

# Application Guide



Humidur® FP Plural by Plural Spray

## Health & Safety



## Surface Preparation

**Step 1:** Remove fouling, dirt and salts by powerwash

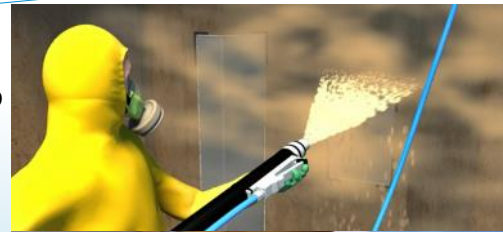


**Step 2:** Degrease the surface



**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

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Date: 12/10/2015

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## Coating Application

**Step 7:** Delivered in pre-dosed pails (A and B)  
Check the labelling: mixing ratio weight: 4,0:1



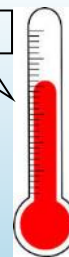
**Step 8:**

Temperature non-mixed in warm water bath

Humidur FP Plural: 50°C - 60°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.

50°C - 60°C



**Step 10:**

Temp. surface > dew point + 3°C

No condensation is allowed!



**Step 11:** Apply the product by Plural airless min. 60:1



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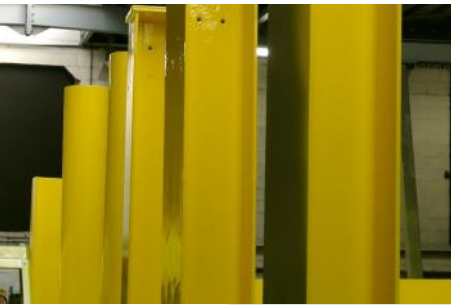
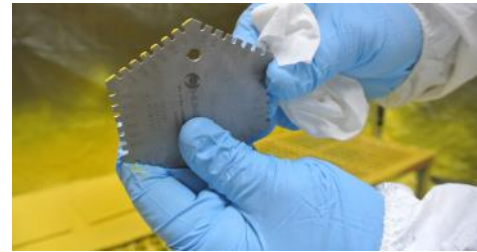
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## Coating Application

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

$$WFT = DFT$$



Allow curing  
**Step 15:** At 20 °C: 24 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

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