

646JB: Base 646J9: Curing Agent 941JB

Description: ACRYLITHANE™ DTM POLYURETHANE is a two component, direct to metal polyurethane topcoat formulated for spray applications in areas requiring VOC less than 3.5 lbs./US gallon. It offers a high quality appearance with exceptional color and gloss retention.

Recommended use: For use on construction equipment, transportation equipment, truck frames, trailers, bulk tanks, chemical trailer applications that require a topcoat as a monocoat application.

Features: Excellent gloss and color retention
Good Corrosion resistance
Resistant to chemical spills & splashes
Does not require a primer

Service temperatures: Maximum, dry service exposure only: 120°C/248°F

Availability: Not included in Group Assortment. Availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade no./Color: 1L000 (formerly J-B 4400-006) White*
Finish: Full Gloss
Volume solids, %: 57 ± 1
Theoretical spreading rate: 7.5 m²/litre - 76 microns
305 [sq. ft US gallon] – 3.0 mils DFT
Flash point: 86°F/30°C
Specific Gravity: 1.3 kg/litre - 10.9 lbs/US gallon
Dry to touch: 1 hour at 20°C/68°F
Dry to handle: overnight
VOC content: 370 g/litre [<3.1 lbs/US gallon]
**wide range of colors available via Acrylithane™ HS Tint System*

The physical constants stated are nominal data according to the Hempel Group's approved formulas.

APPLICATION DETAILS:

Version, mixed product **646JB**
Mixing ratio: BASE 646J9 (formerly J-B 45010) : CURING AGENT 941JB (formerly J-B 99955)
5:1 by volume
Application method: Airless spray Air spray Brush & Roll
Thinner (max.vol.): 08NJB DMC (JB 21142)- 5% for VOC restrictions 5-15% 2-4oz. 08DJB (formerly JB 21099)
Pot life: 4 hours at 20°C/68°F
Nozzle orifice: 0.011"-0.013" airless / 0.110" or 2.8 MM fluid cap conventional
Nozzle pressure: 138 bar [2,000 psi]
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: MEDIUM REDUCER 0832
Indicated film thickness, dry: 76 – 102 microns / 3.0 – 4.0 mils (see REMARKS overleaf)
Indicated film thickness, wet: 133 - 178 microns / 5.26 – 7.0 mils
Overcoat interval, min: overnight (20°C/68°F)
Overcoat interval, max: (See REMARKS overleaf)

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult Safety Data Sheets and follow all local or national safety regulations.

SURFACE PREPARATION: The surface must be completely clean and dry at the time of application, and its temperature above the dew point to avoid condensation. Minimum temperature for curing is 7°C/44°F. Abrasive blasting to minimum Sa 2½ (ISO 8501-1:2007) or SSPC-SP 10 w/ a surface profile corresponding to Keane-Tator Comparator, 3.0 G/S or ISO Comparator, Medium (G) **Repair and maintenance:** Remove oil and grease with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to SSPC-SP 11 (or St 3, ISO 8501-1) or by abrasive blasting to min. SSPC-SP 6 (or Sa 2, ISO 8501-1) preferably to SSPC-SP 10. Improved surface preparation will improve the performance of the paint. Feather edges to sound and intact areas. Dust off residues. Touch up to full film thickness.

APPLICATION CONDITIONS: Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 7°C / 44°F. The temperature of the paint itself should be: 15-25°C/59-77°F. In confined spaces provide adequate ventilation during application and drying. Thinning may be necessary in the case of very long spray hoses and/or paint temperatures below 15°C/59°F. This will cause lower film build and longer drying time. Alternate reducers such as Acetone or Dimethyl Carbonate (DMC) may be used to reduce product without adding VOC's.

REMARKS:

Mixing: Mix thoroughly before use. Add 2 quarts of catalyst to a 1 each 1.25 gallon unit of ACRYLITHANE™ DTM (5:1 ratio) and mix thoroughly again. Only apply when air and surface temperature are between 7°C-38°C/44°F-100°F.

Thinning: For VOC restrictive use, add Dimethyl Carbonate (DMC) or Acetone as needed for viscosity adjustment. If VOC mixed total is not a concern, Add 08EJB (*formerly J-B 21102 Fast Spray Reducer*) as required. When temperature is over 70°F, use 08320 (*formerly J-B 21092 Medium Reducer*). Add 08BJB (*formerly J-B 21093 Slow Reducer*) to reduce dry spray and orange peel, if required. 085JB (*formerly J-B 21078 Special Urethane Retarder*) can be added to help add a wet edge for spraying large parts.

Drying: Under normal conditions, and due to high film build applications, it dries to touch in 10 hours and dries for overcoat overnight. Low temperature, high humidity, poor ventilation and thick films will retard drying. Addition of 99056 accelerator (*formerly J-B 99011*) at the rate of 1.0 fl. /oz. per mixed gallon will shorten dry times.

Pot Life: Pot life is approximately 4 hours after mixing. Mix only the amount of material that can be used in 4 hours. Pot life is decreased with an increase in temperature. Mixed material should be kept in as cool a location as possible.

Cleaning: Flush mixed material from pressure pot and lines immediately after use. Clean paint tools or spills immediately with 08320 (*21092 Medium Reducer*), MEK, or lacquer thinner carefully observing cautions on paint and thinner labels. Dried paint may need to be removed by scraping.

Overcoating: Sanding or roughening of surface is recommended if overcoating after 2 weeks.

Note: **ACRYLITHANE™ DTM is for professional use only.**

Issued by: Hempel (USA), Inc.
646JB1L000

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on hempel.com. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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