



625 POLYTHANE

PRODUCT DESCRIPTION

Commercial Performance Coatings 625 Polythane is a high performance, re-coatable acrylic polyurethane enamel with superior opacity.

It is used in atmospheric chemical and marine service where gloss and colour retention, hardness and abrasion resistance are required.

Commercial Performance Coatings 625 Polythane is available in a range of colours from the AS2700 and RAL Classic colour ranges.

PRODUCTS

Polythane Mixed Colour		625	
Hardeners		625-9220	Polythane Hardener Slow
		625-9225	Polythane Hardener Standard
		625-9386	Polythane Hardener Fast
		625-9807	Polythane 4:1 HS Hardener
Reducers	<i>Cold conditions</i>	PUR10	Polyurethane Reducer Fast
	<i>Normal conditions</i>	PUR20	Polyurethane Reducer Normal
	<i>Hot conditions</i>	PUR30	Polyurethane Reducer Slow
	<i>Very Hot conditions</i>	PUR40	Polyurethane Reducer Extra Slow
Cleaners		971-9119	PROTEC [®] Metal Conditioner
		AA-6822	Protec Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



Commercial Performance Coatings 625 Polythane can be applied over the following primers:

- EPS EtchPro Primer Surfacer, 426 EtchPro, 426 Vinyl Etch
- 408 Epotec Primer Surfacer, 428 Barrierprime, 470 Barrierprime

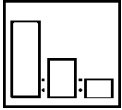


Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

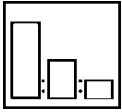
For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



625-9220, 625-9225, 625-9386 HARDENERS

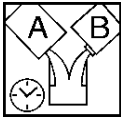
PRODUCT	PARTS
625 Polythane Mixed Colour	2
Hardener	1
Reducer	Up to 15%



625-9807 4:1 HS HARDENER

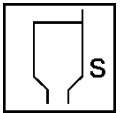
PRODUCT	PARTS
625 Polythane Mixed Colour	4
Hardener	1
Reducer	Up to 25%

POT LIFE



Catalysed material is useable for up to 6 hours at 25°C

SPRAY VISCOSITY



CONVENTIONAL, HVLP	16 - 24 seconds (DIN 4) at 25°C
AIRLESS, AIR ASSISTED AIRLESS	20 - 30 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.4 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar



AIRLESS, AIR ASSISTED AIRLESS

SETUP

- TIP 0.007 - 0.015
- PUMP RATIO 32:1

SPRAY PRESSURE

- AIRLESS 100 - 140 bar
- AIR ASSISTED AIRLESS 70 - 100 bar

APPLICATION & FLASH OFF



CONVENTIONAL, HVLP	2 wet, even coats
AIRLESS, AIR ASSISTED AIRLESS	1 - 2 wet, even coats

Allow 10 - 15 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80%, or if the surface temperature is within 3°C of the dew point.

DRYING TIMES



AIR DRY (25°C)

• TOUCH DRY:	3 hours
• HARD DRY:	16 hours

BAKE (65°C) 40 minutes

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied. Full cure will be achieved after 7 days.

RECOAT



Recoat within the potlife (6 hours) or after 16 hours.

Maximum recoat time is indefinite.

Aged films must be free of chalk and dirt (abraded and degreased) before recoating.

TOTAL DRY FILM BUILD

50 - 75 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	50 - 60%, depending on colour
COVERAGE	7.3 - 11.0 metres squared per litre (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	Excellent
ABRASION	Excellent
SOLVENT	Good to splash and spillage for common solvents
CHEMICAL	Good to splash and spillage for mild chemicals
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	Good. Satisfactory for intermittent immersion

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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