

Randolph Products Company

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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>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>	<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">1. Volume Solids: 60 – 65% (as packaged) 52 – 54% (as applied)2. Pencil Hardness: 2H – 3H3. Cross Hatch Adhesion: 5B4. Taber Abrasion (1000 grams; 1000 cycles; CS17 wheel): < 70 mg loss5. Flexibility: Pass 1/8" Mandrel6. Theoretical Coverage @ 1 mil dft: 834 - 866 ft²/gallon (as applied)7. Direct Impact: 100 inch lbs.8. Reverse Impact: 100 inch lbs9. Humidity Exposure: 300 hours with no blistering10. Pot Life: 3 -4 hours11. Salt Spray Exposure: 250 hours no blistering12. Solvent Resistance: 50 double rubs – "No effect" is defined as no permanent softening of film and/or permanent change in appearance.	<p>Use conventional air pressurized spray equipment or HVLP.</p> <p>Surface Preparation: 6.7 Urachem 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>Mixing: 6.7 Urachem is a two component polyurethane. Urachem W5005 is the recommended hardener.</p> <p>Mix Ratio: 4 parts 6.7 Urachem Part A; 1 part 6.7 Urachem W5005 hardener; 1 part W7161 Reducer</p> <p>Base Coat: 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>Texture Coat: Use same admixed paint for texture. Adjust pressures accordingly to match texture pattern. Allow 15 – 20 minutes flash off before force drying.</p> <p>Pressure: Base Coat: Fluid pressure 8 – 15 psi Atomizing pressure 45 -55 psi</p> <p>Texture Coat: Fluid pressure 8 – 15 psi</p>

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	<p>Isopropyl Alcohol: No effect Lacquer Thinner (T4-1): No effect MEK: No effect</p> <p>13. Chemical Resistance: 30 minutes uncovered exposure spot test.</p> <p>409 Cleaner: No effect Fantastic: No effect Household Ammonia: No effect 10% NaOH: No effect 10% HCl: Slight staining 5% Acetic Acid: Slight staining Ketchup: Slight staining Mustard: Slight staining Coffee: No effect Windex: No effect Hospital Antiseptic Cleaners: No effect</p> <p>14. VOC (as supplied): 2.6 – 2.7 lbs/gallon</p> <p>15. VOC (as applied): 3.1 – 3.5 lbs/gallon</p> <p>16. Shelf Life: One Year</p>	<p>Atomizing pressure 10 – 20 psi</p> <p>Pressures will vary according to spray equipment and part configuration.</p> <p>Drying Times:</p> <p>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.</p> <p>Clean Up: Use #928 Washing Thinner.</p> <p>Safety Precautions: This product is intended for professional use in an industrial environment only. Consult the Material Safety Data Sheet prior to application.</p>
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