

## Baltoflake

### Product description

This is a glass flake reinforced unsaturated polyester coating. It is an ultra high build, extremely abrasion resistant and fast curing barrier coating. Can be used as primer, mid coat or finish coat in atmospheric and immersed environments. Suitable for properly prepared carbon steel, stainless steel, aluminium and approved primers.

### Typical use

Recommended for areas subject to extreme mechanical wear and harsh exposure conditions. Recommended for offshore environments, including splash zones, jetties, piles, tidal zones, decks, battery rooms, power stations, exterior of buried tanks, concrete bunds, refineries, bridges, mining equipment and general structural steel where future maintenance is challenging.

### Approvals and certificates

APAS approved to specification 2917, 2917F, 2917P and 2917S  
Norsok M501 / ISO 20340

Additional certificates and approvals may be available on request.

### Colours

selected range of colours

### Product data

Property	Test/Standard	Description
Solids by volume	theoretically calculated	96 ± 2 %
Gloss level (60 °)	ISO 2813	matt (0-35)
Flash point	ISO 3679 Method 1	34 °C
Specific gravity	calculated	1,25 kg/l
VOC-USA / VOC Hong Kong	EPA Method 24	80 g/l
VOC-Solvent Emission Directive	SED (1999/13/EC)	3 g/kg

The provided data is typical for factory produced products, subject to slight variation depending on colour.  
Gloss level: According to Jotun Performance Coatings' definition.

### Recommended film thickness per coat

Film thickness and spreading rate	Dry film thickness	Wet film thickness	Theoretical spreading rate
	(µm)	(µm)	(m <sup>2</sup> /l)
Minimum	600	650	1,52
Maximum	1500	1650	0,61
Typical	750	820	1,21

All vinyl ester and polyester resin systems are subject to some shrinkage during the curing process. This results in a practical spreading rate lower than the theoretically calculated. The shrinkage depends on actual dry film thickness applied and conditions during application.

## Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

### Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	Sa 2½ (ISO 8501-1) with a surface profile Fine to Medium G (ISO 8503-2)	Sa 2½ (ISO 8501-1) with a surface profile Fine to Medium G (ISO 8503-2)
Aluminium	Sa 2½ (ISO 8501-1) with a surface profile Fine to Medium G (ISO 8503-2)	Sa 2½ (ISO 8501-1) with a surface profile Fine to Medium G (ISO 8503-2)
Stainless steel	Cleanliness and surface profile corresponding to Sa 2½, Fine G (ISO 8503-2)	Cleanliness and surface profile corresponding to Sa 2½, Fine G (ISO 8503-2)
Coated surfaces	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1)	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1)

## Application

### Application methods

The product can be applied by

Spray: Standard airless spray may be used. Dedicated two component airless spray is an option.

### Mixing ratio table - Additives

The steel temperature shall not be lower than the paint temperature and not more than 20 °C above the paint temperature.

Additive volumes (ml) in 16 litres product.

Additive	Paint temperature					
	10-14 °C	15-19 °C	20-24 °C	25-29 °C	30-34 °C	35-40 °C
Jotun Accelerator CO1P	300 *					
Jotun Peroxide 1	300 *	300 *	200 *	200	200	200
Jotun Inhibitor 51				200	200	400

\* Not applicable for Baltoflake FC

### WARNING:

**Jotun Accelerator and Jotun Peroxide must never come in direct contact with each other.**

All peroxides must be stored in a dark and cool storage room (below 25°C), and kept away from all kind of combustible materials. Exposure to direct sunlight must be avoided. Use only original or approved containers. Empty containers should be washed with water and kept in separate storage/containers.

The peroxide may catch fire if exposed to sparks or to hot metal dust from grinding or other mechanical work. The curing reaction develops heat. For leftovers of mixed paint it is recommended to fill the tin with water to avoid excessive heat development.

### Thinner/Cleaning solvent

Thinner:	Styrene
Thinning max.:	5 %
Cleaning solvent:	Jotun Thinner No. 17 / Jotun Thinner No. 27

### Guiding data for airless spray

Nozzle tip (inch/1000):	27-35
Pressure at nozzle (minimum):	150 bar/2100 psi

## Drying and Curing time

Substrate temperature	10 °C	23 °C	40 °C
<b>Baltoflake</b>			
Surface (touch) dry	3 h	2 h	2 h
Walk-on-dry	5 h	2 h	2 h
Dried to over coat, minimum	5 h	2 h	2 h
Dried to over coat, maximum, atmospheric	20 h	12 h	12 h
Dried/cured for service	4 d	2 d	1 d
<b>Baltoflake FC</b>			
Surface (touch) dry		2 h	2 h
Walk-on-dry		2 h	2 h
Dried/cured for service		2 d	1 d

Drying and curing times are determined under controlled temperatures and relative humidity below 85%, and within the DFT range of the product.

Baltoflake FC should not be overcoated with itself or Baltoflake.

Procedure for repair of minor areas are found under Repair of coating system.

**Surface (touch) dry:** The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness. Dry sand sprinkled on the surface can be brushed off without sticking to or causing damage to the surface.

**Walk-on-dry:** Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

**Dried to over coat, minimum:** The shortest time allowed before the next coat can be applied.

**Dried to over coat, maximum, atmospheric:** The longest time allowed before the next coat can be applied without any surface preparation.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

## Induction time and Pot life

**Paint temperature** **23 °C**

Pot life 45 min

Reduced at higher temperatures

## Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	90 °C	100 °C
Immersed, sea water	50 °C	50 °C

Peak temperature duration max. 1 hour.

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Note that the coating will be resistant to various immersion temperatures depending on the specific chemical and whether immersion is constant or intermittent. Heat resistance is influenced by the total coating system. If used as part of a system, ensure all coatings in the system have similar heat resistance.

## Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Previous coat: unsaturated polyester, unsaturated vinyl ester

Subsequent coat: unsaturated polyester, polyurethane, polysiloxane

## Packaging (typical)

	Volume (litres)	Size of containers (litres)
Baltoflake	16	20

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

## Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

### Shelf life at 23 °C

Baltoflake 6 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

## Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray 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.

## Colour variation

Products primarily meant for use as primers and antifoulings may have slight color variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

## Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.