

Technical Data Sheet

Indothane 4800G

Polyurethane DTM (Direct-to-Metal) Finish

Product Description

Two component aliphatic Isocyanate cured Glossy, Fast Cured, DTM (Direct-to-Metal) polyurethane finish. Indothane 4800G is pigmented with zinc phosphate to provide anti corrosive properties.

Recommended Use

Indothane 4800G is specially designed for use as a single coat primer cum finish coating system to protect Construction and Mining heavy machinery, Agricultural equipment, Transportation vehicles, material handling and lifting equipment, Tanks and Vessels, and industrial structures. It gives good adhesion properties over correctly prepared steel and stainless steel and provides Good gloss and colour retention.

Physical Data

Colour	: Any IS/ RAL/ Custom Shades
Finish	: Glossy (75-90 GU at 60° angle)
Soild by Volume	: 55 ± 2%
Supply Weight (Kg/ Ltr)	: 1.15±0.05
Flash Point	: 30° C
Dry Heat Resistance	: Intermittent : 100°C, Continuous: 80°C
Shelf Life	: 12 months

Film Thickness

Recommended film thickness per coat

Dry Film Thickness	: 50-80µ in single coat
Wet Film Thickness	: 90-145µ in single coat
Therotical Coverage Rate	: 11.00 sq.mt / lit at recommended DFT of 50µ

Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning. This product is suitable for use over phosphate washed steel.

Primed Surface: The primed surface should be dry and free from all contamination and Indothane 4800G should be applied within the overcoating intervals specified in primer TDS.

Area of damaged primer or rework etc should be prepared as per specified standards, either by power tool cleaning or other means.

Steel: Abrasive blast clean to a minimum of Sa2½ (ISO 8501-1:2007). Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner. A surface profile of 30-40 microns is recommended.

Stainless Steel: Dirt and oils should be removed by solvent cleaning or other suitable cleaner followed by a thorough water rinsing. Sand or abrasive sweep blast to a standard similar to ISO 8501-1:2007 Sa1 to create a surface profile.

Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: 4 Part (Base) : 1 Part (Hardener)
Pot Life	: Three Hours at 30°C
Thinner and Cleaner	: Indothane PU Thinner (IK.1705)
Airless Nozzle Orifice	: 0.33 - 0.45mm
Nozzle Pressure	: 155 kg/cm ² or 2200 psi

Working Precautions: Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommence with freshly mixed units.

Maintenance: Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Drying Characteristics

Surface Dry	: 30 mins
Touch Dry (to Handle)	: 2 Hours
Hard Dry	: 16 Hours
Overcoating Interval	: Minimum 2 Hours

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Compatibility

Previous Coating	: Epoxy, Epoxy MIO, Epoxy Zinc Rich, Epoxy Mastic, Polyurethane
Subsequent Coating	: Polyurethane

Product Features

The gloss level is subject to application method, dry film thickness and environmental conditions within a controlled OEM painting facility. Gloss level achieved may differ if there is excessive variation in cure temperature and application thickness. The best results in terms of gloss and appearance will always be obtained by air spray application.

This product must only be thinned using the recommended thinner. The use of alternative thinners, might contains alcohols, can severely affect the curing mechanism of the coating. Indothane 4800G should be applied at least 3°C temperatures above dew point. During winters or at low temperature areas, condensation occurring during or immediately after application may result in a matt finish and an inferior film.

When applying Indothane 4800G by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness. The ability to apply Indothane 4800G in one coat will be affected by the temperature of the substrate. At higher steel temperatures, lower film builds and thinner coats are likely to be achieved.

Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

Precaution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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