

Rocathaan Hotspray PA 695-DTM

Description and application

A highly reactive hotspray based on full-fledged aromatic polyurea technology. This product is designed as a tough, impact resistant coating applied in one single coat, with no need of a primer, directly onto metal substrates. Once cured, a hard top layer is formed with excellent chemical and mechanical resistance. It has also good application properties providing an aesthetic finish.

Rocathaan Hotspray PA 695-DTM is designed for long term protection against corrosion and mechanical damages, of steel, galvanized steel and ductile iron structures, for external use, for above and below ground. It's typically used as a coating for metal poles, tanks, pipelines, oil/water separators, wastewater structures and utility structures.

Article number and packaging

19695-20	39,45 kg set (already on colour)
19695-200	447,50 kg set (colourless product)
	4,5 kg Prokol Hotspray Color Pasta

Properties

- Good chemical resistance
- No toxic vapours
- Excellent thermal stability
- Excellent adhesion on metal, without a primer
- Outstanding impact resistance

Elongation	180% (DIN 53504)
Tensile strength	20 MPa (Din 53504)
Shore hardness	D70 ± 5 (Din 53505, ASTM D2240)
Impact resistance	EN 12206 on 2 mm standard steel > 100 N/m
MU Value	1000
TG Value	140 °C
Temp. performance	- 30 °C till 150 °C

Results DTM	Water test	Adhesion test
Galvanised blasted 30-35 microns	Nb	17,6 MPa
Standard steel blasted 30-35 microns	Nb	17,3 MPa

Nb = No Blistering

Water test: one week 65 °C hot water

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%
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. Drums 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	75 – 80 °C
Hose temperature	75 – 80 °C
Spraying pressure	<i>Depending on the type of pistol and mixing chamber.</i> - CS gun 130 – 140 bar - AP gun 150 – 180 bar
Usage	1,12 kg/m ² /mm <i>The applied layer thickness partially determines the properties and must be adjusted to the purpose.</i>
Handling	3–10 minutes <i>Depending on the thickness of the layer applied and the surface temperature.</i>
Mixing ratio	1:1 in volume
Minimum DFT	600 microns <i>Contact Prokol technical support for specific recommendations.</i>
Surface temperature	+5 and +30 °C
Open time*	Solvent free: max. after 3 hours Solvent-containing: min. 3 and max. 36 hours. <i>The subsequent layer is to be applied within this time. Open times can decrease as the temperature rises. When exceeding the</i>



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open time, the existing layer must be sanded and provided with a suitable primer.

Chemical resistant*	After 7 x 24 hours <i>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.</i>
Mechanical resistant*	After 3 x 24 hours
Dilution	Not allowed
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.

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

Abrasive blasting with suitable media to remove surface contamination and to create an anchor profile. Rocathaan Hotspray PA 695-DTM has been especially optimised for minimal blasting profiles

- Profile standard steel : 30-25 microns
- Profile galvanised steel : 30-35 microns

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.

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.

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.



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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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