

KLB-SYSTEM ACRYL

AC 23

Rapid-setting, low-viscosity 2-component PMMA base coat for block joints

Packaging units

Article no.	Packaging	Content (kg)	Units/pallet
MA0102-53	Canister	10.00 kg	50



Product characteristics

Processing time	0 °C / 32 °F : 15 min. 5 °C / 41 °F : 10 min. 12 °C / 53.6 °F : 8 min. 20 °C / 68 °F : 6 min. 30 °C / 86 °F : 4 min.
Curing time (accessibility)	0 °C / 32 °F : approx. 50 minutes 5 °C / 41 °F : approx. 40 minutes 12 °C / 53.6 °F : approx. 30 minutes 20 °C / 68 °F : approx. 20 minutes 30 °C / 86 °F : approx. 15 minutes
Dosage of hardener	0 °C / 32 °F : 4.0 - 4.5 % 5 °C / 41 °F : 3.0 - 3.5 % 12 °C / 53.6 °F : 2.0 - 2.5 % 20 °C / 68 °F : 1.5 - 2.0 % 30 °C / 86 °F : 1.0 - 1.5 %
Further coatings	After curing and accessibility
Consumption	see the consumption table after section "Processing"
Colours	Non-pigmented
Shelf life	12 months (originally sealed)

Product description

KLB-SYSTEM ACRYL AC 23 is a rapid-setting, non-pigmented, solvent-free, low-viscosity acrylic resin. **KLB-SYSTEM ACRYL AC 23** is used as base coat with good adhesion on screed and concrete, particularly for priming PMMA block joints before the application of acrylic resin grouting resins, such as **KLB-SYSTEM ACRYL AC 353** or **KLB-SYSTEM ACRYL AC 356**.

KLB-SYSTEM ACRYL AC 23, just like all other KLB acrylic resin systems, is characterized by a rapid setting, and may also be used at lower temperatures. If required, by adding an AC accelerator. **KLB-SYSTEM ACRYL AC 23** can be applied in combination with subsequent epoxy coatings; however, a complete scattering with quartz sand 0.7/1.2 mm is necessary.

Note: for priming non-absorbent or low-absorbent substrates, e.g. metal, we recommend adding 10% by weight of the additive **KLB-SYSTEM AC-ADD 25** into the primer to increase the adhesion. **KLB-SYSTEM AC-ADD 25** is supplied in adapted packaging sizes.

Area of application

- Use as base coat before coating with acrylic grouting compounds for block joints.

Product features

- very rapid-setting
- can be reworked after 30 minutes
- easy application onto vertical surfaces
- cures at low temperatures
- good resistance to water and chemicals
- suitable for renovations

Technical data

Viscosity	250	mPas	DIN EN ISO 3219 (23 °C / 73.4 °F)
Density	1.01	kg/l	DIN EN ISO 2811-2 (20 °C / 68 °F)
Water absorption	< 0.2	weight-%	DIN 53495
Shore-hardness D	68	-	DIN 53505 (after 7 days)

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.

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 not recommended. The substrates to be coated should be prepared by milling or grinding the joint profile. 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. Obtain technical 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.

KLB acrylic resin has to be stirred or agitated to a homogeneous resin mixture before processing. Due to the rapid curing of the material, only partial quantities to be processed within the pot life should be mixed. The specified hardener additions must be observed in any case, 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.

Note: for priming non-absorbent or low-absorbent substrates, e.g. metal, we recommend adding 10% by weight of the additive **KLB-SYSTEM AC-ADD 25** into the primer. Be aware that mistakes in the dosage may cause loss of adhesion or hardening problems. **KLB-SYSTEM AC-ADD 25** is supplied in adapted sizes to fit common packaging units. PMMA resins to which the additive has been added are not storage-stable. Therefore, always add the additive directly before processing.

Add KLB-SYSTEM AC-ADD 25 to the acrylic resin before the hardener. Blend thoroughly with a slow speed mixer. Then the hardener powder is added.

Processing

The joints are cut/chiselled out according to the desired joint profile and freed from loose material. If necessary, clean the joint edges with thinner, e.g. **VR 119**. Then insert a closed-cell PE round cord of suitable joint width to prevent three-flank adhesion. Prime the joints with **AC 23** and, if needed, scatter openly with quartz sand 0.7/1.2 mm.

Adequate air circulation is necessary after application 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 - 30 °C / 32 - 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.

Note: PMMA resins are highly flammable and subject to the Ordinance on Hazardous Substances. Observe the instructions in the safety data sheet and on the container!

Processing

	Joint width				
	10 cm	15 cm	20 cm	25 cm	30 cm
Void depth	Consumption per running metre of joint in grams				
15 mm	51-61	64-80	82-103	100-126	118-149
20 mm	55-65	68-84	85-107	104-130	122-154
25 mm	59-69	72-88	90-111	109-135	127-159
30 mm	62-73	76-92	94-116	113-140	132-164
35 mm	66-77	80-96	99-120	117-144	136-168
40 mm	70-81	84-100	103-125	122-149	141-173
45 mm	74-85	88-104	107-129	126-154	145-178
50 mm	78-89	92-104	111-133	130-158	150-183
Important note:	The values indicated in this table shall only be seen as a reference. The actual consumption may deviate from these values due to different roughness depths in the substrate.				

Cleaning

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

Storage

Store in dry and if possible, at frost-free conditions. Ideal storage temperature is between 10 - 20 °C / 50 - 68 °F. 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 20

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 89335 Ichenhausen, GERMANY	
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AC23-V1-072023	
DIN EN 13813:2003-01	
Synthetic resin screed mortar DIN EN 13813: SR-B1,5-AR0,5-IR4	
Fire behaviour	E _{fl} -s1
Emission of corrosive substances	SR
Wear resistance BCA	AR 0,5
Adhesive tensile strength	B 1,5
Impact resistance	IR 4



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