

# Nerothane 640 HB

## Scope

Nerothane 640 HB is a high-performance finish topcoat having excellent durability. It is tough, abrasion resistant and cures through a wide temperature range. It is recommended as a topcoat for use over various Nerolac epoxy primers, mid coat for use in new construction and maintenance services especially in areas subjected to bridges, power industries marine and industrial atmospheric exposures, having temperature resistance upto 120 °C

## Composition

Pigments dispersed in acrylic binder with separately packed clear Aliphatic isocyanate hardener.

Volume solids	64 ± 3 %
DFT / Coat	40 - 75 μ
Theoretical Coverage / Coat	8.53 - 16.00 m <sup>2</sup> / ltr.
VOC (EPA Method 24)	330 gm/Lit
Product Weight	1.20 kg/lit

## Product Details

Type	Two Pack
Mixing Ratio	By volume
Component A	9 Parts
Component B	1 Part
Colour	Various shades
Gloss	Glossy
Pot life	1 Hrs at 30°C
Curing mechanism	Solvent release and chemical reaction.
Flash Point comp A	Above 25°C
comp B	Above 25°C
Drying Time (30°C)	
Surface Dry	45 mins max
Hard Dry	16 - 18 Hrs
Recoating Time	Min 16 Hrs.
Thinner	Range of Nerolac PU Thinner
Thinner Consumption	
Conventional Spray	5 - 25%
Airless Spray	0 - 15%
Brush	0- 10%

## Application Details

**Applied over:**  
Primed surface

**Application Method:**  
Brush / conventional spray / Airless spray.

**Shelf Life:**  
12 months under normal storage condition in original sealed containers at 30°C

**Pack Size:**  
20 ltrs : (18 Lits - Part A + 2 Lits Part B = 20 lits Mix)..

**Surface Preparation:**  
Before applying Nerothane 640 HB the under coat must be clean dry and free from moisture grease and other contaminants in use of are aged epoxy under coat, the surface should be sufficiently roughened prior to painting.

**Application Instruction:**  
Stir comp A and comp B separately. If settling is observed in component A, loosen the settled material and mix it with the help of a pneumatic stirrer. Mix component A with comp B in the specified ratio under continuous stirring till homogeneous Add thinner as required. Filter through 100 mesh before application.

**Environmental Conditions:**  
Surface temperature must be 3°C above the dew point to prevent condensation.

**Temperature:**

Air	5 - 40°C
Surface	5 - 50°C

**Special Notes:**  
Thinner consumption may vary depending upon site conditions. Practical covering capacity depends on application techniques, ambient conditions, wastage, surface condition etc.

**Safety Precautions:**  
Please refer to the Material Safety Data Sheet.

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