# VITRETHANE 650IF

## TECHNICAL DATA SHEET

Two Pack Isocyanate Free Polyurethane

A&I COATINGS

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

| | | | |
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| **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<br>1. High-performance isocyanate free polyurethane. Patent No 2021218019<br>2. Brilliant gloss | 3. Fast Cure Times<br>4. Meets the requirements of AS3750.6 Paints for steel structures full gloss polyurethane (two-pack)<br>5. Australian Made and owned. | |
| **PHYSICAL PROPERTIES** | Vehicle Type | Based on Polyurethane resin | |
| | Hardener | Proprietary | |
| | Mixing Ratio | Full Gloss: 4:1 (Part A : Part B) By Volume<br>Satin: 3:1 (Part A : Part B) by Volume using SATIN Hardener | |
| | Pot Life | 4 Hrs @20°C (Do not use beyond pot life) | |
| | Finish | Full 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 | Full Gloss: Mix Part A and Part B in a ratio of 4:1 by volume and stir thoroughly.<br>Satin: Mix Part A and SATIN Part B in a ratio of 3:1 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 approved primer. 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 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 and delays. |
| **PACKING & STORAGE** | Packing | Full Gloss: Available in 5 or 20L Packs.<br>Satin: Available in 4 or 12L Packs. |
| | Storage | 12 months if stored in sealed containers away from heat and moisture (ambient temperature). Subject to re- inspection thereafter. |

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| **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 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.

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RESULTS DELIVERED

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