EDITION: 00126FLO

Technical Data Sheet

PA330

HIGH PERFORMANCE FLOOR COATING

Description

Hychem PA330 is a highly versatile polyaspartic coloured coating utilising the latest premium technology. It comprises of a 2-component aliphatic technology delivering a durable protective coating with an excellent decorative finish and UV colour stability. It has excellent long-term resistance to external weathering.

Typical Applications

- Ideal as a protective coat over Hychem epoxy coatings.
- As a topcoat for most concrete and masonry finishes.
- Factory, warehouse, garage, restaurant, retail and industrial floors.
- Driveways, walkways, corridors, steps, walls and balconies.
- Add suitable aggregates to conform to a range of slip resistance specifications.

Features & Benefits

- Excellent wear resistance.
- Excellent chemical and stain resistance.
- Excellent scratch resistance.
- Low temperature curing.
- Excellent UV resistance, non-yellowing and high gloss.
- Ideal for interior and exterior use.
- Easy application.

Physical Properties	
Mix Ratio	2:1 Part A Resin to Part B Hardener by volume.
Solids content	85%
Pot life	20 minutes @ 23°C
Tack free time	6 hours @ 23°C
Recoat time	6-24 hours @ 23°C
Walk time	12 hours @ 23°C
Full cure time	48 hours @ 23°C
App. temperature	15 to 35°C
Service temperature	-20 to 50°C

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Application Guidelines

Surface Preparation

Surface preparation on concrete
Prior to the application of PA330, the substrate must be thoroughly prepared.
The concrete substrate must be firm, clean and dry with a minimum compressive strength of 1.5MPa.
New concrete must be allowed to cure for a minimum of 28 days.
Remove all surface laitance, contaminants, existing coatings, curing compounds and any weak or loose materials.
Prepare the concrete surface by grinding, shot blasting, scarifying, ultra high-pressure water jetting or scabbling to provide the appropriate concrete surface profile (CSP) for optimum mechanical keying.
The extent of surface preparation required is dependent upon but not limited to the thickness of the coating system to be applied. It is highly recommended that all surface preparation is carried out in accordance with industry standards and publications such as NACE 02203 item No. 22420 or ICRI Technical Guideline No. 03732.

Very important note: The surface must be dry when applying Hychem PA330.

For surface preparation on timber, plastic or metal substrates
Please contact Hychem technical department for advice.

Mixing

Mixing ratio is 2:1 by volume (1x 4L Part A: 1x 2L Part B)
The product is generally supplied as 5.5L neutral kit to which 500ml pigment is added.
Mix pigment into Part A and stir thoroughly until the pigment is incorporated uniformly.
Add Part B and mix until uniform consistency is achieved
Do not over mix as this product has a short pot life.
A mechanical stirrer is used for this process to achieve optimum uniformity.
Up to 10% Xylene can be added to thin down product - only do this if specification and site regulations allow. The Xylene should be added and mixed into the pigmented part A prior to addition of Part B.
If solvent is added, the application rate should be $\geq$ 8sqm/L to avoid trapped solvent in the film.

Application

- By roller or brush at a rate of 5 -10 sqm. /L
- High humidity will reduce drying time and curing rate.

Coverage

5.5L neutral kit.
Part A - 3.5L
Part B - 2L
Pigment - 500ml
This 6L kit will cover approximately 40sqm.

Clean Up

Xylene (Solvent X) can be used for cleaning tools and equipment before the mixed compound begins to harden.

Shelf Life

24 months from date of manufacture, stored under shelter at 23ºC in original un-opened container.

Comments

Actual cure times will be dependent on climatic conditions including air and substrate temperature, relative humidity and air movement.
All information is given in good faith and to the best of our knowledge.
Users are encouraged to assess the product under their own conditions and for their own applications.

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Warning – Environmental Conditions

Temperature and the surrounding atmospheric conditions will play a part in the curing process of all epoxy products. Under conditions of low temperatures and high humidity the final cured surface finish can be adversely affected potentially resulting in poor gloss retention, discoloration over time, poor overcoat ability and inter-coat adhesion. Quite often these conditions will result in the formation of a white film over the surface, often evident after contact with water. This chemical reaction with the atmosphere is commonly referred to as “amine bloom” or “amine blush”.
If this occurs, then the existing coating will need to be abraded to completely remove the affected surface to ensure the adhesion of subsequent applications. In some cases, partial or complete re-priming may be necessary.
To minimise an unsatisfactory cure, the following indicative application conditions should be observed with respect to temperature and humidity levels.
21° C and less than 85% humidity
10° C and less than 75% humidity
Attention also needs to be paid to the substrate temperature which should be at least 3-5° C above the dew point during the curing phase.
Industry standards recommend the accurate recording of environmental conditions such as substrate & air temperatures, humidity levels and dew point readings during both the application & curing processes. Full material warranties cannot be provided unless all the relevant data has been recorded accurately.
If in doubt consult the Hychem technical department for advice.

Safety Precautions

Epoxy polymer products may cause allergic reactions through skin contact. Goggles and protective gloves and clothing should be always worn. Ensure that there is adequate ventilation and air flow and avoid breathing the vapour. If skin contact occurs, wash skin with soap and water. If eye contact occurs, wash immediately with copious amount of clean water.

Warranties and Disclaimers

Hychem warrants that this product shall conform to the technical specifications published in the product literature. The quality and fitness of the product is dependent upon the proper use and application of the product by the applicator. Hychem has no role in the application of the finished polymer other than to manufacture and supply its components. It is vital that the person applying this product understands the product and is fully trained, experienced and competent in the use of epoxy grouting products. There are no warranties that extend beyond the description on the face of this instrument, except when provided in writing, directly by Hychem and executed under seal by a company officer.

Field Support

Field support where provided, does not constitute supervisory responsibility. Suggestions made by HYCHEM either verbally or in writing may be followed, modified or rejected by the owner, engineer or contractor since they and not HYCHEM are responsible for carrying out procedures appropriate to a specific application.

Customer Responsibility

The technical information and application advice given in this publication is based on the best information available at the time of print. As the information herein is of a general nature, no assumption can be made as to the product suitability for a particular use or application and no warranty as to its accuracy, reliability or completeness either expressed or implied is given other than those required by Commonwealth or State Legislation. The owner, his representative or the contractor is responsible for checking the suitability of products for their intended use.