# 625 POLYTHANE

## PRODUCT DESCRIPTION

Commercial Performance Coatings 625 Polythane is a high performance, re-coatable acrylic polyurethane enamel with superior opacity.

It is used in atmospheric chemical and marine service where gloss and colour retention, hardness and abrasion resistance are required.

Commercial Performance Coatings 625 Polythane is available in a range of colours from the AS2700 and RAL Classic colour ranges.

## PRODUCTS

| | | | |
|---|---|---|---|
| Polythane Mixed Colour | | 625 | |
| Hardeners | | 625-9220 | Polythane Hardener Slow |
| | | 625-9225 | Polythane Hardener Standard |
| | | 625-9386 | Polythane Hardener Fast |
| | | 625-9807 | Polythane 4:1 HS Hardener |
| Accelerator | | AA-5770 | Protec Accelerator Additive |
| Reducers | *Cold conditions* | PUR10 Polyurethane Reducer Fast | |
| | *Normal conditions* | PUR20 Polyurethane Reducer Normal | |
| | *Hot conditions* | PUR30 Polyurethane Reducer Slow | |
| | *Very Hot conditions* | PUR40 Polyurethane Reducer Extra Slow | |
| Cleaners | | 971-9119 PROTEC® Metal Conditioner | |
| | | AA-6822 *Protec* Heavy Duty Wax & Grease Remover | |

## SUBSTRATES & PREPARATION

Commercial Performance Coatings 625 Polythane can be applied over the following primers:

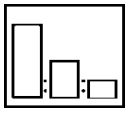
- EPS EtchPro, PAR Paraloc, VIN Vinyl Etch, Sigmaprime 200, Sigmacover 280
- EPO Epotec Primer Surfacer, BAR Barrierprime, ZPH High Build Primer
  SLX Self Levelling Epoxy Primer

Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

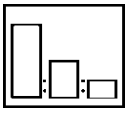
*For other primer options please consult the PPG Commercial Performance Coatings Technical Team.*

## MIXING RATIO BY VOLUME



***625-9220, 625-9225, 625-9386 HARDENERS***

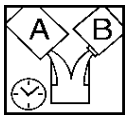
| PRODUCT | PARTS | |
|---|---|---|
| 625 Polythane Mixed Colour | 2 | |
| Hardener | 1 | AA-5770 Accelerator-Up to 10%, this can reduce the drying time up to 50% depending on the weather |
| Reducer | Up to 15% | |



***625-9807 4:1 HS HARDENER***

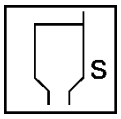
| PRODUCT | PARTS | |
|---|---|---|
| 625 Polythane Mixed Colour | 4 | AA-5770 Accelerator-Up to 10%, this can reduce the drying time up to 50% depending on the weather |
| Hardener | 1 | |
| Reducer | Up to 25% | |

## POT LIFE




Catalysed material is useable for up to 6 hours at 25°C

## SPRAY VISCOSITY




| | |
|---|---|
| CONVENTIONAL, HVLP | 16 - 24 seconds (B4) at 25°C |
| AIRLESS, AIR ASSISTED AIRLESS | 20 - 30 seconds (B4) at 25°C |

## SPRAYGUN

***CONVENTIONAL, HVLP***

**SETUP**

| | |
|---|---|
| • GRAVITY | 1.4 mm - 1.6 mm |
| • SUCTION | 1.4 mm - 1.8 mm |

**SPRAY PRESSURE**

| | |
|---|---|
| • CONVENTIONAL | 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi) |
| • HVLP / RP | 2 - 3 bar |

***AIRLESS, AIR ASSISTED AIRLESS***

**SETUP**

| | |
|---|---|
| • TIP | 0.007 - 0.015 |
| • PUMP RATIO | 32:1 |

**SPRAY PRESSURE**

| | |
|---|---|
| • AIRLESS | 100 - 140 bar |
| • AIR ASSISTED AIRLESS | 70 - 100 bar |

## APPLICATION & FLASH OFF

| | |
|---|---|
| CONVENTIONAL, HVLP | 2 wet, even coats |
| AIRLESS, AIR ASSISTED AIRLESS | 1 - 2 wet, even coats |

Allow 10 - 15 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80% or if the surface temperature is within 3°C of the dew point.

## DRYING TIMES

**AIR DRY (25°C)**

| | |
|---|---|
| • TOUCH DRY: | 3 hours |
| • HARD DRY: | 16 hours |

**BAKE (65°C)** 40 minutes

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied. Full cure will be achieved after 7 days.

## RECOAT

Recoat within the potlife (6 hours) or after 16 hours. Recommendations are based on 25°C ambient temperature.

Maximum recoat time is indefinite.

Aged films must be free of chalk and dirt (abraded and degreased) before recoating.

## TOTAL DRY FILM BUILD

50 - 75 µm

## TECHNICAL PARAMETERS

**VOLUME SOLIDS (RFU)** 50 - 60%, depending on colour

**COVERAGE** 7.3 - 11.0 metres squared per litre ($m^2/L$)

**RESISTANCE PROPERTIES**

| | |
|---|---|
| **WEATHERING** | Excellent |
| **ABRASION** | Excellent |
| **SOLVENT** | Good to splash and spillage for common solvents |
| **CHEMICAL** | Good to splash and spillage for mild chemicals |
| **HEAT** | Satisfactory up to 120ºC Dry Heat |
| **IMMERSION** | Good. Satisfactory for intermittent immersion |

## EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## *HEALTH AND SAFETY*

**Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.**

Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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