

ELASTOCOAT[®] AC 74000R RESIN ELASTOCOAT[®] AC 74000T ISOCYANATE

Scope:

- This guideline defines the application requirements for ELASTOCOAT[®] AC 74000R Resin / ELASTOCOAT[®] AC 74000T Isocyanate, a 2:1 mix ratio by volume, two-component, zero VOC, 100% solids, polyurethane based, elastomeric coating used for the protection of steel and associated fittings.
- ELASTOCOAT[®] AC 74000R / ELASTOCOAT[®] AC 74000T can be applied in either factory or field environments.
- Pipe substrates may include, elbows, tees, valves, miscellaneous appurtenances, rehabilitation and repair areas.
- Contact your BASF representative with question concerning additional application details.

Requirements:

- The guidelines and standards presented in this document are to be used solely as a guideline. BASF recommends that a copy of this Application Guideline be made available at the application site, at all times, and that all employees involved in the application of ELASTOCOAT[®] AC 74000R / ELASTOCOAT[®] AC 74000T understand these guidelines.
- The following standards shall be included as part of this guideline.

SSPC-SP1	Solvent Cleaning
SSPC-SP10/NACE No.2	Near-White Metal Blast Cleaning
SSPC-SP11	Power Tool Cleaning to Bare Metal
SSPC-VIS-1-89	Pictorial Surface Preparation Standard
RP0287-2002	NACE Standard Recommended Practice for Field Measurement of Abrasive Blast Cleaned Surfaces Using Replica Tape
SP0188-2006	NACE Discontinuity (Holiday) Testing of New Protective Coatings on Conductive Substrates
AWWA C-222	Polyurethane Application

Surface Preparation:

- All parts should be visually inspected before blast cleaning.
- Any rough welds or sharp projections should be ground smooth.
- Any deposits of oil, grease or other organic contaminants should be removed by using a solvent wash.
- All surfaces to be coated should be completely dry, free of moisture, dust, grit, oil, grease or any other contaminants in accordance with SSPC-SP1.
- The temperature of the substrate must be at least 5°F (3°C) above the dew point temperature.
- A near-white blast, SSPC-SP10/NACE No.2 and 3-4 mil profile is recommended. The blast medium used should be clean, dust-free, hard, sharp and angular.
- Cleaned surfaces should be air blasted, brushed off or vacuumed to remove all dust and debris prior to coating and shall be coated before any rust blooming occurs. Any cleaned steel showing rust stains must be re-blasted prior to coating.

Material Preparation:

- Prior to use, the materials should be stored in accordance with the parameters listed in the Technical Product Data Sheet.
- The resin material, ELASTOCOAT® AC 74000R should be agitated, via an approved mixer, in its original container for a time period not less than 30 minutes prior to use. In the event any material sits for a time period in excess of 4 hours or more, the resin material should be agitated for the 30 minute time period.
- Opened drums of resin and isocyanate must be protected from moisture contamination.

Application Equipment:

The polyurethane should be applied by a 2:1 by volume, plural component, high-pressure metering machine. The machine must be capable of maintaining component temperatures of at least 150°F (66°C) at the spray gun, as well as operating pressures up to 3000 psi. An impingement mix, airless spray gun with changeable spray tips, which allow for the optimization of the spray pattern, will be required.

Application Guidelines

Machine:	GlasCraft MHR-VR or equivalent
Spray gun:	GlasCraft Probler 2 or equivalent*
Mix Chamber:	01
Fan Tip:	36/40
Mix Ratio – Parts by Volume:	200 Resin to 100 Isocyanate
Component Temperatures:	150°F Resin/Isocyanate
Component Pressures:	2,000 psi Resin/2,100 psi Isocyanate
Gel Time:	90 seconds**

*Gun and tip combinations are influenced by part geometry, desired finish, and other factors and should be determined by the applicator.

**These items are nominal at the resin and isocyanate temperatures listed above. Reactivity can be influenced by the temperature of the components, the temperature of the substrate, coating thickness, and environmental conditions.

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Coating Application:

ELASTOCAST® AC 74000R / ELASTOCOAT® AC 74000T should be applied according to the guidelines listed herein:

- No thinning of the material is allowed.
- All coating thickness should be set by the engineer or end user. A minimum coating thickness of 25 mils is required for ELASTOCOAT® AC 74000R / ELASTOCOAT® AC 74000T. Coating thickness should be measured and recorded in a manner acceptable to the end user
- Environmental conditions, substrate preparation and material requirements should follow the guidelines listed in this document as well as on the ELASTOCOAT® AC 74000R / ELASTOCOAT® AC 74000T Technical Product Data Sheet.
- Spray application should be done in a manner that is uniform, continuous and free of runs and sags.
- Refer to the ELASTOCOAT® AC 74000R / ELASTOCOAT® AC 74000T Technical Product Data Sheet for specifics related to the cure time required before placing the system into service.

Inspection and Testing:

- The finished part should be visually inspected for any defects (i.e. cracks, blisters, pin holes or uncoated areas).
- Coating thickness should conform to the minimum listed in the guideline, as well as the engineering requirements.
- Holiday testing should be conducted in accordance with SP0188-2006 NACE Discontinuity (Holiday) Testing.

Coating & Joint Repair:

The approved product for coating repair is Elastocoat AC 74000 Repair System (See the repair system application guide). Please contact your BASF representative for more information.

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