

PLASCOTHANE 421 INDUSTRIAL POLYURETHANE

PRODUCT CODE: FPW & FPB 4000 Tint Base

TECHNICAL DATA SHEET

Product Description	High quality dual pack polyurethane enamels for interior and exterior use.													
Intended Uses	PLASCOTHANE 421 INDUSTRIAL POLYURETHANE has been developed for use on truck trailers, agricultural equipment, machinery and other general industrial applications requiring a high gloss finish with good durability.													
Features & Benefits	<ul style="list-style-type: none"> • Smooth, tough, gloss finish that is easily cleaned. • Good durability and chemical resistance (excluding strong acids and alkalis) • Long pot life • Tintable on the "Alchemy" tinting system. 													
Product Information	Colours Generic type Solvent type Solids (mixed) Recommended DFT Theoretical spreading rate Viscosity at 23 °C (mixed) Pot life (mixed) Flash Point VOC	The full range of Alchemy colours available, utilising Tint base (FPB 4000) Polyurethane A blend of hydrocarbons and ester solvents Approx. 35-45 % by mass; 30-35 % by volume (depending on colour) 30 µm to 50 µm 8,12m ² /L @ 40 µm DFT 30 – 35 sec Ford Cup No. 4 8 h at 23 °C 23 °C < 510 g/ L												
Application Details	Mixing Method Thinner Cleaning Application Environment	Stir base with a flat paddle until homogeneous. Mix in ratio supplied, viz. 4 parts BASE to 1 part CATALYST KAT 421 by volume. Note: This catalyst was specifically formulated for this product and is not to be used with the UP or FPA Range. Conventional spraying and Brush. For conventional spray application thin to a viscosity of 20 – 22 sec Ford cup 4 @ 23 °C with UNIVERSAL REDUCER (PUR 1) UNIVERSAL REDUCER (PUR 1) or NO. 40 LACQUER THINNER (ILS 1) . <table border="1"> <thead> <tr> <th>Surface Temperature</th><th>Ambient Temperature</th><th>Relative Humidity</th></tr> </thead> <tbody> <tr> <td>Min: 10 °C</td><td>Min: 10 °C</td><td>Min: 10%</td></tr> <tr> <td colspan="2">or 3 °C min. above dew point</td><td></td></tr> <tr> <td>Ma.: 40 °C</td><td>Max: 40 °C</td><td>Max: 85 %</td></tr> </tbody> </table>	Surface Temperature	Ambient Temperature	Relative Humidity	Min: 10 °C	Min: 10 °C	Min: 10%	or 3 °C min. above dew point			Ma.: 40 °C	Max: 40 °C	Max: 85 %
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Ma.: 40 °C	Max: 40 °C	Max: 85 %												
	Drying time	Touch dry Overcoating time Dry to handle Full cure												
		Approx. 1 h @ 23 °C Min: 1 h @ 23 °C Max: 48 h @ 23 °C 6 h @ 23 °C 7 days @ 23 °C												

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Storage & Packaging	<p>Store away from direct sun, heat and severe cold.</p> <p>Caution: Hardener Kat 421 hardens when exposed to atmospheric moisture – Keep tightly closed.</p> <p>Packaging: Base (for the FPB 4000 – when tinted) Catalyst (Kat 421) 1 L</p>
Surface Preparation	<p>All surfaces must be clean, sound and dry.</p> <p>MILD STEEL (New Work):</p> <ul style="list-style-type: none"> Degrease with PLASCON AQUASOLV DEGREASER (GR 1) and rinse thoroughly with fresh water. To remove rust, mill scale and other contaminants abrasive blast clean to Grade Sa 2 ½ of ISO 8501-1:2007 to a blast profile of 30 – 50 µm. Prime with EPIWASH STRONTIUM CHROMATE PRIMER (AW 255, AW 1255, AW 1256)) <p>PREVIOUSLY PAINTED SURFACES (Fully cured and in good condition):</p> <ul style="list-style-type: none"> Degrease with PLASCON AQUASOLV DEGREASER (GR 1) and rinse thoroughly with fresh water. Sand paint to a matt finish to provide a key.
Application	<ul style="list-style-type: none"> Thin to recommended spraying viscosity
Cautions	<ul style="list-style-type: none"> Do not apply PLASCOTHANE 421 directly over alkyd enamels or alkyd primers Application in high humidity environments (75 % RH) may cause surface bloom.
Safety Precautions	<ul style="list-style-type: none"> Always keep paint out of reach of children. Ensure good ventilation during application and drying. If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner. Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention. Harmful if swallowed. Seek medical attention and do not induce vomiting. Do not smoke while painting. Flammable. Store in a cool dry place away from heat and sparks. Catalyst contains isocyanate – use suitable respirator, particularly during spray application of the mixed material. Refer to Safety Data Sheet for complete information.

DISCLAIMER:

The recommendations contained herein are given in good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

N.B. Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

N.B. TO ORDER: Quote product name, product code number, packaging and colour.

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