

CODE: PU-840

PRODUCT NAME:

Acrylic-Aliphatic Urethane Primer

DESCRIPTION:

PU-840 is a two component aliphatic polyurethane primer, which has excellent resistance to chemical, industrial and marine environments. PU-840 forms an impact and abrasion resistant coating where a wide range of corrosion resistance is required for chemical plants and equipments. PU-840 may also be applied over epoxy primers as tie coats.

TECHNICAL DATA:

Binder	Acrylic-Urethane
Pigment	Anti corrosion pigments
Finish	Flat
Shade	Light grey
Specific gravity after mixing	1.4±0.1 Kg/Lit
Volume solids	50±2 %
Flash point	26 °C
Typical dry film thickness	50-75 Microns per one coat
Number of coat	One
Mixing ratio by weight	Base : 100 parts Hardener : 16 parts
Substrate	Prepared steel ,Aluminum,galvanized
Application method	Conventional or airless spray , brush , roller
Thinner / Cleaner	T-850
Weight of added thinner	Maximum 10%
Induction Time at 20 c	30 minutes
Theoretical spreading rate (at 50 microns)	10 M ² /Lit
Packing	Base : 25kg Hardener:4 kg
Shelf life	12 Months

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Drying Time

Temp	Touch dry	Hard dry	<u>Overcoating</u>		Full cure
			Min	Max	
15°C	90 minutes	13hours	10 hours	Not limited	9 days
25°C	40minutes	9hours	7hours	Not limited	7 days
40°C	15 minutes	6hours	4 hours	Not limited	3 days

Note: Drying times are dependent on applied film thickness; all data in this catalogue are reported at recommended DFT.

Pot life

Temp. of paint	15°C	25°C	40°C
Pot life	10 hours	6 hours	3 hours

Surface preparation

All surfaces to be coated clean dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:1992.

Where necessary, remove weld spatter, and where required smooth weld seams and sharp edges.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning

Abrasive Blast cleaning

Abrasive blast clean to Sa2 1/2 (ISO 8501-1:1988) or SSPC-SP10. If oxidation has occurred between blasting and application of PU-840, the surface should be reblasted to the specified visual standard

For thin layer systems a sharp, angular surface profile of 35-50 mic is recommended.

For heavy duty systems angular surface profile of 30-40 microns is recommended..

Surface preparation shall not take place in the following conditions:

- A) At temperature below 5 °C
- B) When the relative humidity greater than 85%
- C) When the metal surface temperature is less than 3 °C above the dew point
- D) Outside day light hours on exterior locations



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Application Method

Material is supplied in two containers as a unit. Always mix a complete unit in the proportion supplied. Once the unit has been mixed it must be used within the working Pot life specified.

1-Agitate part A with a power agitator.

2-Combined entire contents of curing agent (part B) With Base (Part A) and mix thoroughly with power agitator.

(Stir during application to maintain uniformity of material.)

Application Equipments

Air less Spray	Tip range 0.017-0.021 inch output pressure at spray tip not less than 141 Bar (2000 psi)	Total
Air Spray	Nozzle orifice 1.8-2mm Nozzle pressure: 2-4 Bar (29-58 psi)	
Brush	Typically 30 mic can be achieved.	
Roller	Typically 30 mic can be achieved.	

Note: The components of polyurethane are reactive with moisture. Keep containers dry and tightly sealed to avoid moisture contamination.

ENVIRONMENTAL CONDITIONS:

- To prevent moisture condensation during application, surface temperature must be at least 3 °C above dew point.
- Never apply coatings under reverse environmental condition.
- In hot climate, material temperature should be 20 to 25 °C prior to mixing; otherwise pot life becomes very short.
- For satisfactory cure, air and surface temperature must be above 10 °C.
- Paint shall not be applied when wind speed is in excess of 7 m/s

Air temperature	10 to 40 °C
Surface temperature	10 to 50 °C
Material temperature	10 to 30 °C
Relative humidity	MAX 80 %

HEALTH AND SAFETY:

This product is Flammable. Keep away from heat and open flame .Keep container closed .Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to the health:

- 1-Circulate adequate fresh air continuously during application and drying.
- 2-Use fresh air masks and explosion proof equipment.
- 3- Prohibit all flames, sparks, welding and smoking.

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