VITRETHANE 640

TECHNICAL DATA SHEET

Two Pack Polyurethane Premium Exterior Coating

A & I Coatings VITRETHANE 640 is a two-pack high-performance reactive acrylic crosslinked with aliphatic isocyanates at room temperature or under low bake conditions.

USES & BENEFITS	• Locomotive and Rolling Stock • Earthmoving Machinery & Equipment • Agriculture Equipment • Truck and Trailer bodies				
	Benefits: 1. Excellent weathering performance. 2. Excellent application properties. 3. Excellent chemical resistance. 4. Good recoat ability.				
PHYSICAL PROPERTIES	Vehicle Type	Acrylic polyol			
	Hardener	Isocyanate			
	Mixing Ratio	2: 1 (Part A: Part B) by Volume			
	Pot Life	4 hours at 20ºC			
	Finish	Full Gloss or 50% Gloss			
	Theoretical Coverage	9m2/litre/50 microns theoretical (dependent on colour of coating)			
	Volume Solids	48 ± 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	1.02 – 1.40Kg/L (Pack A); 0.99 – 1.03Kg/L (Pack B)			
ENGINEERING DATA	Abrasion Resistance	Excellent resistance to scrubbing and sand abrasion			
	Flexibility	Excellent flexibility - adequate for normal substrate movement			
	Bacterial Resistance	Excellent			
	Chemical Resistance	Excellent resistance to a wide range of organic and inorganic acids. Good resistance to alkalis. Excellent resistance to water-splash and immersion.			
	Solvent Resistance	Excellent resistance to solvents, petrol and oils.			
	Salt Spray Resistance	Excellent			
	Graffiti Resistance	Excellent, most graffiti damage removed simply with cleanser			
	Dry Heat Resistance	Good			
	Durability	Superior			
CURING DATA	Substrate Temp.(ºC)	Surface Dry	Dry to Handle	Full Cure	Recoat
	25°C	45 Mins	6 Hrs	7 Days	2-12 Hrs

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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 to a viscosity of 16-20 seconds Ford Cup No 4. Normally approx 20-30% with V111 Medium Thinners < 15° V108 Slow Thinners 15°C - 25°C V115 Retarder >25°C
SURFACE PREPARATION	All Surfaces	All surfaces to be structurally sound and free of contamination, particularly salt deposits. lose 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 VITRESET 580 Primer to specification. Please consult A & I Coatings Technical team for particular specifications.
	CFC and Cementitious Board	All surfaces to be structurally sound and free of contamination, particularly salt deposits. Loose or flaking paint must be removed by 180 grit sandpaper with orbital sanding to achieve smooth uniform surfaces, providing a sound mechanical key profile for the topcoat to adhere to. Ensure surface is dry and free of all sand, dust, oil, grease and moisture before application of primer – Vitrethane 555 or similar.
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).

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PACKING & STORAGE	Packing	Available in 6 or 24L 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.
ADDITIONAL DETAILS	Suitable Primer	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 V640. Users should familiarize themselves with all the safety aspects of 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 onsite 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. For additional information, phone our Customer Service Centre.

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RESULTS DELIVERED

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