

URACHEM ULTRA

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>A two component high solids polyurethane topcoat with a maximum VOC 2.8 lbs/gallon.</p> <p>This polyurethane coating provides a highly durable, flexible finish with excellent exterior durability, chemical and abrasion resistance.</p> <p><i>Urachem Ultra</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>	<ol style="list-style-type: none"> 1. Volume Solids: 50 - 57% (varies by color) 2. Solids by Weight: 60 - 70% (varies by color) 3. Viscosity: 30 seconds max. #4 Ford Cup 4. DFT: 1.7 – 2.3 mils 5. Theoretical Coverage @ 1 mil dft: 802 - 914 ft²/gallon (varies by color) 6. Dry Times Flash Off – 45 – 60 minutes Dry to Handle – 60 minutes @ 150°F Dry to package or perform secondary operations: 120 minutes @ 150°F Air Dry: Allow 24 to 36 hours air dry at room temperature. Full cure will take 7 – 10 days depending on environmental conditions. 7. VOC <2.8 lbs/gallon (340 grams/liter) 8. Shelf Life One year from date of manufacture 	<p>Use conventional air pressurized spray equipment or HVLP.</p> <p>Surface Preparation: <i>Urachem Ultra</i> can be applied directly to chemically treated steel. Use W6583 WB Wash Primer 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>Urachem Ultra</i> is a two component polyurethane. <i>Urachem Ultra Hardener</i> 991FL for semigloss and flat products and 991GL for high gloss products..</p> <p>Mix Ratio: 2 parts Urachem Ultra Part A; 1 part Urachem Ultra Hardener (Note: Thinner should not be needed, but if a slight reduction is necessary use W7161.</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>

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Texture Coat:

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 Material Safety Data Sheet prior to application.