

EXTERIOR URACHEM

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component polyurethane enamel suitable for use on a variety of substrates that require superior appearance and durability. <i>Exterior Urachem</i> has excellent solvent resistance and chemical resistance. <i>Exterior Urachem</i> is recommended for both metal and plastic substrates used in the electronic enclosure and medical and office equipment manufacturing industries. <i>Exterior Urachem</i> is designed to dry and cure at ambient temperature so it is an excellent choice for pre-assembled parts that are too large for baking ovens or for parts that cannot tolerate the heat. <i>Exterior Urachem</i> will cure at ambient temperature or by force drying 20 – 30 minutes at 125° - 180°F.</p> <p><i>Exterior Urachem</i> can be textured or applied as a smooth coat.</p> <p><i>Exterior Urachem</i> is custom color matched and formulated to meet each customer's specifications.</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: 30 – 35% (varies by color) 2. Pencil Hardness: 2H 3. Cross Hatch Adhesion: 5B 4. Taber Abrasion (1000 grams; 1000 cycles; CS10 wheel): < 100 mg loss 5. Flexibility: Pass 1/8" Mandrel 6. Theoretical Coverage @ 1 mil dft: 481 - 561 ft²/gallon (varies by color) 7. Direct Impact: 100 inch lbs. 8. Reverse Impact: 80 inch lbs 9. Humidity Exposure: 500 hours with no blistering 10. Pot Life: 4 hours 11. Salt Spray Exposure: 500 hours no blistering 12. 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: <i>Exterior 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>Mixing: <i>Exterior Urachem</i> is a two component polyurethane.</p> <p>Mix Ratio: 4 parts Exterior Urachem Part A; 1 part Urachem R1100 hardener; 2 parts W283 Reducer</p> <p>Base Coat: Apply smooth wet coat approximately 3.0 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:</p> <p>Base Coat: Fluid pressure 8 – 15 psi Atomizing pressure 45 -55 psi</p> <p>Texture Coat: Fluid pressure 8 – 15 psi</p>

Randolph Products Company

33 Haynes Circle

Chicopee, MA 01020

Telephone 413-592-4191

Facsimile: 413-594-7321



	<p>Isopropyl Alcohol: No effect Lacquer Thinner (T4-1): No effect MEK: No effect Skydrol: 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); 5.5 lbs/gallon</p> <p>15. 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: Overnight or 20 minutes at 150°F. Dry to package or secondary operation: Overnight or 40 minutes at 150°F – always allow parts to cool prior to secondary processing.</p> <p>Do not pack in plastic bags.</p> <p>Clean Up: Use lacquer thinner or #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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