

Purlac Polyurethane Enamel

Product Description	A two pack polyurethane gloss finish for use on protective systems for steelwork.				
Features & Use	<ul style="list-style-type: none"> • A two pack polyurethane finish with maximum performance and high durability characteristics • Allows quick turnaround due to rapid film hardening with excellent chemical and solvent resistance • Suitable for commercial and industrial usage where a high gloss, durable finish is required, such as the ACE market • Easily cleaned gloss surface 				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Gloss				
Volume Solids	44 ± 2% (varies with colour)				
VOC Content	495 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	40 µm	91 µm	11.0 m ² /litre	
	Maximum	50 µm	114 µm	8.8 m ² /litre	
	Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated				
Drying Times	Applied to 40 microns DFT	+10°C	+23°C	+35°C	
	Dust Free		1½ hr	40 min	
	Hard Dry		10 hr	8 hr	
	Overcoating	Minimum	3 hr	1 hr	45 min
		Maximum	4 days	3 days	2 days
	Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation				
Colours	BS, RAL and shades to order				
Mix Ratio/ Product Code	Base	11PPE-	3 parts by volume		
	Hardener	11PHV-ACT-	1 part by volume		
Pot Life	4 hours at 23°C				
SG	1.14 kg/lit mixed (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23°C – 60°C				

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Surface Preparation	<ul style="list-style-type: none"> This product is a finish coat and should be applied over an appropriate primer or intermediate coating All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts or other contamination 														
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.														
Thinner	No.6 Thinner		Equipment Cleaner No.6 Thinner												
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15°C.														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="451 864 692 938">Method</th> <th data-bbox="692 864 938 938">Airless Spray</th> <th data-bbox="938 864 1185 938">Conventional Spray</th> <th data-bbox="1185 864 1339 938">Brush</th> <th data-bbox="1339 864 1482 938">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="451 938 692 994"></td> <td data-bbox="692 938 938 994">Yes</td> <td data-bbox="938 938 1185 994">Yes</td> <td data-bbox="1185 938 1339 994">No</td> <td data-bbox="1339 938 1482 994">No</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	No	No
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<ul style="list-style-type: none"> Airless Spray: output fluid pressure at tip 1800-2500 psi, Tip Size: 15-21 thou (0.38-0.53mm). It is recommended that a mist coat be applied, followed by a further full coat, allowing 15 minutes flash off between coats Conventional spray: thin up to 10% with Thinner No.6, 40-60 psi pressure 															
Product Notes	<ul style="list-style-type: none"> For optimum opacity use a primer/undercoat of a suitable shade High humidity and condensation will impair gloss if exposed during application and curing Contains isocyanates – refer to Safety Data Sheet Material temperature should be a minimum of 10°C at application Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide, to provide solid coverage 														
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.														

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