VITRETHANE 630

TECHNICAL DATA SHEET

Two Pack Polyurethane Exterior Coating

A & I Coatings **VITRETHANE 630** is a solvent based two pack acrylic urethane with very good exterior durability and excellent application properties. It is quick drying and well suited to onsite application.

USES & BENEFITS	Industrial roller shutters • Steelwork • Refurbishment of weathered • Colourbond fascias • Suitable for toys and playground equipment in accordance with AS1924.1 • Truck bodies • Machinery				
	Benefits 1. VITRETHANE 630 is quick drying, therefore intended for on-site application – its overspray will not damage adjacent sensitive surfaces provided adequate precautions are taken.				
PHYSICAL PROPERTIES	Vehicle Type	Reactive acrylic resin			
	Hardener	Aliphatic isocyanate			
	Mixing Ratio	4: 1 (Part A : Part B) by Volume			
	Pot Life	4 hours at 20ºC			
	Finish	Brilliant gloss or satin			
	Theoretical Coverage	8m2/litre/50 microns theoretical (dependent on colour of coating)			
	Volume Solids	42 ± 2 % (White)			
	Recommended DFT	50 to 100 microns			
	Usual No. of Coats	1 to 2			
	Colour	Unlimited colour range			
	Pigmentation	Titanium Dioxide and other organic and inorganic pigments			
	Product Weight	Pack A 0.96 – 1.28Kg/L dependent on pigmentation; Pack B 0.99Kg/L			
ENGINEERING DATA	Abrasion Resistance	Excellent resistance to scrubbing and sand abrasion			
	Flexibility	Excellent flexibility - adequate for normal substrate movement			
	Bacterial Resistance	Good			
	Chemical Resistance	Good			
	Solvent Resistance	Moderate resistance to solvents and oils			
	Dry Heat Resistance	Good			
	Durability	Very Good			
CURING DATA	Substrate Temp.(ºC)	Surface Dry	Dry to Handle	Full Cure	Recoat Min
	25°C	30 Mins	1 Hr	7 Days	15-30 Mins
	Note: Maximum Recoat Time - within 48 hours at 25ºC. Abrade to secure mechanical bond after this.				

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APPLICATION DATA	Mixing	Pack A to be mixed thoroughly, then thoroughly mix Pack A with Pack B (Hardener) prior to use.
	Application	Airless, air assisted airless, electrostatic, HVLP, air atomisation. (A & I Coatings technical staff can advise on the most appropriate equipment for a specific task). Brush and roller are only suitable for small areas.
	Cleaning	V102 Cleaning Thinners or V111 Medium Thinners.
	Thinning	Thin up to 10% with V111 medium thinners if necessary. Thin to a viscosity of 16-20 seconds Ford Cup No 4 using VITRETHANE V111 Medium Thinners below 25°C or V108 Slow Thinners above 25°C or V112 Retarder above 30°C. Normally about 15 – 20% is required.
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.
	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 preferred primer to specification. Please consult A & I Coatings Technical team for specifications.
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 packs. 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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ADDITIONAL DETAILS	Suitable Primer	V440, V560, V586
	Suitable Intermediate coat	V416MIOX, V419 STE, V425
HEALTH & SAFETY	All applicable statutory regulations must be observed in the application of this product. Users must first read the Safety Data Sheet for V630. Users should familiarize themselves with all the safety aspects of tl product prior to usage	

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