

**Randolph Products Company**

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**URACHEM E65A4 PRIMER-SEALER**

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component polyurethane primer sealer for use on metal and plastic substrates. <i>Urachem E65A4 Primer-Sealer</i> can be applied over untreated ferrous and nonferrous metal substrates as well as plastics. <i>Urachem E65A4 Primer-Sealer</i> can be topcoated with all polyurethane topcoats.</p> <p><b>Typical Uses:</b> <i>Urachem E65A4 Primer-Sealer</i> can be used for hiding substrate defects in electronic enclosures, metal chassis or weldments. It can also be used on a variety of plastics used in the business machine and medical equipment industries prior to topcoating. Due to the diverse nature of plastic substrates, always test the coating system to be used for adhesion prior to commencing production. Re grind or recycled plastics, plus various fire retardants, flow agents, blowing agents and mold releases will affect adhesion.</p> <p>Randolph Products Co. warrants that its products meet its internal specifications and are of merchantable quality. However, the purchaser is solely responsible for the suitability of the product for any particular application. The purchaser should thoroughly test or qualify the product for serviceability, environmental compliance and health and safety factors prior to use. Further, our total liability is limited to the price of the product or replacement in kind.</p> <p>Randolph Products Company 33 Haynes Circle Chicopee, MA 01020 Phone: 413-592-4191 Fax: 413-594-7321 www.randolphproducts.com</p>	<ol style="list-style-type: none"> <li>1. <b>Colors Available:</b> X3649 – Gray X5085 – White X-7543 – Red Oxide</li> <li>2.. <b>Volume Solids:</b> 36 +/- 2%</li> <li>3. <b>Pencil Hardness:</b> HB</li> <li>4. <b>Cross Hatch Adhesion:</b> 5B</li> <li>5. <b>Theoretical Coverage @ 1 mil dft:</b> 577 ft<sup>2</sup>/gallon (as supplied)</li> <li>6. <b>Recommended DFT:</b> 0.7 – 1.2 mils</li> <li>7. <b>VOC:</b> 4.65 lbs/gallon (557 grams/liter) (as supplied)</li> <li>8. <b>Dry Times:</b> Room Temperature: Set to Touch: 15 – 20 minutes Dry to Handle: 40 – 60 minutes Dry to Sand: 2 hours maximum Dry to Topcoat: 30 – 60 minutes No maximum recoat time.</li> </ol> <p>Force Dry @ 150°F Dry to Sand or Topcoat: 15 – 30 minutes</p>	<p>Use conventional air pressurized spray equipment or HVLP.</p> <p><b>Surface Preparation:</b> Apply to a clean, dry substrate.</p> <p><b>Mixing:</b> <i>Urachem E65A4 Primer-Sealer</i> is a two component polyurethane. <i>Urachem R500</i> is the recommended hardener for interior use only.</p> <p><b>Mix Ratio:</b> <b>13 parts</b> Urachem E65A4 Primer-Sealer Part A; <b>1 part</b> Urachem R500 hardener; <b>3.5 parts</b> W283 Reducer</p> <p><b>Clean Up:</b> Use #928 Washing Thinner.</p> <p><b>Safety Precautions:</b> This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.</p>