

VITRETHANE 650IF

TECHNICAL DATA SHEET

Two Pack Isocyanate Free Polyurethane



A & I Coatings VITRETHANE 650IF is a solvent based two pack isocyanate free polyurethane with very good exterior durability and excellent application properties.

USES & BENEFITS	• Original equipment manufacture • Steelwork • Trucks and buses • Mining infrastructure • Suitable for toys and playground equipment in accordance with AS1924.1 • Machinery • Rolling Stock						
	Benefits 1. High-performance isocyanate free polyurethane. Patent No 2021218019 2. Brilliant gloss		3. Fast Cure Times 4. Meets the requirements of AS3750.6 Paints for steel structures full gloss polyurethane (two-pack) 5. Australian Made and owned.				
PHYSICAL PROPERTIES	Vehicle Type		Based on Polyurethane resin				
	Hardener		Proprietary				
	Mixing Ratio		4 : 1 (Part A : Part B) by Volume				
	Pot Life		4 Hrs @20°C (Do not use beyond pot life)				
	Finish		Gloss & Satin				
	Theoretical Coverage		10 m² / Litre/ 50µm DFT				
	Volume Solids		50 % (White)				
	Recommended DFT		50-100 µm DFT				
	Usual No. of Coats		1 – 2 Coats				
	Colour		Unlimited Colour Range				
	Pigmentation		Titanium Dioxide and other organic and inorganic pigments				
	Product Weight		Pack A 0.96 – 1.28Kg/L; Pack B 0.99Kg/L				
	VOC Content		393.76g/L				
	ENGINEERING DATA	Abrasion Resistance		Excellent resistance to scrubbing and sand abrasion			
Flexibility		Excellent flexibility - adequate for normal substrate movement					
Solvent Resistance		Moderate resistance to solvents and oils					
Dry Heat		Good					
Bacterial Resistance		Good					
Chemical Resistance		Good					
Salt Spray Resistance		Good					
Durability		Very Good					
CURING DATA	Substrate Temp.(°C)		Surface Dry		Through Dry	Full Cure	Recoat Min
	15°C		30 Min		8 Hrs	10 Days	30 Mins
	25°C		15 Min		6 Hrs	7 Days	15 Mins
	30°C		10 Min		4 Hrs	5 Days	10 Mins

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APPLICATION DATA	Mixing	Mix Part A and Part B in a ratio of 4:1 by volume and stir thoroughly
	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
	Thinning	V111 Medium Thinners
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, Gal 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 VITRETHANE 560 Primer to specification. Please consult A & I Coatings Technical team for particular 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 recommences 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 and 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 (ambient temperature). Subject to re- inspection thereafter.

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HEALTH & SAFETY

All applicable statutory regulations must be observed in the application of this product. Users must first read the Safety Data Sheet for V650IF. Users should familiarize themselves with all the safety aspects of the 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 information, phone our Customer Service Centre.



PO Box 820 Moss Vale, NSW 2577

7 Lackey Road Moss Vale NSW 2577

Australia 1800 819 585

International +61 2 4869 1441

Fax +61 2 4868 3031

Email helpdesk@aicoatings.com

www.aicoatings.com.au