

ORART619

OROPAL 2K DIRECT TO METAL PRIMER FINISH GLOSS TOPCOAT

Catalyzed at 4:1 ratio by volume with **ORART781HARD**

High solids flexible aliphatic polyurethane coating. This semiglossy 2K product is recommended as a topcoat for aggressive atmospheric environments such as industrial structures, refineries, bridges... It has good colour and gloss retention as well as an excellent impact resistance. Available in a wide range of colours.

Physical parameters	Base ORART472	Catalyst ORART181HARD
Viscosity	320 – 400" (DIN cup #6)	150 – 300 cPoise (Brookfield sp6 10rpm)
Specific gravity	1,20 – 1,50 g/cc	1,05 – 1,10 g/cc
Solids content	70 – 75%	74 – 77%
In-can appearance	Viscous liquid	Viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	4:1 by volume (ORART619:ORART781HARD)
Viscosity of the mixture	-"
Specific gravity of the mixture	1,16 – 1,46 g/cc
Solids content	70 – 75%
Colour	Wide range of colours
Dry film appearance	Semigloss finish with excellent impact resistance
Spreading rate	5 – 13 m ² / L (95 – 240 g/m ²)
Gloss	75 – 85%
Adhesion	100% (Max: GT0)
Persoz hardness	>120 s
Cupping test	11 mm
Pot life of mixture	1 hour
VOC	<500 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L

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Product use information

Surface	Iron, Steel, Aluminium, Galvanized steel
Surface preparation	Steel should be clean, dry, without grease or rust. Aluminium surface should be blasted, clean and dry. Concrete must be clean, dry and unpolished.
Product preparation	Stir thoroughly the contents of the container with a spatula and check colour before application <u>Mixing ratio (by volume)</u> ORART619 (Base): 4 parts ORART781HARD (Catalyst): 1 part Do not let moisture into the ORART781HARD
Application method	Brush, Air spray gun
Dilution	Use ORART727 as a thinner, if necessary. Homogenize the mixture. Do not use other solvents
Application	Apply 50 – 125 µm of dry film thickness
Drying	Touch drying time: 3 – 4 hours Drying time is very influenced by the dry film weight, type and state of the substrate and weather conditions.
Recoat able	12 hours
Cleaning	ORART727

Application process	Primer (Optional)	Top coat
Iron, steel	ORART480	ORART619
Aluminium, Galvanized steel	OROPRIMER 446	ORART619
Concrete	OROLUR 388	ORART619

Additional information

Safety	Consult package labelling. For further information, ask for the Material Safety Data Sheet
Storage	1 year

This technical data sheet aims to inform our customers about the properties of our product. Although the data contained here is based on our knowledge and technical reports carried out according to the mentioned standards, the suitability for purpose of use should be confirmed under customer practical conditions.



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