Polythane 461

POLYURETHANE FINISH

Product Description:

A two-pack acrylic polyurethane finish that offers excellent durability and long-term recoatability.

Typical Uses:

Polythane 461 is recommended as a top coat for original equipment machines, auto ancillaries and maintenance coating where mild chemical resistance along with good abrasion resistance and decorative finish are required. It has excellent salt and corrosion resistance properties under severe atmospheric conditions.

Technical Properties:

Color / Shades	Available in all shades
Gloss	Smooth & Glossy
Volume Solids	55 ± 2%, mixed
Specific Gravity	***1.28 ± 0.1*** gm/cm^3
Mix ratio	7:1 by volume
Typical Thickness	40-80 microns [1.6-3.2 mils] dry equivalent to 73-145 microns [2.9-5.7 mils] wet
Coverage	11 m²/liter at 50 microns DFT (theoretical)
Flash Point	30^{0}C [86°F]
VOC	***< 446 g/Lit***
Reducer/Thinner	Thinner P1
Cleaner	Thinner C1

Drying Time

Surface Temperature		**0°C**	**20°C**	**40°C**
Touch		1 h 40 min	45 min	20 min
Surface		-	60 min	-
Overcoating	Minimum	18 hours	6 hours	1 h 40 min
	Maximum	Ext	Ext	Ext
Fully Cured		-	7 days	-
Pot Life		6 hours @ 10^{0}C	4 hours	-

These figures are provided at dry film thickness of 50 microns DFT at standard conditions.

Surface Preparation:

All surfaces should be clean, dry, and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

Cleanliness: Blast cleaning to min. Sa 2½ (ISO 8501 1:2007).

In case blasting is not possible, then the surface of steel should be cleaned to St-2/St-3 Standard. The surface should be absolutely dry, moisture and oil free before primer application.

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Application

Application Method	Thinning	Application Parameters
Airless Spray	10%	Nozzle pressure: 150 bar [2200 psi] Nozzle orifice: 0.017-0.019"
Air Spray	10%	Not Applicable

If brush or roller application is used, more coats will be necessary to achieve the specified dry film thickness. Pressure is for a material temperature of 20°C [68°F].

Note:

- It is of vital importance that the nozzle and other parts including the static mixer of the spraying equipment are cleaned properly directly after the work is done due to the PU paint.
- The hoses should be used with high pressure of good quality and no longer than necessary.
- The hose length between the mixer & gun should be less than 1 meter.
- Preferably store both paint components at 20-25^{0}C. Be aware that higher storage temperatures will shorten the life of the paint.
- For stripe/repair coating, however, a lower paint temperature may be favorable in order to get a sufficient pot life.

Storage

Shelf Life: 12 Months, when sealed

Storage Conditions: Store indoors at 4.5^{0}C [40^{0}F] to 38^{0}C [100^{0}F]

The product must be stored in accordance with national regulations. Keep the containers in a cool and dry place and well-ventilated area with no direct source of heat or light. Containers must be kept tightly closed when not in use.

Safety: Handle with care. Before & during use, observe all safety labels on packaging and paint containers, consult Material Safety Data Sheets, and follow all local or national safety regulations. Avoid inhalation, avoid contact with skin & eyes, and do not swallow. Take precautions against possible risks of fire or explosions as well as protection of the environment. Apply only in well-ventilated areas.