

Elasticised, filled Methacrylate resin for broadcasting coatings

**Application** Acrydur™ 412 N is notably suitable for the production of 2.0 to 4.0 mm broadcasting coatings.

**Characteristics:** Acrydur™ 412 N coatings dispose of outstanding mechanical strength and a high resistance to chemicals in addition to resistance against UV-aging and saponification.

**Characteristic data:**

Form of delivery	slightly cloudy liquid
Curing	ca. 30 min at 68°F
Shelf life	dark place at < 68 °F 6 months maximum
Bundle	180 kg drum 25 kg, 10 kg pail

**Processing Notes:**

Suggested formulation:  
*Coating 2-5 mm*

			Consumption
	55.0 ppW	Acrydur™ 410 N	0.205 lb/ft <sup>2</sup>
app.	45.0 ppW	Quartz sand	0.143 lb/ft <sup>2</sup>
	2.0 ppW	Hardener 50 W (68°F)	

This formulation is suitable for floors exposed to severe mechanical and chemical loading in dry and wet areas, e.g. electrolysis and galvanizing plants, chemical production plants, acid-proof installations, dairies and butcher's trade where non-skid floors are required.

This mix is applied to well-primed surfaces. If necessary, it is possible to apply a flexible membrane layer made from Acrydur™ 332/Z.

Processing:

**Stir up the resin well before use!**

Prior to use, hardener and resin must be mixed and stirred at least 1 minute, then fillers are premixed in the power mixer for app. 2 minutes. Then the coating is applied immediately by using a smoothing trowel.

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Thin layers and excess filler deteriorate the liquid quantity of the material and may cause curing defects.

Bleed the coating compound with a pricking roller

For decorative surfaces, colored sands (resin coated), e.g. granulation 15 - 25 mesh may be scattered onto the coating.

We recommend to seal this surface e.g. with Acrydur™ 522 N or Acrydur™ 526 N.

### 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 [°F]**	Hardener [Vol%]	Pot life [min]	Curing time [min]
+41	4,5	ca. 30	ca. 60
+50	3,5	ca. 20	ca. 50
+68	2	ca. 10	ca. 30
+86	1	ca. 10	ca. 30

\* ) Hardener quantity calculated according to Acrydur™ 410

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

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

**Hint:** The coating work always has to be continued only after complete curing of the preceding layer. For jobs below 5°C the application of accelerator 101 is necessary. (query data sheet!)

**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.

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**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.