
Application: Acrydur™ 412 is notably suitable for the production of 2.0 – 4.0 mm broadcasting coatings.

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

Characteristics:

Form of delivery	slightly cloudy liquid
Curing	ca. 30 min at 20°C
Shelf life	dark place at < 20 °C 6 months maximum
Bundle	180 kg drum 25 kg, 10 kg pail

Initiator/Hardener: Hardening powder 50W (BPO), depending on temperature

**Formulation
coating
2-4 mm:**

55.0 ppW	Acrydur™ 412	consumption
45.0 ppW	Quartz sand 0.06- 0.2 mm	1,0 kg/m ²
2.0 ppW	Hardener 50 W (at 20°C)	0,7 kg/m ²

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

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.

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

For decorative surfaces, colored flakes may be scattered onto the coating.

We recommend sealing this surface e.g. with Acrydur™ 522 or Acrydur™ 526.

Acrydur™ 412 (GB)
Elasticised Methacrylate
resin for broadcasting coatings

**Pot life and
hardening
time at different
temperatures:**

Temperature [°C]**	Hardener [Vol%]	Pot life [min]	Curing time [min]
+5	4,5	ca. 30	ca. 60
+10	3,5	ca. 20	ca. 50
+20	2	ca. 10	ca. 30
+30	1	ca. 10	ca. 30

*) Hardener quantity calculated according to Acrydur™ 410

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

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:

Methacrylate resins are subject to the handling regulations of highly flammable materials. Acrydur™ resin has to be storage 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 at temperatures of 35 °C.

Please note the advice of our safety datasheet

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.