BONDING / PRIMING

Recommended primers under **abecote 440** are:
- Steel- **abecote 384**
- Concrete and other porous surfaces
- **abecote 386**

If a high quality finish is required on metallic surfaces, an undercoat of **abecote 386** should be applied over the **abecote 384.**

abecote 386 is easy to rub down with emery or sand paper and to achieve the best finish, this should always be done. All resulting debris must be removed.

If wet sanding is used, the surface must always be allowed to dry completely as any trace of moisture under **abecote 440** will promote bubbling in the film.

Where **abecote 440** clear is used on timber, no priming is required. Reduce the first coat with 15% **abecote Thinners No. 2**.

MIXING

Stir the contents of each container, particularly the base, very well. Add activator to base and stir together for at least five minutes using a flat paddle. It has been found that mechanical mixing gives better dispersion than manual mixing. A suitable mixing method would be by slow-speed electric drill (approximately 200 r/min) fitted with a paddle.

If only part of the kit is to be used add one volume of activator to nine volumes of base. Measuring must be accurate and separate containers must be used for proportioning each component.
The mixed material must be left to stand for 20 minutes prior to application.

If thinning is needed use only **abecote Thinners No. 2**. Incorrect choice of thinners may cause bubbling in the film.

If the kit is split and kept for future use, the activator can must be very tightly sealed and then stored upside down. The activator will react with moisture in the air. The split kit should not be stored for more than a few days or gelling will occur.

APPLICATION

abecote 440 should be applied to the pre-primed surface within the over coating time stipulated for the relevant primer.
If airless spray is used for application a nozzle of approximately 400 µm should be used. Conventional spray is not recommended since any trace of moisture in the air supply may result in bubbling. Bubbling can also result from using damp brushes or short-fibre rollers that are not completely dry before use and also from applying too thick a film of material. Never apply thicker films than recommended.

abecote 440 should not be applied if the ambient temperature is below 8° C. The curing reaction will not proceed at low temperatures. If the surfaces are not at least 2° C above the dew point, a film of condensed moisture could be present. This again will cause bubbling as well as compromising adhesion.

CLEANING

abe super brush cleaner before curing.

PROTECTION ON COMPLETION

Protect surface against traffic and spillage until cured.

MODEL SPECIFICATION

The coating will be **abecote 440**, a two-component polyurethane/acrylic resin enamel cross linked with an aliphatic isocyanate applied in accordance with **abe Construction Chemicals'** recommendations.

PACKAGING

Abecote 440 is supplied in 1 litre and 5 litre yield metal containers.

HANDLING & STORAGE

All **abecote 440** related products have a shelf life of 12 months if kept in a dry, cool store in the original, unopened packs.

If stored at high temperatures and/or high humidity conditions, the shelf life may be reduced.

HEALTH & SAFETY

Wet **abecote 440** is toxic and flammable. Ensure working area is well ventilated during application and drying. Avoid naked flames in the vicinity.
Avoid inhalation of dust and contact with skin and eyes. Suitable protective clothing, gloves, eye protection and respiratory protective equipment should be worn. The use of barrier creams provides additional skin protection. If contact with skin occurs, wash with water and soap. Splashes into eyes should be washed immediately with plenty of clean water and medical advice sought.

Cured **abecote 440** is inert and harmless.

When transporting liquids and semi liquids by aircraft, ask for material safety datasheet.

IMPORTANT NOTE

This data sheet is issued as a guide to the use of the product(s) concerned. Whilst **abe Construction Chemicals** endeavours to ensure that any advice, recommendation, specification or information is accurate and correct, the company cannot - because **abe** has no direct or continuous control over where and how **abe** products are applied - accept any liability either directly or indirectly arising from the use of **abe** products, whether or not in accordance with any advice, specification, recommendation, or information given by the company.

FURTHER INFORMATION

Where other products are to be used in conjunction with this material, the relevant technical data sheets should be consulted to determine total requirements. **abe Construction Chemicals** has a wealth of technical and practical experience built up over years in the company's pursuit of excellence in building and construction technology.

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