

02-10-2019 / REVISION 01

# HUMIDUR.

## Application Guide Humidur® FP Single



[WWW.HUMIDUR.BE](http://WWW.HUMIDUR.BE)  
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## Surface Preparation

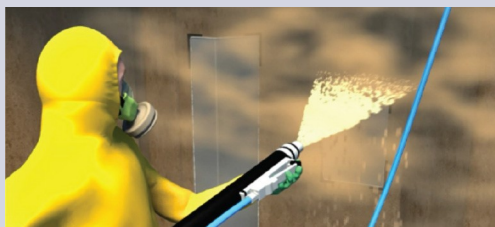
**Step 1.** Remove fouling, dirt and salts by powerwash



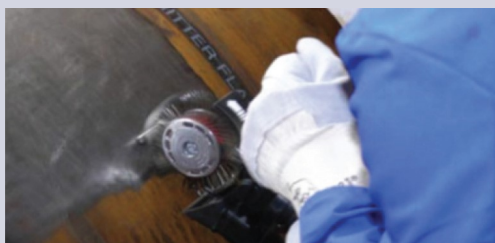
**Step 2.** Degrease the surface



**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)





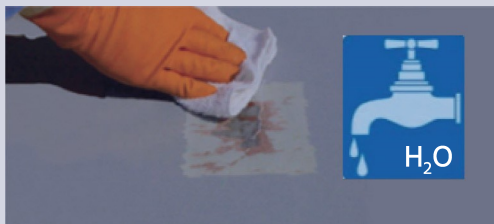
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**Step 4.** Remove dust and clean with fresh water



**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





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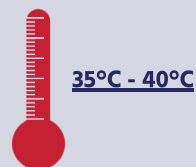
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## Coating Application

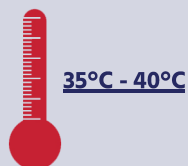
**Step 7.** Delivered in pre-dosed pails (A and B)  
Check the labelling: mixing ratio weight: 5,0 : 1



**Step 8.** Temperature non-mixed in warm water bath  
Humidur FP Single: 35°C - 40°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)

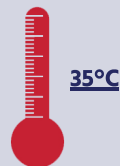




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**Step 11.** Temperature after mixing Humidur FP Single: 35°C



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



**Step 13.** Apply the product by:

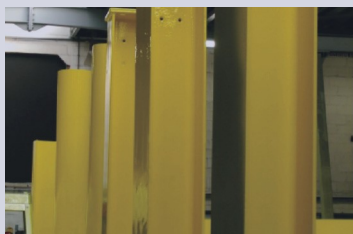
- Brush
- Single airless min. 60 : 1
- Plural airless min. 60 : 1



**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: 24 hours  
Capable of curing under water



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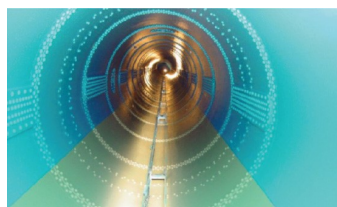
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### Final Results

Interior crude oil storage tank



Interior hydropower pipeline



Offshore crane structure



Steel supporting parts in subway stations

