

Medium viscous methacrylate resin for sealing  
Plastifloor® coatings in wet areas of the  
food industry

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**Characteristics:** Plastifloor® 527 N is a topcoat, particularly on floors broadcast with sand and smoothed coatings based on Plastifloor® 332 N, Plastifloor® 510 N or Plastifloor® 418 N in production plants of the food industry with increased water and fat load. Plastifloor® 527 N is characterized by:

- Good self-levelling
- Low yellowing tendency
- Increased resistance to water up to 176 °F
- Increased resistance to acids and alkalis

### Characteristic data:

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#### Plastifloor® 527 N

Delivery form	Liquid, violet	
Flow time	26-32 s	68 °F (4mm DIN cup)
Density	8,34 lb/gal	DIN 53217
Flash point	+ 50 °F	DIN 51755
Curing time	30-40 min	68 °F (1% Hardener)
Shelf life	In the original container, closed, dry, cool, frost-free max. 6 months	
Bundle	55,12 lb, 22,04 lb pails 396,83 lb barrels	

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#### Plastifloor® Additive 527

Delivery form	Liquid, transparent	
Flow time	16300 cps	77 °F
Density	9,93 lb/gal	77 °F
Shelf life	In the original container, closed, dry, cool, frost-free max. 6 months	
Bundle	22,04 lb, 11,02 lb cans	

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### Processing notes:

Processing: Stir up well all Plastifloor® resins before application! Pour the required preparation quantity into a mixing pail and stir in Plastifloor® Additive 527 for about 1 min by using a suitable agitator. After stirring in the Plastifloor® hardener 50 W (1 min), the sealer is poured out onto the floor and immediately dispersed evenly.

# Plastifloor® 527 N (USA)

**PLASTI CHEMIE**

**Produktionsgesellschaft mbH**

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Best results are obtained with 0,017 gal/ft<sup>2</sup> by roller step with short hair (polyamide gold stripe) on sand broadcast coatings (15 - 30 mesh grain).

For proper curing, at least 0,010 gal/ft<sup>2</sup> sealer must be applied per rolling step. To ensure the necessary slip resistance and to avoid yellowing and flaking, the maximum layer thickness is limited to 0,019 gal/ft<sup>2</sup>.

Scratch and water resistance can be ameliorated by using hardener/M. Hardener/M leads to a mat surface. Please mind the indications on the product data sheet.

Mixing approach: 2,11 gal Plastifloor® 527 N  
0,11 gal Plastifloor® Additive 527  
2,71 oz Plastifloor® Hardener 50 W  
(5,41 oz Plastifloor® Hardener/M)

Material consumption: 0,010 – 0,017 gal/ft<sup>2</sup>

Curing time: Continue the coating work only after full hardening of the previous layer.

Temperature [°F] **	Hardener [Vol-%] *	Pot time [min]	Curing time [min]
+ 41 to + 50	2	~ 35	~ 50
+ 50 to + 68	1,5	~ 30	~ 40
+ 68 to + 77	1	~ 25	~ 35
+ 77 to + 86	1	~ 20	~ 30

\* Hardener quantity calculated on amount of Plastifloor® 527 N (Hardener 50 W)

\*\* The temperature specifications are based on resin, soil and air temperature

Attention: At temperatures below 32°F, the resin needs to be put into a warm environment before processing - minimum 41°F and add up to 2% hardener maximum. Basically accelerator cannot be added to sealers – neither as thinner nor as accelerator – due to yellowing aspects.

## Additional

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**Information:**

Plastifloor® 527 N can be used as clear sealer in interior and exterior zones. Elastic coatings with Plastifloor® 332 N should be sealed with Plastifloor® 528 N PUMMA-Hybrid if it is an exterior area. Otherwise there may appear hair-line cracks on the surface. To avoid yellowing, the hardener quantities in the table must be adhered to exactly. Good cross ventilation during processing assures good curing. A good cross ventilation ensures a good curing during processing.

Due to the thermoplastic property of MMA-resins, black stripes by forklift loading may appear (skidmarks). Using hardener/M lowers the occurrence of skid and roller marks.

**Storage:**

Methacrylate resins are subject to the handling regulations of highly flammable materials. Plastifloor resin has to be stored cool, at temperatures between 59 – 68° C and protected from direct sun.

During storage paraffin particles can be deposited. Therefore materials have to be stirred thoroughly before processing the mixture. Please note the advice of our safety datasheet.

data concerning our products and devices as well as concerning our data and procedures are based on an extensive research work and an application technology experience. We obtain these results, with which we do not take over adhesion going beyond the respective single contract, in word and writing after best knowledge, reserve ourselves we however technical changes in the course of the product development. Beyond that our application technology service stands when desired for large consultation as well as for co-operation with the solution manufacturing and application technology problems for order. That does not relieve the user however to examine our data and recommendations before their use responsible for the own use. That applies - particularly for deliveries to foreign markets - also regarding the keeping of patent rights third as well as for applications and procedures, which are not expressly in writing indicated by us. The case of loss our adhesion is limited to indemnifications of same extent, as they plan our general terms of delivery and sales with lack of quality.