

Description: HDLINE 1000 is a two-component, Solvent free, high gloss acrylic polyurethane coating with excellent corrosion and water resistance.

Recommended use: As a finishing coat for protection of external of pipeline and underground storage tank. It gives fast curing with good adhesion and abrasion resistance properties.

PHYSICAL CONSTANTS:

Colour/Shade nos:	Red brown, Blue, Grey
Finish:	Glossy (75 - 100 Units at 60°)
Volumesolids,%:	100%
Theoreticalspreadingrate:	0.78 m ² /litre - 1500micron
Specificgravity:	1.8 g/cm ³
Dry film thickness:	1300-1500 micron in one coat
Drytotouch:	30-45 minutes at 25°C
Fullycured:	4-5 days at 25°C

APPLICATION DETAILS:

Mixingratio:	Base : Hardener
1 : 1 (By volume)	
Application method:	Application with twin feed hot airless spray
Thinner(max.vol.):	None
Potlife:	5 minutes(20°C/68°F)
Nozzleorifice:	.023"-.032"
Nozzlepressure:	150 bar/2200psi Pumping viscosity is achieved at 45°C – 65°C.
Temperature range:	Temperature in the mixing pot is 65°C – 70°C
Temperature of nozzle:	60°C
Cleaningof tools:	UNILAY PU Thinner
Induction Time :	None
Indicated film thickness, dry:	1500 micron

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult UNILAY Material Safety Data Sheets and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin and eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well ventilated areas.

APPLICATION AND CURING CONDITIONS: The surface must be completely blast clean ISO –Sa 2 ½, blasting profile is 45 – 75 micron and the temperature of substrate is above 15° C and 3°C above the dew point. lower temperature will reduce flow properties.

PRODUCT DATASHEET

HDLINE 1000



Filmthicknesses: May be specified in another film thickness than indicated depending on purpose and area of use. This will alter spreading rate and may influence drying time and recoating interval. The minimum range for closed film is 250-300 micron

Recoating : For good intercoat adhesion it is necessary that a coated surface which should be repaired or completely recoated is roughened up by means of sweep blasting..

Drying/curing time:

Surface temperature	10°C/50°F	30°C/68°F	50°C/86°F
Touch Dry	2Hrs	20 Min	5 Min
Dry to Handle	4Hrs	45 min	10 min
Fully cured, 70% RH	8 days	24 hrs	12 hrs

Shelf Life : Min. 6 months. Store in a dry place and keep the can tightly closed until use.

Notes: Mixed material will become insoluble within a few minutes after mixing at 60°C. Parts of spraying equipment containing mixed base and hardener must be cleaned immediately after completion of job.

This Product Data Sheet supersedes those previously issued.

Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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