

# Rocathaan Hotspray PU 660-S

## Description and application

Highly reactive, solvent-free hotspray coating based on high-quality, aromatic, bi-component, polyurethane technology. Once cured the coating will be hard and sandable.

Rocathaan Hotspray PU 660-S is used for coating metals, various closed grain wood varieties and for coating EPS, XPS and other hard types of insulation.

## Article number and packaging

19660-20	41 kg set (already on colour)
19660-200	461,5 kg set (colourless product)
	4,5 kg Prokol Hotspray Color Pasta

## Properties

- Solvent-free
- Sandable after 30 minutes
- Bi-Polyurethane technique

Elongation	68% (DIN 53504)
Tensile strength	12,8 MPa (DIN 53504)
Shore hardness	D60 ± 5 (Din 53505, ASTM D2240)
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	1,05 kg/l mixed product
Volume solids	>99%
Flash point	>100 °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	15 - 20 seconds
Tack free	3 minutes <i>Depending on the applied layer thickness and the surface temperature.</i>
Spraying temperature	80 – 85 °C
Spraying pressure	<i>Depending on the type of pistol and mixing chamber.</i> - AP Pistol 150 – 180 bar
Usage	1,05 kg/m <sup>2</sup> /mm <i>The applied layer thickness partially determines the properties and must be adjusted to the purpose. Values are given from 2,5 mm.</i>
Mixing ratio	1:1 in volume
Sandable	After 30 minutes <i>Depending on the applied layer thickness, surface and temperatuur.</i>
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 7 x 24 hours
Mechanical resistant*	After 3 x 24 hours
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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Liquid synthetic materials for a sustainable future

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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.

## 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

A surface must be dry, clean and free of grease. Preferably, a surface with closed structure. The surface must be able to meet the function for which it is used. Pre-treat the surface and apply a suitable primer if necessary.

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.

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



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.

## 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](http://www.prokol.com).

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

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



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