

# Nerothane 640 HB

## Product Description

Pigments dispersed in acrylic binder with separately packed clear aliphatic isocyanate hardener

## Recommended Use

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.

## PHYSICAL PROPERTIES

|                        |                                         |
|------------------------|-----------------------------------------|
| Colour                 | In Various Shades                       |
| Finish                 | Glossy                                  |
| Temperature Resistance | Non-continuous: 120°C, Continuous: 80°C |

## Product Features

|                                               |                                                             |
|-----------------------------------------------|-------------------------------------------------------------|
| Excellent Gloss Retention & Weathering        | Excellent adhesion over epoxy primers                       |
| Excellent resistance to water and sea water   | Good resistance to oils and chemicals                       |
| Excellent Finish over MIO/ Intermediate Coats | Excellent resistance to highly corrosive & humid conditions |

## Product Details

### Volume solids



64 ± 3%

### DFT/Coat



40 - 75 μ

### VOC (EPA Method 24)



330 gm/Lit

### Theoretical Coverage/Coat



8.53 - 16.00 m<sup>2</sup>/litr.

## Pack size

20 Ltr.: (18.00 Ltr. - Part A + 2.00 Ltr. Part B = 20 Ltr. Mix).

## Drying at 30°C & 65% RH

|                     |            |
|---------------------|------------|
| Surface (Touch) Dry | 45 mins    |
| Hard Dry            | 8 - 12 Hrs |
| Full Cure           | 7 Days     |

## Overcoating Interval

| Temp | 20°C   | 30°C   | 40°C   |
|------|--------|--------|--------|
| Min  | 8 Hrs. | 5 Hrs. | 3 Hrs. |
| Max  | 5 days | 5 days | 5 days |

The overcoating interval varies with respect to changes in temperature, humidity & DFT.

After max. overcoating interval the surface should be roughened prior to application of subsequent coat.

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## Surface Preparation

All surfaces to be coated should be cleaned as per below guidelines:

- Remove oil, grease and other contaminants by suitable cleaner as per SSPC SP-1
- Remove dust, dirt and loose particles
- Surface should be clean & dry before application of coating

Nerothane 640 HB topcoat must be applied as per the recommended coating system. The primed surface must be clean, dry and free from moisture, grease and other contaminants. In case of aged primer under coat, the surface should be sufficiently roughened prior to application of topcoat.

## Application Instructions

Stir the Comp. A until homogenous. If settling is observed in the component A, loosen the settled material & mix it with the help of pneumatic stirrer. Mix component B gradually into component A in the specified ratio under continuous stirring till homogeneous. Use Nerolac PU thinner as specified.

### Mixing Ratio by Volume

Component A : Component B

9 : 1

Pot Life

Up to 2 hr at 30°C

Curing Mechanism

Solvent release and chemical reaction between two components.

### Thinner Consumption

Air Assisted Spray

5 – 20%

Airless Spray

0 – 10%

Brush / Roller

0 – 10%

### The product can be applied by:

- Airless Spray – Nozzle pressure: 175 bar [2500 psi] Nozzle orifice: 0.013–0.015"
- Conventional Spray / Air Assisted Spray
- Brush / Roller

### During application following precautions should be taken:

- Relative humidity must be below 85% during application as well as during curing
- Do not allow material to remain in hoses, gun or spray equipment
- Clean all equipment with recommended thinner immediately after completion of job

## Environmental Conditions

Surface temperature must be 3°C above Dew Point to prevent condensation.

Air

5 – 40°C

Surface

5 – 50°C

Relative Humidity

< 85%

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## Storage & Shelf Life

12 months under normal storage condition in original sealed containers at 30°C & well-ventilated area. Heavy pigments will have a natural tendency to settle down over time. Mix uniformly with heavy duty stirrer prior to usage. Hard settling may occur if stored above the recommended storage temperature.

## Safety Precautions

Please refer to the Material Safety Data Sheet.

## Product Compatibility

Compatible over Suitable Epoxy Primers & Epoxy Mastics, Epoxy Intermediate Coats & PU

## Special Notes

Thinner consumption may vary depending upon site conditions. Practical covering capacity depends on application techniques, ambient conditions, wastage, surface condition etc. The drying time and overcoating interval vary with respect to change in temperature, humidity, film thickness, ventilation, thinner intake etc.

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