

# ORART604

## OROPAL 2K POLYURETHANE GLOSS TOPCOAT

Catalyzed at 5:1 ratio by volume with **ORART704HARD**

A fast drying 2 pack aliphatic polyurethane enamel with a glossy finish and high weather resistance and high protection against UV. The film is hard, waterproof and oil and petroleum resistant. Specially formulated as a topcoat for many metallic, plastic or concrete substrates which have been suitably primed.

Physical parameters	Base ORART447	Catalyst ORART188HARD
Viscosity (Ford cup #4)	150 – 200"	11 – 15"
Specific gravity	1,08 – 1,30 g/cc	0,96 – 1,00 g/cc
Solids content	55 – 65%	42 – 45%
In-can appearance	Viscous liquid	Viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	5:1 by volume (ORART604:ORART704HARD)
Viscosity of the mixture	-"
Specific gravity of the mixture	1,06 – 1,28 g/cc
Solids content	53 – 63%
Colour	Wide range of colours and Clear Binder
Dry film appearance	Gloss finish with good leveling and resistance
Spreading rate	8 – 13 m <sup>2</sup> / L (80 – 130 g/m <sup>2</sup> )
Gloss	>85%
Adhesion	100% (Max: GT0)
Pot life of mixture	3 – 4 hours
VOC	<500 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L

Product	Product code	Brand	Author	Date	Version	Replaces	Page	Language
ORART604	ORART604XXX/Y	OROPAL	IKI COATINGS – IRURENA GROUP	12.12.19	1	Any previous version	1/2	EN

## Product use information

Surface	Any kind of metallic surface suitably primed, Concrete, Polyester
Surface preparation	Metal should be thoroughly deoxidized and degreased before being suitably primed. Concrete should be clean, dry and unpolished. Polyester should be sanded and thoroughly degreased.
Product preparation	Stir thoroughly the contents of the container with a spatula and check colour before application <u>Mixing ratio (by volume)</u> ORART604 (Base): 5 parts ORART704HARD (Catalyst): 1 part Do not let moisture into the ORART188HARD
Application method	Brush, Roller, All types of spray equipment
Dilution	Thin up to 15% with ORART727. Homogenize the mixture. Do not use other solvents
Application	Apply 1 – 2 coats of 35 – 55 µm dry film thickness
Drying	Touch drying time: 2 hours Forced drying time: 20 – 30 min. at T = 70 – 80°C Drying time is very influenced by the dry film weight, type and state of the substrate and weather conditions.
Recoat able	12 – 24 hours
Cleaning	ORART727

## Application process

	Primer	Top coat
Iron, steel	ORART480	ORART604
Polyester	OROPRIMER 446	ORART604
Concrete	OROLUR 388	ORART604

## 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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