Acrydur® 527 Additive

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

PLASTI CHEMIE International GmbH

Properties:

Acrydur® 527 is a top coat, especially for sanded and smoothed floors based on Acrydur® 332, Acrydur® 510 or Acrydur® 418 in food industry production plants with increased water and grease load. Acrydur® 527 is characterized by:

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

Characteristic of the resin and additive as delivered:

Acrydur® 526

Property	Measuring method	Approx. value
Viscosity at 23 °C	DIN 53 015	100-140 mPa · s
Flow time at 20°C, 4 mm cup	DIN 53 211	30-40 sec
Density D^{20}	DIN 51 757	0.95 g/cm^3
Pot life at 20°C	ca. 12-15 min	
Curing	30-40 minutes (20°C and 1% hardener)	
Form of delivery	liquid, slightly bluish	
Shelf-life	dark at < 20°C, 6 months maximum	
Bundle	180 kg drums 25 kg, 10 kg pails	

Acrydur® Additive 527

Property	Measuring method	Approx. value
Flash point	ISO 2719	> 140 °C
Water solubility at 25 °C	OECD Test Guideline 105	6-80 mg/l
Surface tension at 20 °C	OECD Test Guideline 115	51.4 mN/m / 30mg/l
Viscosity at 23 °C		21.000 mPa · s
Relative density at 20 °C		1.196
Form of delivery	Liquid, yellowish	
Shelf-life	6 Months, Storage temperature: < 45 °C	
Bundle	10 kg, 5 kg cans	

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Processing:

Stir up all Acrydur® resins well before use! Pour the required amount into a mixing bucket and stir in Acrydur® Additive 527 for approx. 1 minute 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.

Best results are obtained at 700 g/m² by roller step with short hair (polyamide gold stripe) on sand broadcast coatings (0.7 - 1.2 mm grain).

For proper cure, a minimum of 400 g/m² of sealer must be applied per rolling step. To ensure slip resistance and to avoid yellowing and flaking, the maximum layer thickness is limited to 800 g/m².

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
0.2 L Acrydur® Additive 527
0.08 L Acrydur® Hardener 50W / 0.16 L Acrydur® Hardener/M

Material consumption:

400 - 700 g/m²

Curing time:

Do not continue coating until the previous coat has completely cured.

Temperatur [°C]	Hardener [Vol%]	Hardener [wt%]	Pot life [min]	Curing time [min]
+ 5 to + 10	2.0	1.3	ca. 35	ca. 50
+ 10 to + 20	1.5	1.0	ca. 30	ca. 40
+ 20 to + 25	1.0	0.6	ca. 25	ca. 35
+ 25 to + 30	1.0	0.6	ca. 20	ca. 30

Hardener quantity calculated on amount of Acrydur® 527 (Hardener 50 W)
The temperature specifications are based on resin, soil and air temperature

Attention:

At temperatures below 0°C, the resin must be placed in a warm environment before processing – at least 5°C and with addition of up to 2% hardener. In general, accelerators cannot be added

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to sealers – either as thinners or as accelerators – due to yellowing.

Additional Information:

Acrydur® 526 can be used as a clear sealer indoors and outdoors. Elastic coatings with Acrydur® 332 should be sealed with Acrydur® 528 PUMMA-Hybrid in exterior areas.

Failure to do so may result in hairline cracking of the surface. To avoid yellowing, the hardener quantities in the table must be followed exactly. Good cross-ventilation during application will ensure good curing. Good cross-ventilation during processing ensures good cure.

Due to the thermoplastic nature of MMA resins, black streaks(skid marks) may appear during forklift loading. The use of hardener/M reduces the occurrence of skid and roller marks.

Storage:

Methacrylate resins are subject to the handling regulations for highly flammable materials. Acrydur® resins must be stored cool, at temperatures between 15 – 20° C and protected from direct sun sunlight.

Paraffin particles may deposited during storage. Therefore, materials must be stirred thoroughly before processing. Please follow the instructions in our Safety Data Sheet.

Industrial safety:

Provide adequate ventilation during work. During processing, observe the regulations of the Hazardous Substances Ordinance, the instructions of the Federal State Committee for Occupational Safety and Safety Technology (LASI), and our safety data sheets.

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VbF:	A I
GISCODE:	RMA 10
HS-Code:	3208 2010

CE-labelling

CE	
Plasti Chemie Produktionsgesellschaft mbH • Falgardring 1 • 08223 Falkenstein • Germany	
EN 13813, SR-B2, 0-AR0, 5-IR12	
Acrydur® 527 Additive	
Synthetic resins for internal uses (Application in accordance with the newest technical information)	
Reaction to fire:	E_{fl}
Wear resistance (Abrasion Resistance):	AR 0.5
Impact resistance:	IR 12
Tensile bond strength:	B 2.0

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.

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