

# Colourthane

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Resource Code: 162-line  
July 2003

## DESCRIPTION

- two-part recoatable aliphatic isocyanate-cured, acrylic polyurethane finish

## PRINCIPAL CHARACTERISTICS

- unlimited recoatability
- excellent resistance to atmospheric exposure
- excellent colour and gloss retention
- tough, flexible and abrasion resistant
- resistant to splash of mineral and vegetable oils, white spirit, paraffins and aliphatic petroleum products
- resistant to splash of mild chemicals
- can be air dried or force dried up to 60°C on metal to improve throughput
- conforms to AS3750.6

## COLOURS AND GLOSS

- solid colours and metallic (refer to Colourthane Colourcard). Also refer AS2700, BS381C and RAL colours – full gloss
- other colours available on request

## BASIC DATA AT 25°C and 50% RELATIVE HUMIDITY

- solids content ..... 33 - 38% by volume when mixed depending on colour
- typical film thickness (per coat) ..... 25 microns (dry), 70 microns (wet)
- theoretical spreading rate ..... 14 - 15m<sup>2</sup>/l for 25 microns (dry)
- touch dry after ..... **standard hardener** - dust free 30 min, touch dry 5 hours  
**fast hardener** – dust free 15 min, touch dry 3 hours
- recoating times ..... for wet on wet allow for a flash-off time of 5 – 10 minutes between coats, can be recoated within 8 hours without sanding, if recoating after 8 hours then sand with P320 – P400 between coats. If higher gloss is required, a coat of Colourthane clear may be applied as soon as the colour is dust free, if applied after coating is hard dry, then sand with P400-P600 before clearcoat
- full cure after ..... 7 days at 25°C
- shelf life (cool and dry place) ..... at least 12 months
- pot life at 25°C ..... 4 hours (max) using std hardener, 2 hours (max) using fast hardener  
do not use after this time even if the mix is still liquid
- application viscosity ..... 18 - 22 seconds B4 Cup

## RECOMMENDED SUBSTRATES

- current existing finishes, provided they are previously degreased and sanded
- surface preparation
  - wet sand with P800 - P1000 grade paper
  - dry sand with P320 - P400 grade paper
- laminates (eg. Laminex, formica) after sanding with P320 – P400
- Colourthane Epoxy Primer or Primer Filler
- for other surfaces such as hot dipped galvanising, zincalume, aluminium, fibreglass, plastics or stainless steel consult protective or metal coatings manuals or contact WattyL for Technical advice

## INSTRUCTIONS FOR USE

- mixing ratio by volume 2A:1B
- stir the components and mixed product well using a mechanical mixer
- this product must be thinned with Colourthane Reducers
- thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure and should only be added after mixing components

- for best results it is recommended to use slow reducer above 25°C and standard reducer below 20°C, blends of the two reducers can be used for intermediate temperatures
- relative humidity should not exceed 75% during application and before the dry to handle time
- freshly catalysed material should not be added to product that has been mixed for some time
- for recommendations outside those contained in this data sheet, refer to Watty!
- **AIRLESS SPRAY**
  - recommended thinner..... Colourthane Reducer
  - volume of thinner .....5% max
  - nozzle orifice.....approximately 0.28mm (+0.011 inch)
  - nozzle pressure ..... 160 – 200 bar
- **AIR SPRAY**
  - recommended thinner..... Colourthane Reducer
  - volume of thinner ..... 10% max
  - nozzle orifice..... 1.2 – 1.5 mm
  - nozzle pressure .....3 – 5 bar
- **CLEANING SOLVENT** ..... Colourthane Reducer

## ADDITIONAL DATA

### Curing table – using Standard Hardener

Substrate temperatures	15°C	25°C	60°C
Dust free	50 mins	30 mins	5 mins
Tack free	8 hours	5 hours	15 mins
Dry to handle	16 hours	12 hours	40 mins
Hard dry	24 hours	20 hours	50 mins
Ready to Sand	20 hours	16 hours	45 mins

### Curing table – using Fast Hardener

Substrate temperatures	15°C	25°C	60°C
Dust free	25 mins	15 mins	5 mins
Tack free	5 hours	3 hours	10 mins
Dry to handle	8 hours	6 hours	20 mins
Hard dry	16 hours	10 hours	25 mins
Ready to Sand	12 hours	8 hours	20 mins

### Pot life (10% thinner)

Paint temperature	Pot life (max)	
	Standard Hardener	Fast Hardener
15°C	6 hours	3 hours
25°C	4 hours	2 hours
35°C	2 hours	1 hour

- adequate ventilation must be continuously maintained during application and curing

**SAFETY PRECAUTIONS**

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this paint contains 0.37% monomeric diisocyanate. Provide adequate ventilation during use. Breathing the vapour is dangerous. Avoid prolonged breathing of fumes. Where ventilation is poor or where applied by spray, use suitable respiratory equipment at all times
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and should not be used without reference to the Material Safety Data Sheet (MSDS)

**PACKAGING GROUP III****UN NO. 1263****PACKAGING 4 litres, 20 litres (Part A), 1 litre (Part B)**

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**1. This information is provided with respect to the listed Wattyl products. Wattyl recommends that:**

(a) you review the Technical Data Sheets (TDS) and Material Safety Data Sheets (MSDS) before you use or handle the product; (b) the product be used only in accordance with the information provided by Wattyl; (c) the product be transported, stored and handled in accordance with the information on the MSDS and relevant TDS; and (d) you thoroughly test the product, using the recommended application method on a sample of intended substrate, before using the product.

2. The information in this technical data sheet was prepared using information gathered during product development. While Wattyl endeavours to update this information and maintain the accuracy and currency of its contents, Wattyl cannot guarantee that the information provided is wholly comprehensive.

3. Wattyl recommends that you conduct such additional investigations as may be necessary to satisfy yourself of the accuracy, currency and comprehensiveness of the information on which you rely in using and handling the product. If you require further information please contact your nearest Wattyl Office.

4. To the full extent permitted by law, Wattyl's liability for breach of a condition or warranty implied into the contract for sale between Wattyl and you by law is limited at Wattyl's election to: (a) the replacement of the product; or (b) payment of the cost of replacing the product.