

PRODUCT DESCRIPTION

Polyur 515 series is multi-purpose fast dry alkyd enamel suited for use in applications that require fast drying times and exterior durability.

PRODUCT FEATURES

- Excellent durability and gloss retention
- Fast drying
- Available in a shading base system
- **Color matching service is available to support your needs**

TYPICAL USES

- Interior piping and guard rails
- Material handling equipment
- Production machines
- Interior structures

TECHNICAL DATA

Colors available:	Available in several colors	Drying times:	
Gloss:	Gloss (available in semi-gloss)	Dust Free:	15 minutes
* Solids by volume:	36 % +/- 2 %	To recoat:	15 minutes - 3 hours (3 - 36 hours not recommended)
* Solids by Weight:	43 % +/- 2 %	Hard:	16 hours
Theoretical Coverage of 1 mil:	649 ft ² / U.S gallon	Reduction solvent:	DE - 300, DE - 400
D.F.T. at 25 microns:	60 m ² / 3.78 liters	Dilution:	10 - 15 % by volume
Recommended D.F.T. mils:	1.5 - 2.0	Shelf life:	12 months @ 25°C unopened
Dry film thickness microns:	37.5 - 50.0	Packaging:	3.78 liters (1 US gallons) 18.93 liters (5 US gallons)
Viscosity:	65 - 75 ku	Base packaging:	1 gal. 5 gal.
*Specific gravity	0.97 - 1.00 kg/lit	515 – 10 White	3.67 lts. 18.35 lts.
Flash Point:	24°C (75.2°F)	515 – 11 Deep	3.55 lts. 17.75 lts.
V.O.C.:	561 grams/liter 4.68 lbs / US gal.	515 – 12 Clear	3.31 lts. 16.55 lts.
* Data may vary according to colors			

Keep in cool and dry area

APPLICATION GUIDE

SURFACE PREPARATION

Remove all detrimental foreign matter such as oil, grease, dirt, soil, salts, drawing and cutting compounds and other contaminants from steel surfaces.

New surfaces: Prime with any of the following Polyur Primers 518 series, 718 series, E – 4400 series Epoxy Primers.

Previously Painted Surfaces: Wash to remove all contaminants. Rinse thoroughly with water and allow drying. Dully gloss areas by light sanding. Remove sanding dust and loose paint.

MIXING AND THINNING

The entire contents of each container must be mixed well before application.

Dilute 10 – 15 % by volume with thinner DE – 300 or DE – 400.

APPLICATION PROCESS

For application in or on the premises of a factory or a shop as part of a manufacturing, processing or repairing activity.

			RECOATING TIME		
Substrate temperature	Dust free	Hard	Minimum	Maximum	Normal
23°C (73°F)	15 minutes	16 hours	15 minutes	3 hours **	1 hour

**** Allow 36 hours to recoat, if not recoated between the 15 minutes and 3 hours window**

Brush and roller are not recommended for large surfaces

CONVENTIONAL SPRAY		AIRLESS SPRAY	
Manual Spray gun:	DeVilbiss JGA-510, MBC-510 or equivalent	Pump Ratio:	30:1
Fluid Nozzle:	E Fluid Tip	Pressure:	1500 – 3000 Psi
Air Cap:	704 or 765	Hose:	¾ inch, 50 ft length maximum
Atomizing Air:	45 – 75 lbs	Tip Size:	0.011 – 0.017
Fluid Pressure:	15 – 20 lbs	Filter Size:	50 Mesh (300 um)
Hose:	½ inch, 50 ft length maximum		

SPECIAL INSTRUCTIONS & PRODUCT LIMITATIONS

- Recoat must be done within 3 hours maximum otherwise allow 36 hours before recoating.
- Shelf life: 12 months @ 25°C (77°F) unopened

See the material safety data sheet and product label for complete safety and precaution requirements.

DISCLAIMER:

"The following is made in lieu of all warranties, expressed or implied: Manufacturer's obligation shall be to replace such quantity of the product proven to be defective. The manufacturer shall not be liable for any injury, loss or damage, direct or incidental or consequential, arising out of the use of or the inability to use the product. Before using, the user shall determine the suitability of the product for the intended use and the user assumes all risk and liability whatsoever in connection therewith. All values shown are approximations. Values indicated are for guide purposes only, as actual values can change due to application conditions, application methods, environmental conditions etc. The information contained herein is subject to change without notice. Consult your representative for a current data sheet. The foregoing may not be altered except by an agreement signed by the officers of the manufacturer."