

02-10-2019 / REVISION 01

HUMIDUR.

Application Guide Humidur® ME



WWW.HUMIDUR.BE
INFO@ACOTEC.BE



ACOTEC N.V.
Industrielaan 8 Zuid III
9320 Aalst, Belgium

T: +32 (0)53 83 86 60
E: info@acotec.be

Surface Preparation

Step 1. Remove fouling, dirt and salts by powerwash



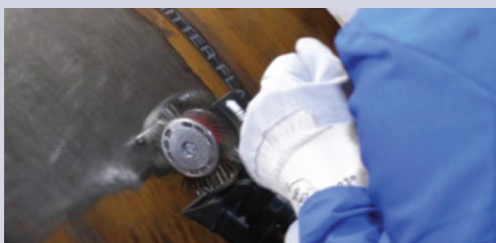
Step 2. Degrease the surface



Step 3 - Option 1. Gritblast the surface by abrasive blasting to Sa2,5 (ISO 8501) and roughness $\pm 60 \mu\text{m}$



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





HUMIDUR.

ACOTEC N.V.

Industrielaan 8 Zuid III
9320 Aalst, Belgium

T: +32 (0)53 83 86 60
E: info@acotec.be

Step 4. Remove dust and clean with fresh water



Step 5. Clean with cleaning agent



Step 6. Check surface preparation

Check for salts (Bresle) - ISO 8502-6



Check the roughness - ISO 8503-2



Check for dust - ISO 8502-3





ACOTEC N.V.
Industrielaan 8 Zuid III
9320 Aalst, Belgium

T: +32 (0)53 83 86 60
E: info@acotec.be

Coating Application

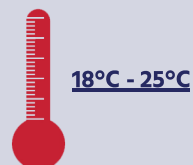
Step 7. Delivered in pre-dosed pails (A and B)

Check the labelling: mixing ratio weight: 4,4 : 1



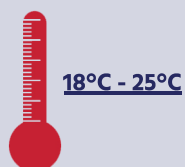
Step 8. Temperature non-mixed in warm water bath

Humidur ME: 18°C - 25°C



Step 9. Transport the pails in an insulated box to the area to be coated

This way the paint will not cool down



Step 10. Agitate only component A

Empty component B into A and mix for 3 minutes
(Plural spray: this step can be skipped)

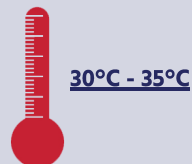




ACOTEC N.V.
Industrielaan 8 Zuid III
9320 Aalst, Belgium

T: +32 (0)53 83 86 60
E: info@acotec.be

Step 11. Temperature after mixing Humidur ME: 30°C - 35°C



Step 12. Temperature surface > dew point + 3°C
No condensation is allowed!



Step 13. Apply the product by: - Brush

- Single airless min. 60 : 1



Step 14. Check the wet layer thickness during application
Consult your Acotec representative for required thickness
WFT = DFT



Step 15. Allow curing
At 20 °C: 48 hours
Capable of curing under water



ACOTEC N.V.
Industrielaan 8 Zuid III
9320 Aalst, Belgium

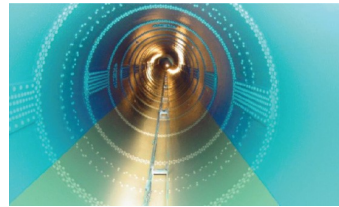
T: +32 (0)53 83 86 60
E: info@acotec.be

Final Results

Interior crude oil storage tank



Interior hydropower pipeline



Offshore crane structure



Steel supporting parts in subway stations

