

DESCRIPTION

- ultra-premium, two component isocyanate cured, direct to metal polyurethane topcoat, with a high gloss finish.

PRINCIPAL CHARACTERISTICS

- excellent colour and gloss retention
- excellent resistance to exterior exposure
- tough, flexible and abrasion resistant
- unlimited recoatability with suitable preparation
- resistant to splash of mineral and vegetable oils, white spirit, paraffins and aliphatic petroleum products
- resistant to splash of mild chemicals
- can be air dried or force dried up to 60°C on metal to improve throughput

Note: we advise that you test this product to determine if it is suitable for your particular use.

COLOURS AND GLOSS

- white, AS2700 Colours
- colours obtained by tinting with Ultratint tinters
- full gloss

RECOMMENDED FILM THICKNESS (PER COAT)

	Minimum	Maximum	Typical
Dry film thickness microns	40	65	50
Wet film thickness microns	77	125	96
Theoretical spreading rate m ² /l	13.0	8.0	10.4

BASIC DATA AT 25°C AND 50% RELATIVE HUMIDITY

- vehicle type..... polyurethane
- solids content approx..... 52 % by volume
- mix ratio 4A:1B by volume
- surface dry after 2-4 hrs
- hard dry after 4-6 hours
- full cure 7 days

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- best coating performance will be obtained with the highest degree of surface preparation
- improved coating performance and increased anti-corrosion protection will be obtained through use of a suitable primer. Refer product compatibility for recommended primers.
- degrease thoroughly to remove all oil, grease and other surface contaminants
- substrate temperature should be at least 3°C above dew point
- relative humidity should not exceed 75 % during application and before the dry to handle time

MILD STEEL, GALVANISED STEEL, IRON AND ALUMINIUM

- remove all loose material by wire brush or mechanical sander
- lightly blast or mechanically abrade the entire surface using P80-180 grit paper/disc (avoid excess removal of zinc during surface preparation).

STAINLESS STEEL

- lightly blast using inert grit or power tool clean to achieve a roughened uniform flat appearance

APPLICATION INSTRUCTIONS

- mixing ratio by volume 4A:1B
- mix Colourthane DTM540 Part A with Colourthane DTM540 Part B only
- induction time - none
- pot life at 25°C 1-2 hours. Do not use after this time even if the mix is still liquid
- stir the individual components and the mixed product well using a mechanical mixer
- 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
- 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 Valspar

APPLICATION METHODS

- **AIR SPRAY**
 - recommended thinnerColourthane Reducers
 - volume of thinnerup to 10 %
 - nozzle orifice approx.1.4-1.8 mm
 - nozzle pressure3.0-4.5bar (45-65 psi)
- **HIGH VOLUME LOW PRESSURE (HVLP)**
 - recommended thinnerColourthane Reducers
 - volume of thinnerup to 10 %
 - nozzle pressure0.7bar (10 psi) max
- **BRUSH/ROLLER**
 - recommended thinnerColourthane Reducers
 - volume of thinnerup to 10 %

NOTE: the maximum dry film thickness that can be achieved when brushing and rolling is 30 microns.

- **CLEANING SOLVENT**.....Colourthane Reducers

REDUCER GUIDE

Temperature	<15°C	20°C	25°C	30°C	>35°C
Colourthane Reducer Fast	█				
Colourthane Reducer Standard		█			
Colourthane Reducer Slow				█	

* thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions

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 0.03% 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 Safety Data Sheet (SDS)

ADDITIONAL DATA

Overcoating Table-

Overcoating interval for Colourthane DTM540 when top coating with itself

Interval	5 °C	15 °C	25 °C	35 °C	60 °C
Minimum	30 hrs	18 hrs	12 hrs	6 hrs	35 mins
Maximum	6 days	3 days	36 hrs	24 hrs	70 mins

Curing Table-

Substrate Temperature	5 °C	15 °C	25 °C	35 °C	60 °C
Surface Dry	12 hrs	6 hrs	3 hrs	1.5 hrs	10 mins
Hard Dry	30 hrs	18 hrs	12 hrs	6 hrs	35 mins
Pot Life (at application viscosity)	6 hrs	3 hrs	1-2 hrs	45 mins	N/A

* adequate ventilation must be continuously maintained during application and curing

PRECAUTIONS

- for recommendations outside those contained in this data sheet, refer to Valspar

PRODUCT COMPATIBILITY

Primers

- Colourthane Etch Primer
- Colourthane NS300
- Colourthane PF330
- Epiname UC230
- Epiname PR250
- Epiname PR360ZPS
- Epiname EB600

Topcoats

- Colourthane DTM540

STORAGE AND PACKAGING

- shelf life at least 12 months in an unopened container
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging
 - 20 Lt kit (16 Lt Part A (when tinted), 4Lt Part B)
 - 5 Lt kit (4 Lt Part A (when tinted), 1Lt Part B)

For the most up to date information visit our website or Contact Valspar Customer Service Hotline on:

www.wattylpc.com
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