ROTHANE HG 777

Product Description

Two component general purpose aliphatic iso cyanate cured acrylic finish.

Product characteristics

- Polyurethane finish for steel and concrete structures for atmospheric exposure.
- Easy to apply by spray, roller or brush.
- Excellent color retention.
- General purpose in protective coating systems for steel metals.
- Good abrasion resistance.
- Resistant to splash and spillage of mild chemicals and solvents.
- Good adhesion properties on steel structures.
- Good U.V resistance.
- Good resistance to water.
- Cured at temperatures down to -5 °C.
- Very good resistance to chemicals and water.

TECHNICAL DATA

Color	as the customer request
Gloss	high gloss
Specific gravity at 20 °C (g / Cm³)	1.25
Flash point (DIN 53213)	base 40°C & hardener 30°C.
Solid content	approx. 62% ± 2 by volume.
Theoretical spreading rate	11 m²/Kg for 50 microns DFT.
Thinner	No. 600 (Roots thinner)
Mixing ratio (by weight)	5:1
Pot life at 10 °C (hours)	3
Pot life at 20 °C (hours)	2
Pot life at 30 °C (hours)	1/2
Over coat interval min	12 hrs.
max	no limitation

Minimum hardening temperature (ºC)	5
Traversable at 20 ºC (hours)	4
Thorough hardened at 20 ºC (days)	4
Storage life in months at 20 ºC	12
Directions for application	Substrate must be free of rust, dirt and grease. mix the hardener thoroughly with the base. Mixture ratio is indicated on packages, and content of each tin is adapted. Ready for application with brush or roller. For conventional spray equipment: Dilute with 5-10 % of thinner. For airless spray equipment: Dilute with 2 – 5 % of thinner. Nozzle opening: 0.015" – 0.017"Clean equipment with thinner no RO 600.

- **METHODS OF APPLICATION**

  - **BY AIRLESS SPRAY:**

Nozzle orifice	0.015" – 0.018"
Nozzle pressure	180 – 200 bar
Volume of thinner	0 – 10 %

  - **BY AIR SPRAY:**

Nozzle orifice	2 – 3 mm
Nozzle pressure	3 – 4 bars.
Volume of thinner	5 – 15 %

  - **By Bruch and roller** — For small area.

Volume of thinner	0 – 5 %

  - **Surface preparation :**

• New steel	Sand blasting to Sa 2.5
• Maintenance	Remove dust, oils and grease, etc. remove all rust and loose materials by wet or dry abrasive blasting or power tool cleaning then apply a new coat as desired.

Additional data

Max dft without sagging with airless spray : 100 µm.

Min dft for closed film with airless spray : 50 µm

Max dft when brushing : 40 µm

Curing table

substrate temperature	Dry to handle	full cure handle
20 º C	6 hours	7 days
30 º C	5 hours	5 days
40 º C	3 hours	3 days