

# Corroless ACO Mastic Grade TG

(Formerly Acothane Mastic Grade TG)

<b>Product Description</b>	<b>A solvent free, two pack polyurethane mastic</b> for steel, for application at higher temperatures.				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>Use for the coating of field joints, repair of damaged coatings, filling of holes and cracks, on steel pipelines and other steel structures</li> <li>This TG grade is specifically developed for use at higher ambient temperatures and on hot substrates</li> </ul>				
<b>Approvals/ Certification</b>	<ul style="list-style-type: none"> <li>Meets the requirements of GBE/CW6 Part 1 for External Pipe Protection</li> <li>BS6920 Factory and site application and WRAS water fittings directory</li> <li>Meets the performance requirements of BS EN 10290 and AWWA C222</li> <li>Malaysian SPAN approved</li> <li>Approvals held in the former name of 'Acothane'</li> </ul>				
<b>Finish</b>	Sheen				
<b>Volume Solids</b>	100%				
<b>VOC Content</b>	0 g/litre				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Typical</b>	0.75 mm	0.75 mm	1.3 m <sup>2</sup> /litre	
	<b>Typical</b>	1.5 mm	1.5 mm	0.67 m <sup>2</sup> /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
<b>Drying Times</b>	Applied to 1.0 mm DFT	<b>+20°C</b>	<b>+30°C</b>	<b>+40°C</b>	
	<b>Dust Free</b>		1 hr	45 min	30 min
	<b>Hard Dry</b>	(Back Fill)	4 hr	2 hr	1 hr
	<b>Overcoating</b>		1 hr	45 min	30 min
	<b>Full Cure</b>		7 days	6 days	5 days
Drying and recoating times are related to the surface temperature					
<b>Colours</b>	Grey, Cream and a limited range of other shades				
<b>Mix Ratio/ Product Code</b>	<b>10AMS-T</b> (base) and <b>10ACT</b> (activator) Base      3 parts by volume      3.23 parts by Weight Hardener 1 part by volume      1 part by Weight				
<b>Pot Life</b>	25 min at 25°C, approx. 8 min at 40°C				
<b>SG</b>	1.29 kg/lit mixed				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 24 months if stored as above in unopened containers				
<b>Flash Point</b>	Above 60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> <li><b>Steel:</b> blast clean to minimum Sa2½ (ISO 8501-1:2007), surface profile depth 75-100µm. Mechanical tools may also be used providing a profile of minimum 75µm. <u>Do not polish the steel surface</u></li> <li><b>Overlap onto existing Corroless ACO coating:</b> remove any loose material to establish a firm edge. Feather sound coating and abrade surface to provide a key. Thoroughly abrade to remove gloss, surface contaminants etc. by suitable method (sweep blasting, abrasive disk etc.)</li> <li><b>Concrete:</b> remove all laitance and other contaminants by most appropriate methods. Ensure the concrete is dry to a reading of &lt;16% on the Wood Moisture Equivalent (WME) scale. Prime with Corroless ACO LV Sealer</li> </ul>										
<p><b>Mixing</b></p>	<p>Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Activator must be added to base and thoroughly mixed to ensure an even mix throughout the container – at least 2 minutes mixing time is recommended. Care must be taken to avoid unmixed material being left on sides and bottom of can. Decanting mixed material into a plastic container and further mixing is recommended. Plastic container may be recovered for further use when coating has cured.</p>										
<p><b>Thinner / Cleaner</b></p>	<p>Do not thin / Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)</p>										
<p><b>Application Conditions</b></p>	<p>Do not apply when rain, mist, sleet or snow are imminent. Normal application requires relative humidity below 80%. To avoid risk of condensation, application should be performed only when the steel surface temperature is at least 3°C (5°F) above the dew point. Application at temperatures below 1°C (33°F) must be carefully monitored, since the possible presence of ice on the surface (or in pores, in the case of concrete) will result in poor performance.</p>										
<p><b>Application Methods</b></p>	<table border="1" data-bbox="483 1081 1524 1176"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>No</td> <td>No</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table> <ul style="list-style-type: none"> <li>Designed for application by brush, roller, putty knife, trowel or spatula</li> </ul>	Method	Airless Spray	Conventional Spray	Brush	Roller		No	No	Yes	Yes
Method	Airless Spray	Conventional Spray	Brush	Roller							
	No	No	Yes	Yes							
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li><b>Activator contains isocyanates</b> – refer to Safety Data Sheet</li> <li>Overcoating - normally after 1 hour and within 24 hours of initial application. Abrading will be required if overcoating after 24 hours</li> <li>In-service temperature limits: Wet – 0°C to 70°C depending on solution; Dry – minus 20°C to + 120°C continuous</li> <li>In order to comply with WRAS certification, a minimum cure time of 14 days at 7°C is required before contact with drinking water</li> <li>Corroless ACO Mastic TG has excellent adhesion to abraded Fusion Bonded Epoxy (FBE), and suitably prepared 3LPE and 3LPP. Please consult Axalta Coating Systems for technical advice</li> <li>Can be used in operations requiring fast cure, e.g. lay barge, weld coating and encapsulation of anode connectors, coating repair prior to trenching/backfilling. Corroless ACO Mastic Standard should be used for less speed-critical coating operations and at lower temperatures (e.g. below 25°C)</li> </ul>										
<p><b>Health &amp; Safety</b></p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>										

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