

## INFO DATA SHEET

# Processing instructions for Sika® Unitherm® Platinum-120

Addendum to product data sheet Sika® Unitherm® Platinum-120

## Sika® Unitherm® Platinum-120

IMPLEMENTS		
	<b>Air supply</b>	Via min. ½-inch supply line at min. 6.0 bar and 1.5m <sup>3</sup> /min
	<b>Airless spraying device</b>	Efficient device for conventional 1-pack application with min. 66:1 ratio and at least 150cm <sup>3</sup> delivery rate per double stroke, e.g. Wiwa Professional or Graco Xtreme
	<b>Flow heater</b>	with thermometer
	<b>Connecting horse</b>	max. 1.00 m, ND 10 mm
	<b>Spray horse</b>	max. 20.00 m, ND 10 mm, plus 'whip line' Isolating the hoses to support the homogeneous flow of material!
	<b>'Whip'</b>	2 - 5 m; ND 6 mm
	<b>Material supply</b>	Storage container, <b>no</b> intake nozzle We recommend a spray gun where the material is not going through the gun handhold (e.g. WIWA 500 F or Graco XHF)
	<b>Mixer</b>	clean efficient (1400-1600 Watt) building-site mixer with a stir basket 140-160 mm Ø or twinshaft mixer
	<b>Wet film thickness gauge</b>	with suitable measuring range
	<b>Thermometer</b>	for checking temperature in front of nozzle

### COATING MATERIAL

Sika® Unitherm® Platinum-120:  
17,2 kg oder 3,7 kg  
**Do not thin Sika® Unitherm® Platinum-120!**

### CLEANING OF IMPLEMENTS

Sika® Thinner E+B

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## WORK PROCEDURE

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### PREPARATION

#### **Scheme:**

- Remove the filters (pistol filter and high-pressure filter)  
(Do not use filters during the application of Sika® Unitherm® Platinum-120!)
- Install the storage container
- Clean all implements with solvent
- Pressure test the interconnected implements with solvent

#### **Flow heater:**

- Commissioning of the flow heater:  
Temper the solvent in the circulation at + 25°C bis + 35°C in order to pre-heat the flow heater and hose assembly

#### **Temperature:**

- Material temperature of the component A and B should be between + 10°C und + 30°C
- Optimal results are achieved between + 16°C und + 25°C
- Substrate and ambient environment: min. + 10°C, max. + 40°C
- Relative humidity max. 80%, dew point clearance during processing and initial drying  $\geq 3$  K

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### PROCESSING THE MATERIAL

- Mixer must be clean and free of residues.
- Stir component A, add component B in the specified mixing ratio and mix thoroughly until a homogeneous mixture is achieved
- Ensure that the B-component is completely emptied.
- Feed the material to the storage container. (It is recommended after mixing the components to re-pot the material and briefly stir it).
- Only mix the amount of material required.
- Operate the pump with an input pressure of about 4 bar (increase the pressure if necessary)
- Spraying pressure approx. 200 bar
- Pump solvent out of the circulation

**Material may not be pumped in the circulation.**

Otherwise the accelerated reaction process during the repeated passage can lead to an increase in heat resulting in material curing within the pump / hose area!!!

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**APPLICATION****Nozzle size:**

0.019 - 0.025 inch (0.48 - 0.64 mm)

**Optimised application** can be achieved via the nozzle sizes

0.021 inch up to 1000 µm NFD per work step or

0.023 inch from 1000 µm NFD per work step (0.53/0.58 mm).

The finer spraying pattern is achieved with the 0.021 inch (0.53 mm) nozzle.

**Spraying angle:**

Spraying angle for the steel construction between 20 ° and 40 °.

Optimisation of the angle depends on the sprayed steel structure and variable parameters (e.g. hose length)

**Spraying distance:**

Ensure that there is a sufficient spraying distance between the nozzle and the sprayed steel structure in order not to displace the thick layer coating by the spraying pressure.

**Heater:**

Prior start of spraying increase the temperature to reach a material temperature of approx. + 35°C to + 40°C in front of the nozzle.

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**RINSING, BRAKS AND RECOMMEND BASIS CLEANING****Rinsing:**

The cycle for the rinsing process should be about 3 hours.

Rinsing must then take place.

At the end of the application day a thoroughly cleaning shall be carried out.

Above recommendations apply to substrate and environmental conditions up to + 30°C. Please consider an adjustment to suit local conditions.

**Breaks:**

Normal daily routines should, where possible, be planned with the appropriate breaks. Hence, during each break, rinsing must be carried out and the flow heater switched off immediately.

**Recommend Basis cleaning:**

The basic cleaning of the system is carried out in the same way as the flushing process. The cleaning dilution is pumped several times in the circuit by holding the gun in the material container. It is recommended to install a sieve or filter with a mesh size of 100-200 microns at the outlet of the gun. This serves to remove suspended particles that have been washed out by the dilution.

The connection of the material container to the pump should be cleaned with a suitable brush (e.g. bottle brush).

Finally, remove the filter and pump the cleaning dilution into a suitable waste container.

# IMPORTANT NOTICES

## LEGAL NOTES

The present information, particularly the suggestions for processing and use of our products is based on our knowledge and experience under normal circumstances, provided the products have been properly stored and used. Due to the different materials, substrates and varying operating conditions, no guarantee of operating results or liability on whatever legal basis can be either inferred from these instructions or on the basis of verbal advice unless we are found guilty of gross negligence or intent to cause damage. In such a case the user is obliged to prove that all the information required by Sika in order to make a material and reliable judgement have been provided fully and promptly to Sika. The users shall check the fitness of the products for the anticipated purpose. We reserve the right to alter product specifications. Third party rights shall be observed. Apart from that our respective sales and supply conditions apply. The most recent product data sheet applies. This can be requested from us or downloaded from [www.sika.de](http://www.sika.de). In cases of doubt the German text is valid.

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Fire protection