

Sector: ACE

536/H781

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Technical Data Sheet

Mecalac Grey Two Pack Polyurethane Finish

High performance two pack polyurethane finish designed to meet the exacting requirements of the ACE market.

Colour: Mecalac Grey
Gloss: 40 ± 5GU at 60°
Hardener: 045/7009

COMPOSITION DETAILS

Binder: Acrylic
Pigment: Inorganic & Organic
Solvents: Esters
Density: 1,43 ±0.05kg/l Base
1,00 ±0.04kg/l Hardener
1,32 ±0.05kg/l Mixed

Weight Solids: 72 ±2% Base Component
50 ±2% Hardener
68 ±3% Mixed

Volume Solids: 56 ±2% Base Component
43 ±2% Hardener
53 ±3% Mixed

Supply Viscosity: 40-45" F4 @ 20°C
VOC Content: 422g/lit, blended

Mix Ratio: 3 unit(s) 536/H781 to 1 unit(s) 045/7009 by Volume
100,0 unit(s) 536/H781 to 23 unit(s) 045/7009 by Weight

Pot Life: <4 hours

RECOMMENDED APPLICATION DETAILS

Dry Film Thickness: 35 - 50 microns
Wet Film Thickness: 66 - 95 microns (calculated)

Theoretical Coverage: 11,7 m²/litre at 45 microns dry film (528 m²/litre at 1 micron dry). Assuming no loss.

Substrate: Mild Steel

Surface Preparation: Substrate should be primed with a Light Buff K5 Primer 490/H123 and allowed to flash off for 25 minutes before application of the topcoat. The substrate before coating should be dry and free from all surface contamination such as grease, oil, dirt, rust etc.

Application Method: Airmix
Application Viscosity: RFU

Application Method 2:	Airless	
Application Viscosity:	RFU	
Application Method 3:	Conventional Spray or HVLP	Comment: Thin with up to 5% thinners
Application Viscosity:	25-30" F4 @ 20°C	Thinner: 046/0309
Cleaning Solvent:	400/0090	

Application Notes: **The use of plural component mixing equipment is recommended**

CURING

Force Dry	- Flash Off:	15 minutes
	- Cure:	30 minutes @ 80°C

Information relating to application parameters and curing schedules will vary from plant to

Health & Safety Data:	Always follow any instructions on the containers and refer to the Product Safety Data Sheets before use. Safety data sheets are available from your local sales office.
Storage Conditions:	The product should be stored out of direct sunlight and between temperatures of 0 and 30°C
Shelf life:	12 months in unopened containers
Flash point:	32°C ASTM D 93.