Technical Data
BALTOFLAKE

Product description
Baltoflake is a quick curing, glass flake reinforced polyester coating, high build, that gives long time corrosion protection.

Recommended use
Steel structures in general and in particular items subject to extreme mechanical wear. May also be used for protection of aluminium and concrete (special designed systems).

Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry (µm)	600	1500	750
Film thickness, wet (µm)	625	1560	780
Theoretical spreading rate (m^2/l)	1.6	0.64	1.28

Physical properties

Colour	Limited number.
Solids (vol %)*	96 ± 2
Flash point	34ºC ± 2 (Setaflash)
Gloss	Semiflat
Gloss retention	Very good
Water resistance	Excellent
Abrasion resistance	Excellent
Solvent resistance	Very good
Chemical resistance	Very good
Flexibility	Limited
Compatibility with cathodic protection	Very good

*Measured according to ISO 3233:1998 (E)

Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Bare steel
Blast cleaning to Sa 2½. (ISO 8501-1:1988). Roughness: using abrasives suitable to achieve a coarse surface of Grade Medium G (50-85µm, Ry5) (ISO 8503-2).

Coated surfaces
Approved on top of Baltoflake Holding Primer

Other surfaces
The coating may be used on other substrates. Please contact your local Jotun office for more information.

Condition during application

The temperature of the substrate should be minimum 10°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is usually required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until fully cured.

Application methods

Spray	Use normal airless spray or two-comp. airless spray equipment
Brush	Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.
Roller	May be used for small areas but not recommended for first primer coat, however when using roller application care must be taken to apply sufficient material in order to achieve the specified dry film thickness.

Application data

Mixing ratio (volume)	See separate table.
Pot life (23°C)	45 - 55 minutes (Reduced at higher temp.)
Thinner	If neded max. 5% styrene.
Cleaner	Acetone or Thinner No. 17 -
Guiding data airless spray	
Pressure at nozzle	15 - 25 MPa (150-250 kp/cm², 2100-4000 psi.).
Ratio/Capacity:	>45:1, min. 12 l per minute. Slow moving piston.
Nozzle tip	0.69 - 1.09 mm (0.027 - 0.043'').
Spray angle	40 - 80°
Filter	To be removed
Note	For further details please see separate "Working Manual".

Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

* Good ventilation (Outdoor exposure or free circulation of air)
* Typical film thickness
* One coat on top of inert substrate

Substrate temperature	**10°C**	**23°C**	**40°C**
Surface dry	3 h	2 h	2 h
Through dry	5 h	2 h	2 h
Cured	96 h	48 h	24 h
Dry to recoat, minimum	5 h	2 h	2 h
Dry to recoat, maximum [1]	20 h	12 h	12 h

1 The surface should be dry and free from any contamination prior to application. If the maximum dry to recoat time is exceeded, please contact Jotun Paints for advice.

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

Typical paint system

Over Sa 2½:

Baltoflake	**1 x 750-1000 µm**	**(Dry Film Thickness)**
or		
Baltoflake	**1 x 600-750 µm**	**(Dry Film Thickness)**
Baltoflake Non Skid	**1 x 400 - 600 µm**	**(Dry Film Thickness)**

Other systems may be specified, depending on area of use

Choose curing agent and, if necessary, inhibitor or accelerator according to the table below. Inhibitor or accelerator (if used) must be thoroughly mixed with Baltoflake before adding the required amount of Norpol peroxide. Mechanical agitation for one minute or more.

Temperature	Addition	Notes
10-15ºC	Norpol accelerator 9802P/S: 2 vol% (320ml to 16l) Norpol peroxide No 1: 2 vol% (320ml to 16l)	Temperature applies to the temperature of the steel. Paint temperature: 15-20ºC.
15-20ºC	Norpol peroxide No 1: 2 vol% (320ml to 16l)	
20-25ºC	Norpol peroxide No 1: 1.25 vol% (200ml to 16l)	Temperature of steel and paint.
25-35ºC	Norpol inhibitor 9851: 1.25 vol% (200ml to 16l) Norpol peroxide No 1: 1.25 vol% (200ml to 16l)	Temperature applies to the temperature of the paint. Steel temperature above 25ºC.
35-40ºC	Norpol inhibitor 9851: 2,5 vol % (400ml to 16l) Norpol peroxide No 1: 1.25 vol% (200ml to 16l)	

Storage

The product must be stored below 25°C and in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.
SHELF LIFE: 6 months, at 23°C (2 months at 40°C), subject to re-inspection therafter. Shelf life very much depends on tempeature. Lower temperatures (if possible below freezing point) will lengthen the shelf life considerably, while high temperature may lead to gelling in the thin.

Handling

Handle Norpol Peroxide with care. Avoid that it comes in contact with combustible materiales. Accelerator and peroxide must never be mixed directly together.

Packing size

16 L. (20 kg.)
Packing may vary from country to country according to local requirements.

Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

DISCLAIMER

The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.

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