes
Tack free	15 – 20 minutes
Spraying temperature	65 – 85 °C
Hose temperature	65 – 85 °C
Spraying pressure	<i>Depending on the type of pistol and mixing chamber.</i> <ul style="list-style-type: none">- Fusion CS gun 135 – 140 bar- Fusion AP gun 160 – 180 bar
Usage	1,12 kg/m ² /mm
Mixing ratio	1:1 in volume
Surface temperature	+5 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 2 x 24 hours
Mechanical resistant*	After 3 hours
Dilution	Not permitted
Cleaning agent	Roca Cleaner N6500-P (equipment)
Rinsing agent	Roca Cleaner TC-N

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.



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



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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.

Notes during application

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

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

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.

The surface must be free from pressure or rising water from the subsoil.

Moisture content surface

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

If a topcoating is going to be applied as a finishing layer, it must be suitable for the purpose and elasticity of the surface.

With most surfaces, a primer will be necessary. In that case, read the technical product sheet of the product in question.

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.

Aromatic products are not fully colour/UV-proof and will slightly decolourise when exposed to UV light. If this is not desired, adding a aliphatic topcoating as finish layer based on the elasticity of this product is advised.

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

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.

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



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

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