

KLB-SYSTEM ACRYL

AC 345 Hohlkehlenharz

Solvent-free, rapid-curing and stable acrylic resin for producing concave covings

Packaging units

Article no.	Packaging	Content (kg)	Units/pallet
MA0024-50	Bucket	10.00 kg	45



Product characteristics

Processing time	0 °C / 32 °F : 18 Min. 10 °C / 50 °F: 15 Min. 20 °C / 68 °F: 13 Min. 30 °C / 86 °F: 10 Min.
Processing temperature	Minimum 0 °C / 32 °F (room and floor temperature)
Curing time (accessibility)	0 °C / 32 °F : Approx. 55 min. 10 °C / 50 °F: Approx. 45 min. 20 °C / 68 °F: Approx. 30 min. 30 °C / 86 °F: Approx. 25 min.
Dosage of hardener	0 °C / 32 °F : 5.5 - 6.0 % 10 °C / 50 °F: 3.5 - 4.0 % 20 °C / 68 °F: 2.0 - 2.5 % 30 °C / 86 °F: 2.0 - 2.5 %
Further coatings	1 hour at 20 °C / 68 °F
Consumption	Filled 1.5 - 1.8 kg/running metres for side length of 5 cm
Shelf life	12 months (originally sealed)

Product description

KLB-SYSTEM ACRYL AC 345 Hohlkehlenharz is a rapid-curing and stable polymethacrylics resin which is especially suitable for concave and triangular covings. Process with the added amount of natural and coloured sand based on our recommendations.

KLB-SYSTEM ACRYL AC 345 Hohlkehlenharz is adjusted stable. Therefore, the material offers rapid curing and economical processing properties. The resin has good smoothing properties resulting in liquid-tight covings when staying within the recommended mixing ratios.

When producing smaller covings, **KLB-SYSTEM ACRYL AC 345 Hohlkehlenharz** may be used without any filling additive. The side length may not be larger than 2 cm for each work step.

KLB-SYSTEM ACRYL AC 345 Hohlkehlenharz may be exposed to hot water up to 80 °C / 176 °F for a short period of time and even for a longer period of time when exposed to hot water with temperatures up to 60 °C / 140 °F. **KLB-SYSTEM ACRYL AC 345 Hohlkehlenharz**, just like all other KLB acrylic resin systems, is characterized by a rapid setting, and may also be used at lower temperatures up to 0 °C / 32 °F.

The resin is suitable for use in dry areas and on surfaces exposed to water, when used in combination with other KLB acrylic resins, mainly indoors, but can also be used on outdoor areas.

Area of application

- Use for concave and triangular covings.
- Especially suitable for the food processing industry and everywhere good cleanability is required, e.g. dairy farms, butcher shops and many more.
- For all dry and wet areas, in combination with KLB acrylic resins, for interior and exterior areas.
- For all areas where a floor junction on ascending construction parts is mandatory.
- Use for small area repair work with the smaller grained quartz sand, grain size 0.1/0.3 mm.

Product features

- very rapid-setting
- good smoothing properties
- quickly accessible
- good resistance to water and chemicals
- cures at low temperatures
- reworkable after 1 hour

Technical data

Viscosity	paste-like	-	
Density	0.98	kg/l	DIN EN ISO 2811-2 (20 °C / 68 °F)
Bending tensile strength	15	N/mm ²	DIN EN 196/1
Compressive strength	40	N/mm ²	DIN EN 196/1

The values established in tests are average values. Deviations from the product specification may occur.

Tests

- Product is compliant with DIN EN 13813: 2003-01.

Build-up of coats

- Prepare the substrate by grinding.
- Prime with **AC 20**, consumption approx. 0.350 - 0.450 kg/m², depending on the substrate.
- Apply the covings with the prepared resin/additive mixture, mixing ratio 1 : 3 parts by weight, consumption 1.5 - 1.8 kg/m² (side length approx. 5 cm). We recommend using a special shaped trowel for concave and triangular covings.
- For thicker layers, we recommend to apply the covings on two layers of **AC 345 Hohlkehlenharz** and quartz or colored quartz sand, in order to avoid overheating and the resulting floor staining. The second or upper layer should not be more than 1 cm thick.
- As far as further processing is necessary, it is recommended to use acrylic resin after curing.

Substrate

The substrate to be coated must be even, dry, free of dust, sufficiently resistant to tension and compression as well as be free from weakly-bonded components or surfaces. Materials impairing adhesion such as grease, oil and paint residues should be removed with suitable measures. Substrates suitable for coating are concrete C20/25, cement screed CT-C35-F5 as well as other sufficiently solid substrates. Screeds treated with synthetic dispersions are not always suitable, as the curing reaction of the acrylic resin can be disturbed. In case of doubt, it is recommended to create a test surface. The substrate has to have adequately high strength for the intended occupational use. Coating mastic asphalt is generally not recommended. The substrates to be coated should be prepared mechanically, preferably by shot blasting. The surface strength must then be at least 1.5 N/mm². For concrete, moisture content must not exceed 4.5 CM-%, remaining residual humidity. The possibility of moisture ingress from the rear must be permanently

excluded. Observe the information issued by the trade associations, e.g. the most recent versions of BEB worksheets KH-0/U and KH-0/S. Reconstructing floors may require special procedures; seek technical consultation when necessary. If installation is to be carried out at temperatures below 0 °C / 32 °F, please obtain separate advice.

Mixing

Acrylic resins and acrylic hardener compound will be delivered in individual packaging units. Since the curing reaction depends on the prevailing processing temperature, the acrylic hardener is dosed according to the section on hardener dosing. Add the hardener powder to the resin and stir it in, then add the sand immediately and start working without delay.

For covings, the following mixture is recommended:

1 part by weight **AC 345 Hohlkehlenharz**
3 parts by weight **natural or coloured quartz sand**

Use the same grain size of sand for the covings as used for the coating. Suitable are grain sizes 0.3/0.8 mm or 0.7/1.2 mm.

For small area repair work, the resin can be mixed with 2.0 - 2.5 parts by weight of quartz sand, grain size 0.1/0.4 mm. Floured sand blends are less suitable.

Due to the rapid curing of the material, only partial quantities to be processed within the pot life should be mixed. In any case, note the indicated hardener limits, as curing problems may occur if too little and colour changes may arise if too much is added.

Empty all of the hardener compound into the core component and mix carefully with a slow speed mixer (200 - 400 r/pm) for at least 30 - 60 seconds until the hardener powder is completely dissolved. If aggregates are added to the fillet compound, the resin/hardener mixture is stirred in first; only then can be poured in pigments and any additives.

Processing

Process immediately after mixing because of the short pot-life. With these fast-curing systems, it is important that the work areas are carefully divided before starting and that sufficient personnel are available. The application must always be done "fresh in fresh".

Apply the material in portions in the fillet area and immediately compact and smooth with a fillet tool. Air pockets behind or in the compound must be avoided in any case, as this endangers proper curing.

Adequate air circulation is necessary during and after processing for good curing. Insufficient air ventilation and static air layer may result in curing disturbances. Avoid draught.

Note: curing is adjusted for a temperature range between 0 to 30 °C / 32 to 86 °F. For application at lower temperatures, please obtain manufacturers advice. Floor and air temperature must not fall below 0 °C / 32 °F. If a dew-point situation arises, adhesion may be disrupted. If working conditions are not complied with, the technical properties of the end product may deviate from those specified.

Cleaning

To remove fresh contamination and to clean tools, use thinner **VR 119** immediately after use. Hardened material can only be removed mechanically.

Storage

Store in dry conditions. Ideal storage temperature is between 10 - 20 °C / 50 - 68 °F. Protect especially from direct sunlight. Bring to a suitable working temperature before application. Tightly re-seal opened containers and use the content as soon as possible.

Special remarks

The product is regulated by the German Ordinance on Hazardous Substances (GefStoffV), the German Ordinance on Industrial Safety and Health (BetrSichV), and transport regulations for hazardous goods. The necessary information is contained in the DIN Safety Data Sheet. Observe all identification information on the container label!

GISCODE: RMA 10

Indication of VOC-content:

(EG-Regulation 2004/42) Maximum Permissible Value 500 g/l (2010,II,j/lb): Ready-for-use product contains < 500 g/l VOC.

CE marking

	
KLB Kötztal Lacke + Beschichtungen GmbH Günztalstraße 25 FRG-89335 Ichenhausen	
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AC345HK-V1-062014	
DIN EN 13813:2003-01	
Synthetic resin screed mortar DIN EN 13813: SR-B1.5-AR0.5-IR4	
Fire behaviour	E _f -s1
Emission of corrosive substances	SR
Wear resistance to BCA	AR 0.5
Adhesive tensile strength	B 1.5
Impact resistance	IR 4



Please consider the latest version of this product information on our website.

All stated information is based on our experience and technical preparation. We guarantee the correct and proper quality of our products. We do not assume any responsibility for the work not carried out by us, since we have no influence on the processing or processing conditions. We recommend on-site trials to be conducted in individual cases. With the publication of this new KLB product information, all prior information loses validity. The latest version is available electronically on our website www.klb-koetztal.com. In addition, our "General Terms and Conditions" apply.