

Plastifloor® 465 (GB)

Methacrylate Resin for Durable Cold Plastic Road Markings

- Description**
- low viscosity methacrylate resin used as a binder for permanent markings based on cold plastic
 - permanently elastic and is processed without plasticizers
 - viscosity of ready formulated material is stable over a long period
 - versatile use as: flat line, profiled and structure markings
 - recommended surface temperature for application is between 5°C and 45°C
 - good wetting properties for fillers and pigments
 - for use in cold and warm climates
- Application**
- markings at junctions and crossings, stop lines and direction arrows
 - centre markings on freeways and highways
 - manual application by trowel and draw box
- Equipment**
- manual application by trowel and draw box
 - application by hand guided machines
 - application by 2-component extrusion machines with 100:2 dosing
 - application by draw box (100:2 system), even for profiled and structure markings
- Properties**
- suitable for high temperatures
 - permanently elastic
 - resistant to ageing and weathering
 - colorfast
 - abrasion-proof
 - resistant to de-icing salt and fuels
 - low tendency to graying

Technical Data

Form supplied in		liquid
Efflux time at 23 °C	ISO 2431	75 – 95 s/4 mm
Viscosity at 23 °C	Brookfield LVDV II+	approx. 250 mPa·s
Density at 20 °C	DIN 51757	0.97 g/cm ³
Flash point	DIN 51755	+ 11 °C
Shelf life	(dark at <20 °C)	min. 6 months
Bundle		180 kg drums 25 kg, 10 kg pails

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Typical formulations:

465 – 1 For hand, draw box or machine application

**1,5 - 3 mm
 100:2 system
 flat**

		pbw
Binder / Resin	Plastifloor® 465	20.00
Dispersing Additive	Tego Dispers 670	0.10
Rheology Additive	Byk 410	0.10
Rheology Additive	Bentone 27	0.10
Pigment (TiO₂)	Tioxide TR 92	10.00
Fine filler (15µm)	Omyacarb 15GU	20.00
Coarse filler (0.1 – 0.4mm)	Cristobalite M72	25.00
Premix beads	50 – 250 µm	25.00

Viscosity test method (23°C):

Blot test for CP: between 8 – 9 cm
 Daniel flow gauge: between 13 - 14
 Shore D hardness (DIN 53505) 50 - 60

Density: 1.85 kg/l
Consumption: approx 3.7 kg/m² for 2 mm thickness

465 – 2 Application with suitable machines with profile function

**up to 7 mm
 100:2 system
 profile**

		pbw
Binder / Resin	Plastifloor® 465	20.00
Dispersing Additive	Tego Dispers 670	0.10
Rheology Additive	Byk 410	0.20
Rheology Additive	Bentone 27	0.30
Pigment (TiO₂)	Tioxide TR 92	10.00
Fine filler (15µm)	Omyacarb 15GU	20.00
Coarse filler (0.1 – 0.4mm)	Cristobalite M72	25.00
Premix beads	50 – 250 µm	25.00

Viscosity test method (23°C):

Blot test for CP: approx. 6 cm
 Daniel flow gauge: between 10 - 12
 Shore D hardness (DIN 53505) 50 - 60

Density: 1.85 kg/l
Consumption: 4 - 6 kg/m² depending on used profile

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465 – 3

Application with suitable structure machines

**up to 7 mm
 100:2 system
 structure**

		pbw
Binder / Resin	Plastifloor® 465	20.00
Dispersing Additive	Tego Dispers 670	0.10
Rheology Additive	Byk 410	0.20
Rheology Additive	Bentone 27	0.30
Pigment (TiO₂)	Tioxide TR 92	10.00
Fine filler (15µm)	Omyacarb 15GU	25.00
Premix beads	100 – 600 µm	25.00

Viscosity test method (23°C):

Blot test for CP: approx. 6 cm
 Daniel flow gauge: between 10 - 12
 Shore D hardness (DIN 53505) 40 - 50

Density: 1.85 kg/l
Consumption: 1.5 - 3 kg/m² depending on used structure

Initiator/Hardener Hardener powder 50W (50% BPO), temperature dependent.

Pot Life and Setting Time Typical formulations 465 – 1, 465 – 2 and 465 – 3
 Approved hardener: Hardener powder, as a proportion of total formulation

Temperature (°C) (surface)	Hardener (50% DBPO) (% by weight)	Pot life (min)	Setting time (min)
+10	3.0	14	45
+10	2.0	18	50
+20	2.0	10	30
+20	1.0	15	35
+30	1.0	8	20
+30	0.5	12	30
+40	0.5	6	18

Note Manual dosage of hardener powder can use mixing ratios from the table.
 Automatic dosage of hardener usually uses a mixing ratio between 1.5 – 2 %.

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.