

Acrydur™ - 522 N (USA)

Low-viscous, slightly blue
methacrylic resin for hard sealings

PLASTI CHEMIE
Produktionsgesellschaft mbH

Characteristics: Acrydur™ 522 N is a newly developed hard methacrylic resin of low viscosity that is preferably used as a sealer for Acrydur™ coatings in order to improve heavy mechanical and scratch resistance as well as maintenance. The main application areas are trowel-smoothed industrial floors made of Acrydur™ 510 N and Acrydur™ 418 N.

Acrydur™ 522 N excels in:

- improved self-leveling qualities
- minimal yellowing
- high scratch resistance by using hardener/M
- excellent chemical resistance
- high thermal endurance
- low tendency to staining

Characteristic data:

Delivery form	liquid, blue
Flow time	26 - 32 sec (68°F) DIN flow cup, 4mm
Curing	20 - 30 min (68°F)
Shelf life	In the original container, dark at < 65°F maximum 6 months
Bundle	396.83 lb drums 55.12 lb, 22.05 lb pails

Processing Notes:

Processing: Stir up well all Acrydur™ resins before application! Pour the required preparation quantity into a mixing pail and stir in hardener 50W for about 1 min by using a suitable agitator. Acrydur™ 522 N is preferably applied crosswise with short hair rollers (mohair) in a layer thickness of up to 0.4 mm max (~ 14.11 oz/ft²). Layer thickness must at least be 0.2 mm (5.22 oz/ft²) and should not exceed 0.5 mm (13.04 oz/ft²) with 2 layers – depending on the required coating structure (smooth or coarse).

Special remarks: After stirring in the hardener, the sealer is poured out onto the floor and immediately dispersed evenly. Sealings with Acrydur™ 522 N should not be applied onto coatings with Acrydur™ 332 N as the coating's high flexibility in combination with the very hard sealer Acrydur™ 522 N might cause cracking on loading.

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Hardener concentrations of > 2 % may cause discolorations (yellowing). Furthermore a waiting time of about 2 hours between the coatings' curing and the application of the sealer has proven.

Despite the good chemical resistance of Acrydur™ 522 N, one has to reckon a reduced resistance when sealing coatings based on Acrydur™ 418 N or 510 N. With these solvents (on continuous loading), a swelling by diffusion may take place after some time. This process depends on the sealing's layer thickness. In these cases, we thus recommend a layer thickness of 0.5 mm minimum or better a double application of Acrydur™ 522 N.

Only continue coating works after complete curing of the previous layer. It has proven that intermediate grinding of the coating before applying the sealer increases intermediate adhesion and levels any unevenness (lumps, knobs)

Suggested formulation:

2.113 gal Acrydur™ 522 N
2.71 oz Hardener 50 W or 5.41 oz Hardener M

Pot life and curing times depending on temperature:

Further coating layers with Acrydur™ must only be applied after the previous layers have completely cured.

Temperature [°C]**	Hardener [Vol%]*	Pot life [min]	Curing time [min]
+5	2	ca. 30	ca. 60
+10	1,5	ca. 20	ca. 45
+20	1	ca. 10	ca. 40
+30	1	ca. 8	ca. 20

*) Hardener quantity calculated according to Acrydur™ 522

**) temperature refers to resin, surface and air temperature

Attention: Hardener quantities below 1 Vol. % may cause polymerisation failures!

Attention: At temperatures below 32 °F, the resin needs to be put into a warm environment before processing - minimum 41 °F and add up to 2% hardener maximum. Basically accelerator cannot be

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added to sealings – neither as thinner nor as accelerator – due to yellowing aspects.

Storage: The handling-regulations for highly flammable materials apply to methacrylate – resins. Acrydur™ resins are to be stored cool, protected against direct sunlight and preferably at temperatures of 59 - 68 °F. During storage paraffin – particles and filler – materials may precipitate. Thus before processing, containers have to be stirred up well. Please mind the advice on our safety data sheets.

Industrial safety: Ensure sufficient ventilation during work. On processing, pay attention to the directives in the hazardous substances ordinance and to the indications of the Federal States Committee for industrial safety and safety engineering (LASI) as well as to our safety data sheets.

VbF: A I
GISCODE: RMA 10
Taxnumber: 3208 2010

Data concerning our products and devices as well as concerning our data and procedures are based on an extensive research work and an application technology experience. We obtain these results, with which we do not take over adhesion going beyond the respective single contract, in word and writing after best knowledge, reserve ourselves we however technical changes in the course of the product development. Beyond that our application technology service stands when desired for large consultation as well as for co-operation with the solution manufacturing and application technology problems for order. That does not relieve the user however to examine our data and recommendations before their use responsible for the own use. That applies - particularly for deliveries to foreign markets - also regarding the keeping of patent rights third as well as for applications and procedures, which are not expressly in writing indicated by us. The case of loss our adhesion is limited to indemnifications of same extent, as they plan our general terms of delivery and sales with lack of quality.