

Application Guide



Humidur® E by *Brush or Plural Spray*

Health & Safety



Surface Preparation

Step 1: Remove fouling, dirt and salts by powerwash

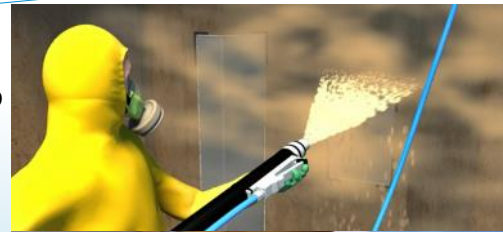


Step 2: Degrease the surface



Step 3 - option 1:

Gritblast the surface by abrasive blasting to Sa2,5 (ISO 8501) and roughness $\pm 60\mu\text{m}$



Step 3 - option 2:

Minimal prep. with powertools to roughen the surface to St 2 or St 3 (ISO 8501)



Step 4: Remove dust and clean with fresh water



Step 5: Clean with cleaning agent



Step 6: Check surface preparation

Check for salts (Bresle)
ISO 8502-6



Check the roughness
ISO 8503-2



Check for dust
ISO 8502-3



Acotec nv

LET'S FACE CORROSION

Industrielaan 8
Zuid III
9320 Erembodegem (Aalst)
Belgium

T: +32 53 83 86 60
F: +32 53 83 69 88
M: info@acotec.be
W: www.acotec.be & www.humidur.be

Date: 12/10/2015

Pg. 1/3

Application Guide



Humidur® E by *Brush or Plural Spray*

Health & Safety



Coating Application

Step 7: Delivered in pre-dosed pails (A and B)
Check the labelling: mixing ratio weight: 4,03:1

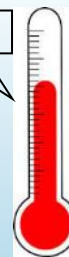


35°C - 40°C

Step 8: Temperature non-mixed in warm water bath
Humidur E: 18°C - 25°C

Step 9: Transport the pails in an insulated box to the area to be coated. In this way the paint will not cool down.

18°C - 25°C



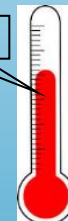
Step 10: Empty component B into A and mix for 3 minutes
Plural spray: this step can be skipped



3 min.

Step 11: Temp. after mixing E: 30°C-35°C

30°C-35°C



Step 12: Temp. surface > dew point + 3°C
No condensation is allowed!



Acotec nv

LET'S FACE CORROSION

Industrielaan 8
Zuid III
9320 Erembodegem (Aalst)
Belgium

T: +32 53 83 86 60
F: +32 53 83 69 88
M: info@acotec.be
W: www.acotec.be & www.humidur.be

Date: 12/10/2015

Pg. 2/3

Application Guide



Humidur® E by *Brush or Plural Spray*

Health & Safety



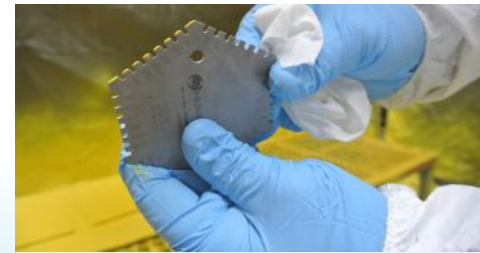
Coating Application



Step 13: Apply the product by: - Brush
- Plural airless min. 60:1

Step 14: Check the wet layer thickness during application
Consult your Acotec representative for required thickness

$$\text{WFT} = \text{DFT}$$



Step 15: Allow curing
At 20 °C: 12 hours
Capable of curing under water

Final Results:



Interior crude oil storage tank



Steel supporting parts in subway stations



Interior hydropower pipeline



Offshore crane structure

Acotec nv

LET'S FACE CORROSION

Industrielaan 8
Zuid III
9320 Erembodegem (Aalst)
Belgium

T: +32 53 83 86 60
F: +32 53 83 69 88
M: info@acotec.be
W: www.acotec.be & www.humidur.be

Date: 12/10/2015

Pg. 3/3