

6.7 EXTERIOR URACHEM

GENERAL INFORMATION	PHYSICAL PROPERTIES	APPLICATION
<p>6.7 Exterior Urachem is a high solids, polyurethane that when combined with R1100 Exterior Catalyst forms a high performance aliphatic cross linked enamel film. This film is designed for use where UV stability is needed.</p> <p>Available in a wide range of colors and gloss ranges from 5 to 60. It is recommended that 6.7 Exterior Urachem can be force dried with heat to accelerate cure times. Please consult with your local technical representative for details.</p> <p>A multistage cleaning pre-treatment system is highly recommended which will remove organic and inorganic surface soils, eliminate residual oxides. Application of a chemical conversion coating will also enhance adhesion.</p> <p>The pretreatment when used in conjunction with a fully cured topcoat, shall produce a total system capable of meeting impact, adhesion, detergent resistance, humidity and salt spray performance as defined under AAMA Specification 2603-98.</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 yellow chromate aluminum 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 – 3H 3. Cross Hatch Adhesion: 5B 4. Taber Abrasion (1000 grams; 1000 cycles; CS17 wheel): < 100 mg loss 5. Flexibility: Pass 1/8" Mandrel 6. Theoretical Coverage @ 1 mil dft: 834 - 866 ft²/gallon (as applied) 7. Direct Impact: 100 inch lbs. 8. Reverse Impact: 100 inch lbs 9. Humidity Exposure: 300 hours with no blistering 10. Salt Spray Exposure: 500 hours no blistering or corrosion 12. Solvent Resistance: 50 double rubs – “No effect” is defined as no permanent softening of film and/or permanent change in appearance. <p>Isopropyl Alcohol: No effect</p>	<p>Use conventional air pressurized spray equipment or HVLP.</p> <p>Mixing: 6.7 Exterior Urachem is a two component polyurethane. R1100 Exterior Catalyst is the recommended hardener.</p> <p>Mix Ratio: 4 parts 6.7 Exterior Urachem Part A; 1 part R1100 Exterior Catalyst; 1 part Solvent Blend #84 (W7161)</p> <p>Base Coat: Apply smooth wet coat approximately 3.0 – 4.0 mils wet. Allow 45 - 60 minutes flash off prior to force drying.</p> <p>Drying Times:</p> <p>Flash off: 45 – 60 minutes Dry to handle: 60 minutes at 150°F. Dry to package or secondary operation: 120 minutes at 150°F Air Dry: allow 24 to 36 hours air dry at room temperature (70°F). Note: Full cure will take 10 – 21 days depending on environmental conditions.</p> <p>ALWAYS ALLOW PARTS TO COOL.</p> <p>NEVER WRAP PARTS IN PLASTIC OR USE PLASTIC BAGS.</p> <p>DO NOT INSTALL UNLESS COATING IS COMPLETELY CURED.</p> <p>Clean Up: Use #928 Washing Thinner or Urachem Reducers to clean equipment. ALWAYS CLEAN EQUIPMENT THE SAME DAY.</p> <p>Safety Precautions: This product is intended for professional use in an industrial environment only.</p>

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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

5% Acetic Acid: Slight staining

Ketchup: Slight staining

Mustard: Slight staining

Coffee: No effect

Windex: No effect

14. Humidity resistance (100%): 500 hours exposure: no blisters, no corrosion.

15. Water immersion

7 days @ 130°F, no effect

16. VOC (as supplied): 2.6 – 2.7 lbs/gallon

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

18. Shelf Life: One Year

Consult the Material Safety Data Sheet prior to application.