



625 POLYTHANE ELECTROSTATIC SATIN BLACK

PRODUCT DESCRIPTION

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

Used in conjunction with Electrostatic spray equipment it will improve wrap of the coating and minimize overspray.

PRODUCTS

Polythane Electrostatic Satin Black	625	
Hardeners	625-9220	Polythane Hardener Slow
	625-9225	Polythane Hardener Standard
	625-9386	Polythane Hardener Fast
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

SUBSTRATES & PREPARATION



CPC 625 Polythane Electrostatic Satin Black can be applied over the following primers:

- EPS EtchPro Primer Surfacer, VIN Vinyl Etch, PAR Paraloc,
- EPO Epotec Primer Surfacer, BAR 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.

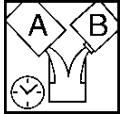
MIXING RATIO BY VOLUME



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

PRODUCT	PARTS
625 Polythane Mixed Colour	2
Hardener	1
Reducer	Up to 10%

POT LIFE



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

SPRAYGUN SETUP



ELECTROSTATIC SYSTEMS

Refer to electrostatic system manufacturers information and settings.

625 Polythane Electrostatic Satin Black can also be sprayed by conventional air application

SPRAY PRESSURE

Refer to manufacturers instructions.

APPLICATION & FLASH OFF



2 full, wet, even coats to achieve a dry film build 50-75µm

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

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)	41%, 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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