

<b>Moravia</b>	<b>TEKNİK BİLGİ FORMU</b>	Doküman No / Rev.	TDS 091 / 00
		Tarih	23.10.2013
		Sayfa No	1 / 2



**Moravia**  
Marine Coatings

## MORACRYLIC HI-BUILD

### Product Description

Moracrylic HI-BUILD is a two-component, acrylic polyurethane based topcoat with high volume solid and aliphatic isocyanate curing. It has perfect colour and gloss retention. Resistance to humidity, UV and chemicals is excellent.

### Intended Uses

With suitable primer, it can be used for a long time for every surface in very hard atmosphere conditions. Especially it is a part of a recommended system which is applied for steel industry where high anticorrosive protection is needed.

### Physical Properties

<b>Physical State</b>	: Liquid
<b>Colour</b>	: Various
<b>Volume Solid (%)</b>	: 64 ± 2
<b>Density</b>	: 1,45 ±0,02 kg/L
<b>Gloss</b>	: Glossy (70-80 Gloss)
<b>VOC</b>	: 319 g/L
<b>Flexibility</b>	: Flexible

### Application Data

<b>Mixing Ratio (weight)</b>	: 87 units Part A / 13 unit Part B (partial mixing is not recommended)
<b>Mixing Ratio (volume)</b>	: 16,5 units Part A / 3,5 units Part B (partial mixing is not recommended)
<b>Application Methods</b>	: Airless spray, conventional spray, brush and roller.
<b>Application Conditions</b>	: The temperature of the substrate should be minimum 3°C above the dew point of the air. Good ventilation is required.
<b>Thinner/Cleaner</b>	: Moravia 012 Thinner

### Guiding data for airless spray

<b>Pressure at nozzle</b>	: 15 MPa (150 kp/cm <sup>2</sup> 2100 psi)
<b>Nozzle tip</b>	: 0.38-0.53 mm (0.015-0.021")
<b>Spray angle</b>	: 40-80°
<b>Filter</b>	: Check to ensure that filters are clean.

	Dry (µm)	Wet (µm)	Theoretical Coverage (m <sup>2</sup> /L)
<b>Typical film thickness</b>	75	117	8,53
<b>Maximum thickness</b>	120	188	5,33

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### Surface Preparations

All surfaces to be coated should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

#### **Steel surface**

Blast-cleaning to Sa 2½ (ISO-8501). Power tool cleaning to min. St 2 (ISO 8501) may be acceptable, subject to exposure conditions.

#### **Coated surface**

Clean, dry and scatheless suitable lining. Please contact Moravia office for further information.

### Drying Time

Substrate Temperature	Pot Life (max)	Touch Dry	Hard Dry	Over coating Data	
				Minimum	Maximum
10°C	8 hours	16 hours	24 hours	16 hours	-
23°C	1,5 hours	6 hours	9 hours	6 hours	-
30°C	1 hours	4 hours	6 hours	4 hours	-

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

**Packing Size** : 20 L

### **Storage**

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated area and away from source of heat and ignition. Containers must be kept tightly closed.

### **Health and Safety**

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

**For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.**

**Disclaimer:** The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.