

604 ACRYLIC URETHANE ENAMEL – Fluoro Colours

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Revised: Nov 2008

DESCRIPTION

604 ACRYLIC URETHANE ENAMEL - FLUORO COLOUR are specifically pigmented, bold strong colours where the fluorescent effect under ultra-violet light is required. They must be applied over a white background and overcoated with 604 ACRYLIC URETHANE ENAMEL - CLEAR.

FLUORO COLOURS have limited outside life to direct sunlight before fading and 6 months is the best that can be expected. To extend the life of the coating, if possible, keep the painted object away from direct sunlight when not in use.

SUITABLE SUBSTRATES

604 ACRYLIC URETHANE ENAMEL is ideally suited for use over the following primers:

- 408 EPOTEC PRIMER
- 429 PARAPHOS PRIMER
- 443 PARAFILL PRIMER/FILLER
- 464 PARATHON PRIMER/ SURFACER
- 466 PARABUILDICF PRIMER FILLER
- 575 POLYESTER SPRAY PUTTY – once re-primed with any of the above primers

It can also be used over degreased and sanded baked enamel, two pack enamel and fibreglass. Due to the diversity of use of this product, it is recommended that potential users contact the PROTEC TECHNICAL SERVICE DEPARTMENT for advice regarding each specific application.

DRYING

At normal ambient conditions and a nominal film thickness of 40 microns, 604 ACRYLIC URETHANE ENAMEL is:

- **DUST FREE** 5 minutes
- **TOUCH DRY** 15-20 minutes
- **DRY TO HANDLE** 4 hours

Full cure is not achieved for at least 7 days under normal conditions. PROTEC 604 ACRYLIC URETHANE ENAMEL may be low baked for 20 minutes at 60°C.

POT LIFE

- Once 604 ACRYLIC URETHANE ENAMEL -PACK A has been mixed with 604 HARDENER -PACK B the useable life of the mixed material is approximately 3 to 4 hours, depending on the ambient temperature.
- Higher ambient temperatures may considerably reduced the pot life, therefore do not mix any more material than can be immediately used.

EQUIPMENT

	Spray Gun Fluid Tip	Spray Pressure
Gravity feed spray gun	1.4-1.6 mm	280-375 kPa (35-55 psi)
Suction feed spray gun	1.4-1.8 mm	280-375 kPa (35-55 psi)



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MIXING RATIO

- Mix 4 parts by volume of 604 ACRYLIC URETHANE ENAMEL -PACK A with 1 part by volume of 604 HARDENER -PACK B.
- 604 HARDENER - PACK B -may be any of the following depending on the ambient conditions and requirements. Refer to PROTEC TECHNICAL SERVICE DEPARTMENT for advice.
 - 604-9101 Standard Hardener
 - 604-9016 Medium Hardener
 - 604-9033 Slow Hardener

THINNING

For normal spray application, thin the mixed material (4 parts by volume 604 Pack A & 1 part by volume Pack B) by addition of approximately 50% by volume of the appropriate Reducer.

- 604 Reducers - R125 -604 ACRYLIC URETHANE REDUCER. (normal thinner for solid colours)
- R229 604 ACRYLIC URETHANE MEDIUM REDUCER. (slower drying thinner for solid colours in warmer conditions or over larger areas)

APPLICATION

- Apply two or three medium coats of 604 ACRYLIC URETHANE ENAMEL - HIGH OPACITY WHITE allowing a few minutes flash off between coats.
- Leave the white to flash off for 30 minutes then apply two or three medium coats of 604 ACRYLIC URETHANE ENAMEL - FLUORO COLOUR allowing a few minutes flash off between coats.
- Leave the fluoro colour to flash off for 30 minutes then apply two or three medium coats of 604 ACRYLIC URETHANE ENAMEL - CLEAR, as the final coat, allowing a few minutes flash off between coats.

PRECAUTIONS

Avoid breathing vapour and contact with skin. Ensure all mixing and handling of hardener and paint containing hardener is carried out under working conditions that prevent skin contact or inhalation of vapour. Wear impervious gloves in a ventilated booth filled with an effective filtered exhaust system. Do NOT smoke whilst handling this material. Breathing of fumes or spray mist can cause sensitisation and asthma like reaction. Persons suffering from chronic respiratory problems should not use this product. Hardener is extremely sensitive to moisture and should be used as soon as possible after opening. Keep all containers thoroughly closed when not in use.

HEALTH AND SAFETY

PROTEC 604 ACRYLIC URETHANE ENAMEL contains flammable solvents and must be kept away from heat and open flames. Do not smoke whilst handling this product. PROTEC 604 ACRYLIC URETHANE HARDENER - PACK B also contains a maximum content of 0.3% volatile free Isocyanate. Avoid breathing the vapour and unnecessary skin contact. Breathing vapour, spray mist or dust from sanding is harmful and may cause lung irritation and asthma-like respiratory reaction. Keep containers thoroughly sealed when not in use. When spraying mixed material (Pack A to which Pack B has been added) the operator must wear a positive pressure air supplied full face respirator. The spray area must be isolated from other people whilst spraying is in progress and until all spray mist has been effectively dispersed. Spray in a booth fitted with an effective filtered exhaust system and comply to local regulations regarding spray painting.



TECHNICAL DATA SHEET

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FIRST AID

Eyes	If splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.
Skin	If splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use.
Inhalation	If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.
Ingestion	If swallowed, give glass of water to drink and seek medical assistance. DO NOT induce vomiting.

Consult separate Material Safety Data Sheet for more detailed Health and Safety information.