

# URESTOP TF

Two-component, solvent free, fast drying, non-modified polyurethane coating

## NATURE AND USE

Two-component non-modified polyurethane coating solvent free, high build. The product can be applied only with dual feed hot bi-mixer equipment. Urestop TF has been studied for the external protection of steel works facing important chemical and mechanical stresses and it is used as external coating of pipes, tanks, valves and special pieces to be buried or submerged.

The film, fully cured even if characterized by good elasticity, is hard, tenaciously adhering and provides good resistance to abrasion and to impact. Its permeability to water is very low and it provides a good resistance to cathodic disbonding.

The product, thanks to its rapid cross-linking/drying properties, allows fast coating application at high thickness in one coat only.

**NB:** Like all the materials of this nature and typology, also the polymerised film of URESTOP TF, when externally exposed (sun, rain, etc.) has the tendency to change colour and to opacify chalking: These phenomenon are only aesthetical ones and do not involve any loss of corrosion protection affecting the coating whose properties are unchanged.

The product is certified according to EN 10290 Specification

## TECHNICAL DATA



Specific Gravity A+B	kg/l	1,30 ± 0,05 @ +20°C
Solids by Weight and Volume:	%	100 ± -1% A+B
Mixing Ratio by Weight:		77 parts of Base / 23 parts of Hardener
Mixing Ratio by Volume:		3 parts of Base / 1 part of Hardener
**Pot life @ +20°C:		~ 5 – 10 minutes
Temperature resistance:		from - 20°C to + 60°C with peaks up to +80°C
		➤ Continuous operating Temperature (in absence of mechanical stress to the coating): -20°C / +80°C
		➤ Limit Temperature (only short periods, in absence of mechanical stress to the coating and with no temperature gradient compared with the substrate): -30°C / +110°C
		➤ Transport and handling: -30°C / +50°C
		➤ Construction and assembly operations: -30°C / +50°C
		➤ Storage of the coated item: -30°C / +60°C
Colour		Black
Appearance of the cured film		Glossy

## SUBSTRATE PREPARATION

**All kind of substrates:** Degrease and decontaminate. After roughening, thoroughly remove dust. Make sure all the substrates to coat are always perfectly dry.

**Steel:** Sandblast the substrate according to ISO 8501/1 SA 2.5 for steel. Suggested roughness profile: Rz Din ≥ 70 µm up to 200 µm according to ISO 8503.

## PRODUCT PREPARATION

Homogenize separately either the Base and the Hardener in their own supply container. Pour each component in the suitable stocking tank of the bi-mixer equipment. Heat at the necessary temperature until the perfect atomization of the product during spray is reached

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\*\* The "POT LIFE" time of two components products (time within which it is possible to apply the paint mix of Base and Hardener), is exponentially dropped by the increase of product temperature.  
Note: The use of a mix of paint (Base + Hardener) over the POT LIFE time is irreparably compromising all the properties of the coating film.\*\*

## APPLICATION DETAILS

<b>Application method:</b>	Dual Feed Hot Airless Spray for two-component with compression ratio 60:1 minimum Automatic premixing of the components at the spray nozzle. It is allowed the separate pre-heating of each component as well as of the substrate to coat
<b>Indicative Nozzle diameter:</b>	0,018 ÷ 0,028 inches (mm. 0,45 – mm. 0,71)
<b>Indicative Nozzle pressure:</b>	250 - 300 Kg/cm <sup>2</sup>
<b>Thinning:</b>	None – Do not thin
<b>Cleaning:</b>	Thinner PUR11 Wash the whole application equipment immediately after use
<b>Hardening @ +20 / +25°C:</b>	Dust dry ~ 30 - 60 minutes Touch dry ~ 4 – 6 hours Complete curing 7 - 10 days
<b>Overcoating interval @ +20/25°C:</b>	Min. 1 / Max. 8 hours according to the substrate to be coated and its temperature
<b>Indicative Preheating temperature:</b>	+40/+65°C (Base) / +20/+45°C (Hardener)
<b>Temperature of the substrate:</b>	> +5 / +65°C always at least +3 / 5°C abovedew point
<b>Humidity:</b>	< 80%
<b>Suggested thickness per coat:</b>	Between 500 and 2000 µm dry (DFT) (depending on the item to be coated and on the preheating temperature of Base and Hardener)
<b>Theoretical spreading rate:</b>	sqm/Kg 0,71 at a thickness of 1000 µm dry (DFT)
<b>Theoretical use:</b>	Kg/sqm ~ 1,4 at a dry film thickness of 1000 µm DFT

## HANDLING STORAGE AND SAFETY PRECAUTIONS

**Warning:** All handling and/or use activities of the material and its components must strictly refer to the given indications in the Safety Data Sheet (Base and Hardener). The following advices are stated by common sense and in good faith, they are uncompleted and do not substitute the content of each specific safety data sheet of the product.

**Handling:** The material must be used only by professional and qualified applicators suitably trained. All the operations involving the use of the product, must be carried on in compliance with all the relevant National Health, Safety & Environmental standards and regulations.

**Precautions:** When the product is used in enclosed areas (rooms, containers, vessels, etc.) it is imperative to use adequate means providing the necessary air circulation, to be granted during the whole application and coating polymerization time, also to avoid conditions open to potential explosion danger.

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All electrical installations must always be grounded. Where explosion hazards exist, the workmen should be required to use only non-ferrous tools and wear conductive non-sparking shoes and clothing. Explosion and flame-proof equipment too are required.

**Storage and transport:** Keep far from flames, sparks or heat sources. Do not leave exposed under direct solar action. Store under shelter in original unopened packaging, in cool, dry and ventilated areas, at temperatures between +5°C and +35°C.

**Shelf life:** **Base** 12 months in the suggested storage conditions (original unopened packaging)  
**Hardener** 6 months in the suggested storage conditions (original unopened packaging)

N.B.: **Product for professional use only and exclusively for the uses not regulated under CE Directive 2004/42/CE.**

**Refer to Material Safety Data Sheet**

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## COMPLEMENTARY INFORMATIONS

### GENERAL RECOMMENDATIONS FOR THE USE OF URESTOP TF FOR APPLICATION ON STEEL SUBSTRATES

- Make sure the choice of the product is done considering the final uses of the finished item (suitability to the exercise conditions, etc.)
- Make sure the substrate is perfectly cleaned, degreased and contaminants free. Perfectly dried and humidity free considering that some substances of the product are particularly sensible to humidity.
- Sandblast the substrate according to ISO 8501/1 minimum SA 2,5 for steel (better SA 3). Suggested roughness profile minimum Rz Din 70 µm and max 200 µm according to ISO 8503 (...parameter to be checked more than one time, during the normal work shift.
- Thoroughly remove the dust from the substrate using dry compressed air dehumidified.
- At the end of the cleaning and preparation operations, check with appropriate instruments that the substrate is completely dried and apply the product immediately.
- Do not exceed 4 hours from preparation of the substrate to apply the product ( R.H ≤80%). Repeat the previous operations of sandblasting and cleaning if the time is exceeded .
- For application of the product, use a hot twin-feed Bi-mixer with automatic mixing at the head (or not, according to the pre-heating temperatures of the base and hardener). Before using the product, make sure the automatic cleaning of the equipment is fully operating. The cleaning operation must be done any time the application is stopped or suspended as well as in all the situations recommended by the manufacturer of the Bi-mixer equipment.
- Check and practically verify before spraying the coating that the correct mixing ratio of Base and Hardener are kept (better to check by weight):

#### Mixing Ratio URESTOP TF

<b>By weight</b>	<b>Base 77pp</b>	<b>Hardener</b>	<b>23pp</b>
By volume	Base 3p	Hardener	1p

Maximum Tolerance (allowance) allowed in errors: 3%  
calculated on the correct mixing ratio of base and hardener

- Check during coating the mixing ratio is not affected by changes.
- Make sure that the temperature of the substrate is always minimum +3/+5°C above the dew point.
- The components of the product do not need to be thinned and can be pre-heated at temperatures of +40 / +65°C for the Base and +20 / + 45°C for the Hardener.
- The suggested thinner for tools cleaning is our type Thinner PUR11

We draw your attention on the recommendations of the Technical Data Sheet  
Contact our Technical Department for further information

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