



## 6.7 URACHEM

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>6.7 Urachem is a two component polyurethane coating engineered for the electronic enclosure industry while meeting state and federal VOC regulations.</p> <p>6.7 Urachem can be applied smooth or textured to a variety of substrates such as pretreated steel ,aluminum and wood as well as the many plastics used in the business machine telecommunications and medical industries.</p> <p>Eastern Chem Lac 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>Eastern Chem Lac  33 Haynes Circle  Chicopee, MA 01020  Phone: 413-592-4191  Fax: 413-594-7321  www.randolphproducts.com</p>	<p>Physical and chemical tests were performed on iron phosphate treated steel panels. All panels were cured for 72 hours at 140°F and then air dried for 14 days. Adhesion tests were performed on the appropriate substrates.</p> <ol style="list-style-type: none"> <li><b>1. Volume Solids:</b> 60 – 65% (as packaged) 52 – 54% (as applied)</li> <li><b>2. Pencil Hardness:</b> 2H – 3H</li> <li><b>3. Cross Hatch Adhesion:</b> 5B</li> <li><b>4. Taber Abrasion (1000 grams; 1000 cycles; CS17 wheel):</b> &lt; 70 mg loss</li> <li><b>5. Flexibility:</b> Pass 1/8” Mandrel</li> <li><b>6. Theoretical Coverage @ 1 mil dft:</b> 834 - 866 ft<sup>2</sup>/gallon (as applied)</li> <li><b>7. Direct Impact:</b> 100 inch lbs.</li> <li><b>8. Reverse Impact:</b> 100 inch lbs</li> <li><b>9. Humidity Exposure:</b> 300 hours with no blistering</li> <li><b>10. Pot Life:</b> 3 -4 hours</li> <li><b>11. Salt Spray Exposure:</b> 250 hours no blistering</li> <li><b>12. Solvent Resistance:</b> 50 double rubs – “No effect” is defined as no permanent softening of film and/or permanent change</li> </ol>	<p>Use conventional air pressurized spray equipment or HVLP.</p> <p><b>Surface Preparation:</b>  6.7 <i>Urachem</i> can be applied directly to chemically treated steel. Use W6583 WB Wash Primer should be used on Yellow/Clear Zinc Plate or any chromated aluminum if aged longer than 24 hours. Wash Primer 2035-534 or R1953 Tu-Com Chromate Primer must be applied if no chemical pretreatment is available. Structural plastics such as ABS (CYCOLAC™), Polycarbonate (LEXAN™) and PPO (NORYL™) that have been injected, foamed, or thermoformed should be clean and free from mold release. Wash with isopropyl alcohol or other mild wash solution.</p> <p><b>Mixing:</b>  6.7 <i>Urachem</i> is a two component polyurethane. <i>Urachem W5005</i> is the recommended hardener.</p> <p><b>Mix Ratio:</b>  <b>4 parts</b> 6.7 <i>Urachem</i> Part A; <b>1 part</b> 6.7 <i>Urachem W5005</i> hardener; <b>1 part</b> W7161 Reducer</p> <p><b>Base Coat:</b> Apply smooth wet coat approximately 3.0 – 4.0 mils wet. Allow 15 – 20 minutes flash off prior to texture coat or force drying.</p> <p><b>Texture Coat:</b> Use same admixed paint for texture. Adjust pressures accordingly to match texture pattern. Allow 15 – 20 minutes flash off before force drying.</p> <p><b>Pressure:</b>  <b>Base Coat:</b>  Fluid pressure 8 – 15 psi  Atomizing pressure 45 -55 psi</p> <p><b>Texture Coat:</b></p>



in appearance.

**Isopropyl Alcohol:** No effect  
**Lacquer Thinner (T4-1):** No effect  
**MEK:** No effect  
Tested per ASTM D5402

**13. Chemical Resistance:** 30 minutes uncovered exposure spot test.

**409 Cleaner:** No effect  
**Fantastic:** No effect  
**Household Ammonia:** No effect  
**10% NaOH:** No effect  
**10% HCl:** Slight staining  
**10% Bleach:** No effect  
**25% Bleach:** No effect  
**5% Acetic Acid:** Slight staining  
**Ketchup:** Slight staining  
**Mustard:** Slight staining  
**Coffee:** No effect  
**Windex:** No effect  
**Hospital Antiseptic Cleaners:** No effect

**14. VOC (as supplied);** 2.6 – 2.7 lbs/gallon

**15. VOC (as applied):** 3.1 – 3.5 lbs/gallon

**16. Shelf Life:** One Year

Fluid pressure 8 – 15 psi  
Atomizing pressure 10 – 20 psi

Pressures will vary according to spray equipment and part configuration.

**Drying Times:**

Flash off prior to texture coat or force dry for 15 – 20 minutes.  
Dry to handle: 20 minutes at 150°F. or 12 hours at room temperature (70°F)  
Dry to package or secondary operation: 30 - 40 minutes at 150°F or 24 hours at room temperature (70°F) – always allow parts to cool prior to secondary processing.  
**Do not pack in plastic bags.**

**Clean Up:** Use #928 Washing Thinner.

**Safety Precautions:**

This product is intended for professional use in an industrial environment only. Consult the Safety Data Sheet prior to application.