

# Acrydur™ 527 Additive

Medium viscous methacrylate resin for sealing  
Acrydur™ coatings in wet areas of the  
food industry

**PLASTI CHEMIE**  
**Produktionsgesellschaft mbH**

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**Characteristics:** Acrydur™ 527 is a topcoat, particularly on floors broadcast with sand and smoothed coatings based on Acrydur™ 332, Acrydur™ 510 or Acrydur™ 418 in production plants of the food industry with increased water and fat load. Acrydur™ 527 is characterized by:

- Good self-levelling
- Low yellowing tendency
- Increased resistance to water up to 80 °C
- Increased resistance to acids and alkalis

## Characteristic data:

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### Acrydur™ 526

Delivery form	Liquid, violet	
Flow time	26-32 s	20 °C (4mm DIN cup)
Density	1,00 g/cm <sup>3</sup>	DIN 53217
Flash point	+ 10 °C	DIN 51755
Curing time	30-40 min	20 °C (1% Hardener)
Shelf life	In the original container, closed, dry, cool, frost-free max. 6 months	
Bundle	25 kg, 10 kg pails 180 kg barrels	

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### Acrydur™ Additive 527

Delivery form	Liquid, transparent	
Flow time	16300 mPas	25 °C
Density	1,19 g/cm <sup>3</sup>	25 °C
Shelf life	In the original container, closed, dry, cool, frost-free max. 6 months	
Bundle	10 kg, 5 kg cans	

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## Processing notes:

### Processing:

Stir up well all Acrydur™ resins before application! Pour the required preparation quantity into a mixing pail and stir in Acrydur™ Additive 527 for about 1 min by using a suitable agitator. After stirring in the Acrydur™ hardener 50 W (1 min), the sealer is poured out onto the floor and immediately dispersed evenly.

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Best results are obtained with 700 g/m<sup>2</sup> by roller step with short hair (polyamide gold stripe) on sand broadcast coatings (0.7 - 1.2 mm grain).

For proper curing, at least 400 g/m<sup>2</sup> sealer must be applied per rolling step. To ensure the necessary slip resistance and to avoid yellowing and flaking, the maximum layer thickness is limited to 800 g/m<sup>2</sup>.

Scratch and water resistance can be ameliorated by using hardener/M. Hardener/M leads to a mat surface. Please mind the indications on the product data sheet.

Mixing approach: 8 l Acrydur™ 526  
0,4 l Acrydur™ Additive 527  
0,08 l Acrydur™ Hardener50W/0,16 l Acrydur™ Hardener/M

Material consumption: 400 - 700 g/m<sup>2</sup>

Curing time: Continue the coating work only after full hardening of the previous layer.

Temperature [°C] **	Hardener [Vol-%] *	Pot time [min]	Curing time [min]
+ 5 to + 10	2	~ 35	~ 50
+ 10 to + 20	1,5	~ 30	~ 40
+ 20 to + 25	1	~ 25	~ 35
+ 25 to + 30	1	~ 20	~ 30

\* Hardener quantity calculated on amount of Acrydur™ 527 N (Hardener 50 W)

\*\* The temperature specifications are based on resin, soil and air temperature

Attention: At temperatures below 0°C, the resin needs to be put into a warm environment before processing - minimum 5°C and add up to 2% hardener maximum. Basically, accelerator cannot be added to sealers – neither as thinner nor as accelerator – due to yellowing aspects.

**Additional Information:** Acrydur™ 526 can be used as clear sealer in interior and exterior zones. Elastic coatings with Acrydur™ 332 should be sealed with Acrydur™ 528 PUMMA-Hybrid if it is an exterior area.

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Otherwise there may appear hair-line cracks on the surface. To avoid yellowing, the hardener quantities in the table must be adhered to exactly. Good cross ventilation during processing assures good curing. A good cross ventilation ensures a good curing during processing.

Due to the thermoplastic property of MMA-resins, black stripes by forklift loading may appear (skidmarks). Using hardener/M lowers the occurrence of skid and roller marks.

### Storage:

Methacrylate resins are subject to the handling regulations of highly flammable materials. Plastifloor resin has to be stored cool, at temperatures between 15 – 20° C and protected from direct sun.

During storage paraffin particles can be deposited. Therefore materials have to be stirred thoroughly before processing the mixture. Please note the advice of our safety datasheet.

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.