



Humidur[®] FP Single by Brush, Single 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

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Application Guide



Humidur® FP Single by Brush, Single or Plural Spray

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Coating Application

Step 7: Delivered in pre-dosed pails (A and B)
Check the labelling: mixing ratio weight: 5,0:1

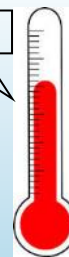


35°C - 40°C

Step 8: Temperature non-mixed in warm water bath
Humidur FP Single: 35°C - 40°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.

35°C - 40°C



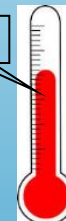
Step 10: Empty component B into A and mix for 3 minutes
Plural spray: this step can be skipped



3 min.

Step 11: Temp. after mixing FP Single: 35°C

35°C



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



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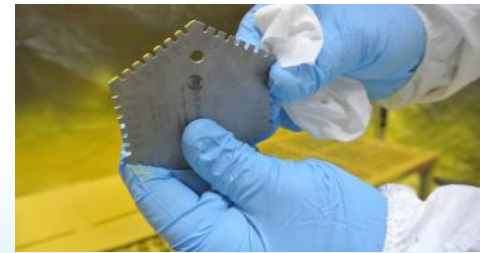
Coating Application



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