

# Rocathaan Hotspray PA 895-XWR

## Description and application

Highly reactive, solvent-free and very durable hotspray coating, based on high-quality, aromatic, polyurea technology. Due to its quick-curing, any shape can be coated seamlessly. Once cured, a fairly hard top layer is formed with a good balance between impact resistance and elasticity.

For use as an extremely abrasion resistant coating on various types of industrial components, e.g. pump housings, silos, chutes, concrete buckets within the offshore and dredging industry and sand and cement industry.

## Article number and packaging

19895-200 452 kg set

## Properties

- Extremely wear resistant
- Remains elastic
- No or hardly any adherence of product residues

Elongation	± 330% (DIN 53504)
Tensile strength	± 22,8 MPa (DIN 53504)
Shore hardness	A82 ± 5 (DIN 53505, ASTM D2240)
Wear resistance taber	<ul style="list-style-type: none"><li>• 0 g 1000 cycles, 1000 g load, CS17</li><li>• 130 mg 1000 cycles, 1000 g load, CS18</li><li>• 183 mg 6000 cycles, 1000 g load, CS17</li><li>• 490 mg 6000 cycles, 1000 g load, CS18</li></ul>
MU Value	1000
Fire class	B2 (DIN 4102-1)

## Properties liquid product

Colour	Grey
Density	1,06 kg/l mixed product
Volume solids	100%
VOC value	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.

## 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	70 – 85 °C
Hose temperature	70 – 85 °C
Spraying pressure	<i>Depending on the type of pistol and mixing chamber.</i> <ul style="list-style-type: none"><li>- Fusion CS gun 130 – 140 bar</li><li>- Fusion AP gun 150 – 180 bar</li></ul>
Usage	1,06 kg/m <sup>2</sup> /mm <i>The layer thickness strongly depends on the application. Contact Prokol technical support for specific recommendations.</i>
Mixing ratio	1:1 in volume
Surface temperature	Minimum +5 °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 <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 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, after which amine or isocyanate residues can also appear in the coating after a few weeks or months.

## 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

### In general

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

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



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.

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.

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

## Steel surfaces

The surface must be free of substances which may have a negative influence on adhesion, such as oil and grease. If these types of substances are present, they must first be removed with the appropriate agents and/or tools

Surface blasting, Sa 2,5, 75 -100 microns, DIN EN ISO 12 944. Then thoroughly remove all dust. Formation of surface rust must be avoided at all times.

## 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 must 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. Afterward, rinse well with 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.

Aromatic products are not fully colour/UV-proof and will slightly decolourise when exposed to UV light.

## 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.

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



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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.

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