VITRETHANE 470

TECHNICAL DATA SHEET

Two Pack Satin Direct to Metal

A & I Coatings VITRETHANE 470 is a two-pack polyurethane with good adhesion and corrosion resistance properties for ferrous and non-ferrous metals. Vitrethane 470 can be used over an epoxy primer or intermediate coat as part of a 2 or 3 coat system.

USES & BENEFITS	As a single coat Direct to Metal coating for: • Aluminium Metal Steel • Copper and its alloys • Aluminium Sheet & Extrusions • Trusses • Structural Steel • Purlins • Galvanized Steels • Metal Fabrications				
	Benefits 1. Excellent adhesion to a variety of suitably prepared substrates 2. Positive curing even at low temperatures		Limitations 1. In early stages of curing the film may be susceptible to mechanical damage		
PHYSICAL PROPERTIES	Vehicle Type	Acrylic			
	Hardener	Isocyanate			
	Ratio	Pack A : Pack B = 4:1 by Volume			
	Pot Life	6 Hrs +/- 1Hr @ 25ºC			
	Finish	Satin			
	Theoretical Coverage	5.7 m²/Litre @ 75 µ DFT or 182 µ WFT (white Satin)			
	Volume Solids	33% - 43% (dependent on gloss/ finish)			
	Recommended DFT	75 µm			
	Usual No. of Coats	1-2 Coats			
	Colour	Tintable to a range of colours			
	Pigmentation	Various			
	Product Weight	Pack A 1.0- 1.3Kg/L, Part B 0.9Kg/L (dependant on gloss/ finish)			
	Abrasion Resistance	Good			
ENGINEERING DATA	Flexibility	Good			
	Bacterial Resistance	Good			
	Chemical Resistance	Good			
	Dry Heat Resistance	Up to 120 ºC			
	Solvent Resistance	Good			
	Salt Spray Resistance	Good			
	Durability	Good			
CURING DATA	Substrate Temp.(ºC)	Touch Dry	Dry to Handle	Full Cure	Recoat Min
	Standard Hardener 25°C	25 Min	6 Hrs	7 Days	4 Hrs

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APPLICATION DATA	Mixing	Sir Part A before use and mix with V470 Part B at 4:1 ratio, by volume.
	Application	Airless, HVLP, Air atomisation.
	Cleaning	Vitrethane 102 Cleaning Thinners or Vitrethane 111 Medium Thinners.
	Thinning	Vitrethane 111. Up to 20%.
	Typical Specification	Mild Steel: Cleanse to AS1627.1 Vitrethane 470 to 60 Microns Aluminium/Galvanised Steel: Cleanse to AS1627.1 Vitrethane 470 to 60 Microns
SURFACE PREPARATION	All Surfaces	All surfaces to be structurally sound and free of contamination, particularly salt deposits. Loose or flaking paint must be removed by abrasive blast cleaning, power tool cleaning or sanding. Oil, grease, dirt etc must be removed with detergent and water blasting in accordance with AS 1627.1.
	Aluminium, galvanised steel & Zincalume	Remove oil and grease with mild detergent or with solvent to AS 1627.1. Slightly roughen the surface by sanding or light whip blasting with a non-metallic abrasive. Apply suitable primer according to specification.
	Steel	Degrease the surfaces and remove all weld spatter and flux. Grind sharp edges and corners. For best results abrasive blast clean to specified/recommended AS 1627-1 to 10 class Sa 2.5. Apply A & I Coatings VITRETHANE 470 DTM Coating to specification. Please consult A & I Coatings Technical Team for particular specifications. Surface prep note: Surface profile to be 20-30 microns.
WORK STOPPAGES	General	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with A & I Coatings recommended cleaner. Once units of paint have been mixed, they should not be resealed, and it is advised that after prolonged stoppages work commences with freshly mixed units.
	Clean Up	Clean all equipment after use with A & I Coatings recommended cleaner. It is good work practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including delays.
PACKING & STORAGE	Packing	Available in 5 or 20L kits. For availability of other sizes, contact A & I Coatings.
	Storage	12 months if stored in sealed containers away from heat and moisture. Subject to re-inspection thereafter.

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HEALTH & SAFETY	This product contains isocyanate. All applicable statutory regulations must be observed in the application of this product. Users must first read the Material Safety Data Sheet for Vitrethane 470. Users should familiarize themselves with all the safety aspects of the product prior to usage. Please ensure the current Technical Data Sheet is consulted prior to specification or application of A & I Coatings products. If the surface intended to be painted differs from the specification, please consult the A & I Coatings Technical team on 1800 819 585.

All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation. Note: The figures quoted for pot life and drying/curing times are not definitive. They are dependent on-site conditions, such as volume of material mixed, ambient and substrate temperatures, weather and ventilation.

DISCLAIMER: Since the use and application of this product is beyond our control we cannot be held responsible for product field performance. The information presented above is the result of our considerable experience with this product but is not to be construed as a performance warranty