BY APPOINTMENT TO
HER MAJESTY THE QUEEN
MANUFACTURERS OF PAINT, VARNISHES & EMULSIONS
DACRYLATE PAINTS LTD.,
NOTTINGHAM

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PRODUCT INFORMATION

Dacrylate HS Sheen Polyurethane

Reference Number	:	585-LINE
Coating Type	:	Acrylic modified polyurethane a) Fully compliant to Environmental Protection act (1990) As required by guidance Note PG 6/23 (97), Clause 20(d) b) Conforms to Highways Agency Specification – Item 168
Typical Uses	:	Long term protection of galvanising, steel etc.
Colours Available	:	Full range to special order. **Note : DACMIX** *scheme available for all BS and RAL colours*.
Appearance of Dried Film	:	Sheen
Volume Solids	:	57%
Dry Film Thickness	:	**Typical** : 50 microns **Range** : 40-70 microns
Theoretical Coverage	:	11.4m^2 litre at 50 microns
Drying Time at 20°C *(will vary with temperature, air movement, etc.)*	:	**Touch Dry** : 2 hours **Firm Dry** : 6 hours **Overcoat** : N/A
V.O.C.	:	390 gram/litre
Packaging	:	5 litre composite pack

Shelf Life : 2 years or longer in unopened containers when stored under cover in good storage conditions.

Storage : Under cover within a temperature range of 5°C to 32°C.

Surface Preparation : Normally applied over Dacrylate Epidac 2 primers and Epidac 2 MIO or Highways Agency Item 111 and 112.

Application Conditions :

Humidity
Do not apply at relative humidities above 90%. Substrate temperature must be at least 3°C above dew point.

Temperature
Do not apply at temperatures below 5°C.

Note : *Dacrylate HS Polyurethane will **cure** at temperatures down to 0°C, however at temperatures below 15°C, the base and hardener will thicken considerably and affect application characteristics. At low ambient temperatures we would advise that base and hardener are warmed **separately** to 20°C before use to ensure optimum application properties.*

Effect of temperatures on drying/over-coating times

Overcoating Times	5°C	10°C	20°C	30°C
Surface Dry	6 Hours	4 hours	2 hours	1 hours
Hard Dry	16 Hours	12 hours	8 hours	4 hours
Minimum	16 Hours	12 hours	8 hours	4 hours
Maximum	---	---	---	---

Application : By brush or airless spray.

Airless spray: 2500psi (170 bar)
Tip size: 13-50 Thou (0.33mm – 0.38mm)

Apply at an approximate wet film thickness of 90 microns to achieve DFT of 50 microns.

Pot Life (at 20°C) : 4 Hours

Mixing Ratio By Volume : 4 parts base to 1 part activator

Clean-up : Dacrylate Thinner R6

Health and Safety	:	Please see relevant MSDS sheet.
N.B.		Certain products retain solvents for longer periods, which will affect plasticizers within the plastic packaging causing damage to the finish. It is therefore not recommended that finished painted products be wrapped in bubble wrap, plastic sleeves etc., until coatings are fully cured as this can cause damage to the finish especially when sacked or stored I sunlight/elevated temperatures. Damage can also occur from condensation caused by fluctuations in temperature consequently causing a "greenhouse" effect within the packaging