

Rev 01 (11/07/22)

Application Guide Humidur® FP QR



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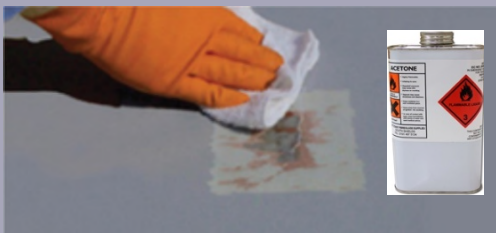
Let's face corrosion.

1. Surface preparation

Step 1. Remove fouling, dirt and salts by power wash.



Step 2. Degrease the surface.



Step 3.

Option 1. Grit blast the surface by abrasive blasting to Sa 2½ (ISO 8501-1) & roughness $60 \pm 10 \mu\text{m}$.



Option 2. Minimal preparation with power tools to roughen the surface to St 2 or St 3 (ISO 8501-1).



Step 4. Remove dust.



Step 5. Clean with cleaning agent.



Step 6. Check the surface preparation.

- Check for *salts* (Bresle) – ISO 8502-6, ISO 8502-9 ($< 60 \text{ mg/m}^2$)



- Check the *roughness* – ISO 8503-2 (optimal surface prep: $60 \pm 10 \mu\text{m}$; minimal prep: original profile)



- Check for *dust* – ISO 8502-3 ($Q \leq 3, C \leq 3$)



2. Coating application

Step 7. Delivered in pre-dosed cartridges (A and B) with static mixer.



Step 8. Store the product in a warm place (15 – 25 °C) prior to application. Temperature control is less strict than for other Humidur products.



15 – 25 °C

Step 9. Remove the metal ring at the top using pliers.



Step 10. Unscrew the cap.
Do not discard the cap as you will need it to store the product if not completely emptied.



- Step 11.** Take off the closing cap.
Do not discard the cap as you will need it to store the product if not completely emptied.



- Step 12.** Attach the static mixer and place the tube in the dispenser gun.
Dispenser guns, suitable for the side-by-side cartridges, can be purchased from Acotec.



- Step 13.** Temperature surface > Dew point + 3 °C. No condensation allowed!



*These criteria are valid to achieve the most durable protection. If a reduced coating lifetime is desired, application can continue outside this window. The existing warranties do not apply in these conditions. Please contact Acotec NV directly for more information on the expected lifetime in these conditions.

- Step 14.** Discard the first couple of millilitres as these will have an incorrect mixing ratio. Next, apply the product on the prepared surface.



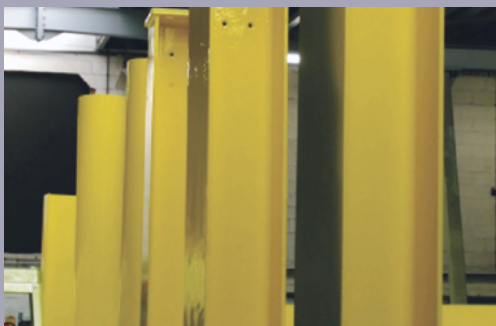
Step 15. Spread out the coating over the surface by brush.



Step 16. Check the wet layer thickness during application.
Consult your Acotec representative for the required thickness (max 400 µm on vertical surfaces).
WFT = DFT.



Step 17. Allow curing: at 25 °C: 24 hours
Capable of curing under water.



Step 18. If the cartridge is not completely emptied, it can be stored for later use. Simply wipe down the opening of the cartridge and close it again with the lid and the cap.

Please consult the SDS and TDS for the required information regarding the potential hazards of Humidur FP QR and for the HSE requirements to safely apply it.