

ADVOTHANE 3360 FG (F2)

(Acrylic Aliphatic Weather Resistant Polyurethane finish Paint)

GENERAL DESCRIPTION

Two pack aliphatic isocyanate cured acrylic finish paint. It has excellent chemical resistance. It is fast drying, and gives a Full Gloss finish with high scratch hardness and mar resistant. Being UV resistant, it has excellent colour and gloss retention, and exterior durability.

RECOMMENDED USE

Designed as a topcoat for steel and concrete structural installations, pipelines, machineries and equipment in severe industrial and marine environments. It is specially recommended for transport vehicles, buses, railway carriages, and other areas where long-term durability and aesthetic look is desired.

PHYSICAL DATA

Colour	Range of RAL, BS & IS colours
Finish	Smooth, uniform and Full -Gloss
Volume Solids (ASTM D 2697)	57 %
Mixing Ratio	3 : 1 By Volume
Dry Film Thickness	30 – 40 µm per coat
Spreading Rate	10 - 13.3 m ² per litre @ 30 - 40 µm
Flash Point	> 23°C
Adhesion MPa (ASTM D 4541)	>5
Abrasion Resistance (ASTM D4060 FOR 1000g load)	>300 mg/1000 Cycle/CS 17
Temperature Resistance (Minimum)	80°C Dry Service (Method A)

DRYING TIME:

Drying times are generally depending on air circulation, ambient temperature, film thickness and number of coats, and will be affected accordingly. The figures given in table below are indicative only.

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TEMPERATURE		15°C	25°C	35°C
INDUCTION TIME		20 Minutes	15 Minutes	10 Minutes
TOUCH DRY		45 minutes	30 minutes	20 minutes
HARD DRY		8 hours	6 hours	4 hours
OVERCOATING INTERVAL	MINIMUM	12 hours	10 hours	8 hours
	MAXIMUM	Extended*	Extended*	Extended*
POT LIFE		7 hours	5 hours	3 hours

THINNER RECOMMENDED	Advothane PU Thinner
SHELF LIFE	Base – 12 Months @25°C Hardener – 6 Months @25°C

LIMITATION	
POT LIFE	If viscosity of mixed paints reaches more than double of initial viscosity do not apply the mixed paint anymore.
BLASTING OR APPLICATION	Do not carry out an application in the following conditions: When humidity > 90% When ambient temperature < 10°C When Substrate temperature is less than 3°C about the dew point.

SURFACE PREPARATION	Oil and grease should be removed following SSPC-SPI solvent cleaning and apply a suitable primer i.e. Advoguard 1250, Advoguard 1240 APP, Advamastic 1280 HB Prior to surface oxidation. Remove accumulated dirt and salt with fresh water and dry it. Advothane 3360 should be always applied on suitably Primed metal surface. Primer surface should be dry and free from all contaminations, and Advothane 3360 must be applied within the over coating intervals of Intermediate coating. Area of damage etc., should be prepared to the specified standard and patch primed prior to the application of Advothane 3360 topcoat.
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ABRASION BLAST CLEANING	Abrasion blast clean to minimum Sa 2½ (ISO 8501-1:2007) or SSPC-SP10. Surface defects like weld spatters, holes etc. must be taken care. Ensure there is no oil and grease on the surface. Remove dirt and salts by brush or by potable water and dry it prior to over coating with Advothane 3345 S/G Recommended primer/undercoats: Galozinc 1180/1190, Advoguard 1250/1255, Advoguard 1240 APP, Advoguard 2260 Mio, Advamastic 1280 HB, Advamastic SP80, Advashield Bandorust.
MIXING METHOD	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Agitate Base (Part A) with pneumatic stirrer and add Base (Part B) slowly and continue stirring 3-5 minutes till the mixture becomes homogeneous. Do not add thinner. If ambient temperature >35°C, add 3-6% thinner to avoid dry spray and to control the DFT.
AIRLESS APPLICATION	Pump Ratio: 60: 1 Tip size : 0.33 – 0.48 mm Air pressure: 4 – 5 Bar
CONVENTIONAL AIR SPRAY	Air Spray Gun (Pilot Type 59) Pressure – 3 – 4 Kg/sq cm Nozzle size – 1.2 – 1.8 mm
BRUSH APPLICATION	For small area or to touch up, apply by brush. Do not apply when humidity is very high (>90% R.H) or the ambient temperature is below 3°C of dew point.
STORAGE	The product must be store below 25°C and in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space, and away from source of heat and ignition. Containers must be kept tightly closed.

SAFETY PRECAUTIONS

Keep the material away from heat, spark, and direct flame.

In case of contamination, rinse with fresh running water and seek medical help at once.

Provide sufficient ventilation when working with solvent based coatings in confined spaces and stagnant air.

Follow Local and National Safety Rules.

WORK STOPPAGE

Clean the hoses, gun or spray equipment with water immediate after application. Do not allow material to remain in the equipment system.

CLEAN UP

Clean all equipment thoroughly with Advothane thinner immediately after use. As part of good working practices, spray equipment should also be flushed periodically during the working day. The frequency of cleaning depends on factors such as the volume of material sprayed, ambient temperature, and the duration of any delays or downtime.

Dispose of all surplus materials and empty containers responsibly, in compliance with applicable regional regulations and legislation.

NOTE

Thinner consumption and loss factor in practical coverage of paint depends upon the site condition.

Avoid inhalation of solvent vapour or paint mist by using facial mask. Also use gloves and goggles to protect against direct contact of paint with skin and eyes.

This cancels all previous information sheets for this Product.

Information given here is in good faith without warranty.

DISCLAIMER

The information provided in this document is based on Advance Paints best knowledge, derived from laboratory testing and practical experience. As Advance Paints products are considered semi-finished goods, they are often used under conditions beyond the company's control. Therefore, Advance Paints can only guarantee the quality of the product itself and cannot assume responsibility for its performance under all circumstances. Minor variations in the product may occur to meet local requirements. Advance Paints reserves the right to amend the provided data without prior notice.

Users should always consult Advance Paints for specific guidance on the suitability of this product for their particular needs and application practices.

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This data sheet is not exhaustive. For further information or additional details, please reach out to our Technical Service Team.

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