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PRODUCT INFORMATION SHEET

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2 PACK POLYURETHANE FINISH

Description:

2 PACK POLYURETHANE is a non-yellowing finish with outstanding chemical and abrasion resistance. The product has excellent exterior durability due to its fastness to UV light thereby providing maximum gloss and colour retention.

Uses:

2 PACK POLYURETHANE is intended as a topcoat over a selected range of undercoats and primers in the marine, transport, chemical and building industries. Typically used on steel structures, industrial equipment and machinery such as found in manufacturing and chemical plants, hospitals, food processing plants, dairies, and abattoirs. Ideal for surfaces subjected to frequent cleaning with strong detergents and mechanical brushing, chemical and solvent spillage, and heavy wear and tear.

Properties:

Fast drying
Outstanding adhesion.
High abrasion resistance.
High gloss and colour retention.
Excellent hardness and chemical resistance.

Suitable Substrates:

After suitable preparation and priming, *2 PACK POLYURETHANE* may be applied to steel, galvanised and zinc coated steel, aluminium, fibreglass, SMC, particle board, MDF and timber structures.

May be applied direct over the following *HiChem* primers:

- *2Pack Red Primer.*
- *2 Pack Iso-Free High Build Primer-Isolator.*
- *2 Pack Epoxy Primer.*
- *2 Pack High Build Primer/Filler.*
- *Super Etch Primer*

May be applied over suitable previously painted surfaces after isolating with *2 Pack Iso Free High Build Primer-Isolator*. Test a small area.

Surface Preparation

Steel:

Prepare by abrasive blast cleaning to AS1627.4 Class 2.5.
Clean and degrease with *Prepwash*.
Apply *HiChem 2 Pack Epoxy Primer* to a dry film build of 50 microns.

Galvanised steel, zinc coated steel and aluminium:

Abrade with abrasive pad such as Scotchbrite.
Clean and degrease with *Prepwash*.
Apply *HiChem Super Etch Primer* to a dry film build of 6-12 microns.

Fibreglass:

Sand with 280-320 grit paper.
Degrease with *Prepwash*.
Apply *HiChem 2 Pack Epoxy Primer*.

Previously painted surfaces:

Remove loose and flaking paint.
Sand until all gloss is removed. (280-320 grit paper).
If bare metal is exposed, carefully feather edges of remaining paint. Spot prime bare metal using *2 Pack Iso Free High Build Primer-Isolator*.
Prime whole surface with *2 Pack Iso Free High Build Primer-Isolator*.

Timber, MDF, Particle board:

Sand with 280-320 grit paper.
Prime with *2 Pack Iso-Free High Build Primer-Isolator*.

Mixing/Thinning:

1. Mix 3 parts by volume of 2 Pack Polyurethane with 1 part by volume of 2 Pack Polyurethane Hardener Stir the base portion thoroughly before use. Add the Hardener slowly while stirring and continue to blend for 5 minutes. Allow a further 20 minutes induction time.
2. Thin up to 30% by volume of the total mix with *Thinner 315N(Normal)* or *Thinner 315S(Slow)*. Slow thinner should be used on large jobs and in temperatures above 25 Deg °C.
3. Mix thoroughly.
May be tinted with *HiChem 2 Pack Colour* tinters. Use maximum of 10% by weight. Mix with the base *Polyurethane* prior to addition of *Hardener*.

Application:

1. May be applied using conventional spray gun with a jet size of 1.8 to 2.0mm, or airless spray.
2. Brush or roller may be used for small areas only.
3. Apply in 2-3 passes allowing 10 minutes flash off between passes; to a dry film thickness of 50 microns. In certain aggressive conditions a second coat may be required. The first coat should dry for not less than 5 hours nor more than 48 hours. If this time is exceeded, abrade the surface, solvent wipe(*Thinner T315N*) and apply the next coat.
4. Do not apply when the temperature is below 10°C or above 35°C or when the relative humidity is above 80%. The surface temperature must also be at least 3°C above the dew point.
5. Full cure, hardness and chemical resistance is not reached in less than 5 days after application.

Drying time:

Surface dry in 45 minutes at 20°C. Hard dry in 8 hours at 20°C.

Potlife:

Approximately 6 hours at 20°C.

Polishing:

After full cure is achieved (5 days) imperfections may polished out with appropriate 2 pack cutting and polishing compounds.

Coverage:

Theoretical coverage at 50 microns dry film thickness is 10.0 m² per litre. Material losses during application will vary and must be taken into account when calculating requirements.

Clean up:

Clean up with *ThinnerT315N*.

Storage:

Store in a cool dry place. Always replace the lids securely after use.
Shelf life 24 months in unopened sealed container if stored away from heat and moisture.

Safety:

See material safety data sheet.

Standard Packages and Product Codes:

1. Stock Colours:

	Colour	15 Litre	5 Litre	3 Litre	1 litre
Polyurethane Finish	Clear (Internal use only)	2PPUC15		2PPUC3	-
	White	2PPUW15		2PPUW3	-
	Black	2PPUB15		2PPUB3	-
Polyurethane Hardener	-		2PPUH5	-	2PPUH1

2. Factory Made Colours:

Colours matched to customer requirements.
Minimum order 200 litres.

The information contained in this bulletin is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.