

Kit Code: 646JB: Base 646J9; Curing Agent 941JB

Formerly Jones-Blair 4400-002

Description: Acrylithane DTM is a two component, direct-to-metal polyurethane topcoat formulated for spray applications in areas requiring VOC less than 3.5 lbs./US gallon (420 g/L).

Recommended use: For use on construction equipment, transportation equipment, truck frames, trailers, bulk tanks, chemical trailer applications that require a topcoat as a monocoat application.

Features:

- Excellent gloss and color retention.
- Good corrosion resistance.
- Resistant to chemical spills and splashes.
- Does not require a primer.
- Wide range of colors available.

Physical constants:

Color name/Shade code: White/10000 (other colors available)
Finish: High gloss
Volume solids: 57% ± 1
Theoretical spreading rate: 914 ft²/US gallon [22.8 m²/liter] – 1 mil [25 micron]
Flash point: 86°F/30°C (mixed product)
Specific gravity: 10.9 lbs/US gallon [1.3 kg/liter]
Dry to touch: 1 hour, 68°F/20°C
Dry to handle: 12+ hours, 68°F/20°C
Service temperatures: Maximum, dry service exposure only: 248°F/120°C
VOC content: 3.1 lbs/US gallon [370 g/liter]
The physical constants stated are nominal data according to the Hempel Group's approved formulas. VOC may be dependent on color.

Application details:

Products / Mix ratio: Base 646J9 : Curing Agent 941JB / 5.5 : 1 by volume
Application methods: Airless spray / Air spray / Brush or Roller
Thinners (max. vol.): 08NJB, 5% / 08NJB, 5% – 15% / 08DJB, 2 – 4 oz
Pot life: 4 hours, 68°F/20°C
Nozzle orifice: 0.011" – 0.013" airless, 0.110" or 2.8 MM fluid cap conventional
Nozzle pressure: 2,000 psi [138 bar]
(Airless spray data are indicative and subject to adjustment)
Cleaning of tools: 08320 Medium Reducer
Indicated film thickness, dry: 3.0 – 4.0 mils [76 – 102 microns]
Indicated film thickness, wet: 5.26 – 7.0 mils [133 – 178 microns]
Overcoat interval, min: 12 hours, 68°F/20°C
Overcoat interval, max: See Overcoating below

Surface preparation, new build:

- Abrasive blasting: Minimum Sa 2½ (ISO 8501-1:2007) or SSPC-SP 10.
- Surface profile: Medium (G) (ISO 8503-2).

Application conditions:

- Surface must be completely clean and dry at the time of application.
- Ensure adequate ventilation.
- Air and surface temperature must be 5°F/3°C above the dew point to avoid condensation.
- Air and surface temperature must be between 44°F – 100°F [7°C – 38°C].
- Paint temperature should be between 59°F – 77°F [15°C – 25°C] for best performance.
- Minimum temperature for curing is 44°F/7°C.

Preceding coat: None.

Subsequent coat: According to specification. Recommended system is Acrylithane DTM.

Overcoating: Sanding or roughening of surface is recommended if overcoating after 2 weeks.

Repair/maintenance:

- Remove oil and grease with suitable detergent.
- Remove salts and other contaminants by high pressure fresh water cleaning.
- Clean damaged areas by power tool to SSPC-SP 11 (or St 3, ISO 8501-1) or by abrasive blasting to minimum SSPC-SP 6 (or Sa 2, ISO 8501-1), preferably SSPC-SP 10.
- Remove dust and blast media.

Additional information:**Additives:**

Jones-Blair numbers and names in parentheses

- DMC or acetone: For viscosity adjustment in VOC-restricted areas.
- 08EJB (21102 Fast Spray Reducer): For viscosity adjustment in non-VOC restricted areas.
- 08320 (21092 Medium Reducer): For temperatures over 70°F/21°F.
- 08BBJ (21093 Slow Reducer): To reduce dry spray and orange peel.
- 085JB (21078 Special Urethane Retarder): To add a wet edge for spraying large parts.
- 99056 (99011 Accelerator): Shortens dry times.

Storage/shelf life:

- Store in a cool area to ensure full shelf life. Recommended temperature: 75°F/23°C.
- Shelf life: 646J9, 3 years; 941JB, 2 years.

Safety:

Handle with care. Use with adequate ventilation. Before and during use, observe all safety labels on packaging and paint containers, consult product Safety Data Sheets and follow all local or national safety regulations.

Note: Acrylithane DTM is for professional use only.

Issued by: Hempel (USA) – 646JB

This Product Data Sheet ("PDS") relates to the supplied product ("Product") and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under 'Products' at www.hempel.com (the "Additional documents"):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at www.hempel.com and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at www.hempel.com
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at www.hempel.com

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from www.hempel.com.

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