



POLY U400 METALLIC

P50.02

DESCRIPTION

- a two pack recoatable isocyanate- cured, acrylic polyurethane metallic finish
- approved to APAS-2911/1
- conforms to AS/NZS 3750.6

PRINCIPAL CHARACTERISTICS

- metallic finish
- unlimited recoatability
- excellent resistance to atmospheric exposure
- excellent gloss retention
- tough, flexible and abrasion resistant
- resistant to splash of mineral oils, vegetable oils and aliphatic petroleum products
- for best protection overcoat with Poly U400 antigrffiti clear

COLOURS AND GLOSS

- Metallic - full gloss

BASIC DATA AT 25° C

- solids content approx. 40% by volume
- mix ratio 4A:1B by volume
- typical film thickness (per coat) 50 microns(dry), 125 microns(wet)
- theoretical spreading rate 8 m²/l for 50 microns(dry)
- touch dry after refer curing table for details
- overcoating interval refer overcoating table for details
- full cure after 7 days
- shelf life (cool and dry place) at least 12 months

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- previous suitable coat must be dry and free from chalking and contamination and sufficiently roughened if necessary
- oil and grease should be removed from all surfaces in accordance with AS 1627.1 solvent cleaning
- substrate temperature must be at least 5°C during surface preparation, application and curing and at least 3°C above dew point
- relative humidity should not exceed 75% during application and before the dry to handle time

INSTRUCTIONS FOR USE

- mixing ratio by volume 4A:1B
- induction time - none
- pot life at 25°C 5 hours for standard hardener, (3 hours for rapid recoat hardener). Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- this product must be thinned with the recommended thinner before application
- thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure



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- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to WattyI

APPLICATION

- **AIRLESS SPRAY**
 - Not recommended
- **AIR SPRAY**
 - recommended thinner Thinner L707 (or blend to retard drying with L745)
 - volume of thinner 15 - 25%
 - nozzle orifice..... 1.4 - 1.8 mm
 - nozzle pressure 0.3 - 0.4 MPa (50 - 60 psi)
- **BRUSH / ROLLER**
 - Not recommended
- **CLEANING SOLVENT** Thinner L707

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this paint contains 0.049% monomeric diisocyanate when mixed. Provide adequate ventilation during use. Breathing the vapour is dangerous. Avoid breathing of fumes. Where applied by spray, use suitable air-fed respiratory equipment/hood at all times
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)



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ADDITIONAL DATA

Overcoating table - with Poly U400

Substrate temperature	Poly U400 Std PT B				Poly U400 Rapid Recoat PT B			
	5°C	15°C	25°C	35°C	5°C	15°C	25°C	35°C
Minimum interval	36 hrs	24 hrs	16 hrs	6 hrs	24 hrs	12 hrs	6 hr	3 hrs
Maximum interval	unlimited				unlimited			

- surface must be free from chalking and contamination

Curing table

Substrate temperature	Poly U400 Std PT B			Poly U400 Rapid Recoat PT B		
	Touch dry	Dry to handle	Full cure	Touch dry	Dry to handle	Full cure
5°C	8 hrs	36 hrs	16 days	4 hrs	16 hrs	16 days
15°C	4 hrs	24 hrs	10 days	2 hrs	10 hrs	10 days
25°C	2 hrs	16 hrs	7 days	1 hr	6 hrs	7 days
35°C	1 hr	8 hrs	5 days	30 min	3 hrs	5 days

- adequate ventilation must be continuously maintained during application and curing

Potlife (at application viscosity)

Paint temperature	Poly U400 Std PT B	Poly U400 Rapid Recoat PT B
15°C	8 hrs	5 hrs
25°C	5 hrs	3 hrs
35°C	3 hrs	2 hrs

CUSTOMER SERVICE HOTLINE 132101 (Aust)

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