

DESCRIPTION

- a two pack recoatable isocyanate cured, high build satin acrylic polyurethane finish
- conforms to AS/NZS 3750.6

PRINCIPAL CHARACTERISTICS

- satin 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
- resistant to splash of mild chemicals

COLOURS AND GLOSS

- White - satin

RECOMMENDED FILM THICKNESS (PER COAT)

	Minimum	Maximum	Typical
Dry film thickness microns	100	100	100
Wet film thickness microns	170	170	170
Theoretical spreading rate m ² /l	6.0	6.0	6.0

BASIC DATA AT 25 °C

- solids content approx..... 60% by volume
- mix ratio 6A:1B by volume
- touch dry after 2 hours
- full cure 7 days
- temperature resistance 95 °C (dry), 35 °C (wet)

SURFACE PREPARATION

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

APPLICATION INSTRUCTIONS

- mixing ratio by volume 6A:1B
- mix Poly U630 Part A with Poly U630 Part B only
- induction time - none
- pot life at 25 °C - 4 hours. 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
- 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
- Valspar recommends the use of coating inspection reports in compliance with AS/NZS 3894.10,11,12 refer to Information Sheet I-20 for more information
- for recommendations outside those contained in this data sheet, refer to Valspar

APPLICATION METHODS

- **AIRLESS SPRAY**
 - recommended thinner Thinner L747
 - volume of thinner 0-10%
 - nozzle orifice approx. 0.33mm (0.013 inch)
 - nozzle pressure 15 MPa (2100psi)
- **AIR SPRAY**
 - recommended thinner Thinner L747
 - volume of thinner 10-15%
 - nozzle orifice approx. 1.4-1.8mm
 - nozzle pressure 0.3-0.4 MPa (50-60 psi)
- **BRUSH/ROLLER**
 - recommended thinner Thinner L754
 - volume of thinner 5-10%
 - The maximum dry film thickness that can be achieved when brushing/rolling is 50 microns
 - Multiple coats may be required to achieve the recommended dry film thickness
- **CLEANING SOLVENT**..... Thinner L747

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 0.024% 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)

ADDITIONAL DATA

Overcoating Table

Overcoating interval for Poly U630 HB Satin when top coating with itself

Interval	5 °C	15 °C	25 °C	35 °C
Min	36 hrs	24 hrs	16 hrs	8 hrs
Max	Unlimited when dry and free from any chalking and contamination			

Curing and Potlife Table

Paint temperature	5 °C	15 °C	25 °C	35 °C
Touch Dry	8 hrs	4 hrs	2 hrs	1 hr
Dry to handle	36 hrs	24 hrs	16 hrs	8 hrs
Full cure	16 days	10 days	7 days	5 days
Potlife (at application viscosity)		6 hrs	4 hrs	2 hrs

- 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

- Duranamel PR7 Etch
- Epinamel UC230
- Epinamel PR250
- Epinamel PR360ZPS
- Epinamel CP502
- Epinamel EB600
- Epinamel DTS680
- Epinamel DTM985

Topcoats

- Poly U630 HB Satin

STORAGE AND PACKAGING

- shelf life at least 12 months
- all components shall be stored in a dry internal environment at between 5 °C and 35 °C
- packaging 20litre kit (17.1 litre Part B, 2.9 litre Part B)
- product line: 2027



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For the most up to date information contact Valspar Customer Service Hotline or visit the Wattyl Website.

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