Rocathaan Hotspray PA 610-S



Highly reactive hotspray coating based on full-fledged aromatic polyurea technology. This product has a very high Shore hardness with a large degree of elasticity. Once cured, a hard top layer is formed with a good balance between impact resistance and elasticity. This is especially important with projects and works of art where heavy loads and vandalism can have an impact. Due to the longer gel time, this product can be sprayed smooth and, if desired, sanded after complete curing.

Rocathaan Hotspray PA 610-S is suitable for coating metals, various closed grain wood varieties and for coating EPS, XPS and other hard types of insulation.

Article number and packaging

19610-20 38,50 kg set (already on colour) 19610-200 447,50 kg set (colourless product) 4,5 kg Prokol Hotspray Colour Pasta

Properties

- Good chemical resistance
- No toxic vapours
- · Excellent thermal stability

Elongation	180% (DIN 53504)	
Tensile strength	20 MPa (Din 53504)	
Shore hardness	D70 ± 5 (Din 53505, ASTM D2240)	
MU Value	1000	/
TG Value	140 °C	
Temp, performance	- 30 °C till 150 °C	

Properties liquid product

Colour	Available in RAL colours, see colour overview.
	Other colours are available on project basis and on request.
Density	1,12 kg/l mixed product
Volume solids	100%
VOC quality	0 g/kg
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. Products should always be placed on pallets to avoid direct contact with the floor.

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	8 – 10 seconds	
Tack free	30 - 45 seconds	
Spraying temperature	80 - 80 °C	
Hose temperature	80 - 80 °C	
Spraying pressure	Depending on the type of pistol and mixing	
	chamber.	
	- CS Pistool 130 – 140 bar	
	- AP Pistool 150 - 180 bar	
Usage	1,12 kg/m²/mm	
	The applied layer thickness partially	
	determines the properties and must be	
	adjusted to the purpose.	
Handling	3–10 minutes	
	Depending on the thickness of the layer	
	applied and the surface temperature.	
Mixing ratio	See the label on the packaging	
Surface temperature	+5 and +30 °C	
Open time*	Solvent free: max. after 3 hours	
	Solvent-containing: min. 3 and max. 36	
	hours.	
	The subsequent layer is to be applied within	
	this time. 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.	
Chemical resistant*	After 7 x 24 hours	
	Each Prokol product has varying levels of	
	resistance to specific chemicals. Chemical	
	concentrations are complex and are	
	strongly influenced by the environment and	
	temperature. Contact Prokol technical	
	support for specific recommendations.	
Mechanical resistant*	After 3 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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For detailed information regarding surface pre-treatments, please consult the information sheet "Surface Pre-treatment".

Application and circumstances

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.

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.

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.

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.

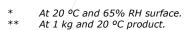
In practice, the differences in materials, surfaces and local conditions are such that no guarantee can be given concerning the marketability or suitability for a certain objective, nor can any liability arise from any legal relationship based on this information, nor from any written recommendations 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.

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.

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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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Liquid synthetic materials for a sustainable future