



609 COLOURCOAT URETHANE ENAMEL

Page 1/3
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DESCRIPTION

609 COLOURCOAT URETHANE ENAMEL is a premium quality, high solids, two pack acrylic urethane enamel specifically formulated for painting of large commercial vehicles.

It has been designed for low bake oven curing but will air dry satisfactorily under normal ambient conditions. It has been developed in Australia, for maximum performance under Australian conditions with outstanding resistance to outdoor weathering and UV degradation. 609 COLOURCOAT URETHANE ENAMEL is ideally suited for the repair and refinishing of all large vehicles including trucks, buses, rail wagons and locomotives.

609 COLOURCOAT TINTING SYSTEM

This is a solid colour only Tinting System consisting of a range of 24 tinters based on the highest quality, light fast automotive grade pigments. All tinters are carefully standardised and controlled to ensure uniformity in both colour strength and tone.

Colour mixing formulations for most popular vehicle manufacturers solid colours are available, as well as, for a large number of fleet colours.

FEATURES

609 COLOURCOAT URETHANE ENAMEL exhibits the following outstanding properties :

- High solids
- High opacity
- Ease of application
- Exceptionally high gloss
- Excellent hardness and abrasion resistance
- Outstanding resistance to weathering

SUITABLE SUBSTRATES

609 COLOURCOAT URETHANE ENAMEL is ideally suited for use over the following primers:

- 408 EPOTEC PRIMER
- 429 PARAPHOS PRIMER
- 443 PARAFILL PRIMER/FILLER
- 466 PARABUILD ICF PRIMER FILLER
- 472 RAPID EPOXY PRIMER SURFACER
- 426 VINYL ETCH PRIMER – Black and Grey
- It can also be used over degreased and sanded baked enamel and 2 Pack enamel.

MIXING RATIO

Mix 4 parts by volume of 609 COLOURCOAT URETHANE ENAMEL - PACK A - with 1 part by volume of 609 COLOURCOAT URETHANE ENAMEL HARDENER - PACK B

- STANDARD HARDENER
- RAPID HARDENER

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DRYING

AIR DRY: At normal ambient temperatures of 20 -25°C 609 COLOURCOAT URETHANE ENAMEL will be:

- DUST FREE 30 minutes
- TOUCH DRY 3-4 hours
- HARD DRY 16 hours

Full cure will not be attained for at least 7 days.

LOW BAKE: Temperature referred to below is not booth air temperature but body metal temperature.

	40°C	60°C
• DUST FREE	5 minutes	3 minutes
• TOUCH DRY	45 minutes	25 minutes
• HARD DRY	70 minutes	40 minutes

POT LIFE

- Once 609 COLOURCOAT URETHANE ENAMEL - PACK A has been mixed with 609 COLOURCOAT URETHANE ENAMEL HARDENER - PACK B, the useable life of the mixed material is approximately 4 - 6 hours @ 25°C.
- Higher ambient temperatures may considerably reduce the pot life.

THINNING

- For normal spray application, thin the mixed material with 30 – 40% by volume of R199 PARAGLAZE ACRYLIC URETHANE ENAMEL REDUCER.
- Optimum spraying viscosity is 18 - 21 seconds BS4 @ 25°C.

APPLICATION

Apply two medium full coats allowing 10 minutes flash off between coats. Spray gun set up:

	Fluid Tip	Spray Pressure
Gravity Feed	1.4-1.6 mm	300 - 450 kPa
Suction Feed	1.4-1.8 mm	300 - 450 kPa

HVLP – DeVILBISS - Gravity

Mixing Ratio	4 : 1 V/V
Thinner Ratio / Reducer	30 – 40 % R199
Air Cap Number	105
Fluid Tip (mm)	1.4 – 1.6
Pressure at Air Cap	2 Bar / 29 psi
Paint Visc Flow Cup 25°C	18 - 20 sec
Distance from Object	180 – 210 mm

RECOATING

- May be recoated after baking at 60°C for 40 minutes or air dry overnight at 25°C. Product is tape free after the same time frame.



609 COLOURCOAT URETHANE ENAMEL

Page 3/3
Revised: Apr 2008

PACK SIZES

609 COLOURCOAT URETHANE ENAMEL - PACK A - MIXED COLOURS

- 4 Litres

609 COLOURCOAT URETHANE ENAMEL - TINTERS

- 4 Litres and 1 Litres (Reduced Colours only)

609 COLOURCOAT URETHANE ENAMEL - Pack B – HARDENER

- 1 Litre

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

609 COLOURCOAT URETHANE ENAMEL contains flammable solvents and must be kept away from heat and open flames. Do not smoke whilst handling this product. 609 COLOURCOAT URETHANE ENAMEL 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.

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.