

# PUR 840-G

## Polyurethane antioxidant 2K gloss

High performance, tough, industrial strength Direct To Metal 2K Polyurethane topcoat with high gloss, anticorrosive protection and superior chemical resistance. Product designed to be applied in a wide variety of DTM industrial applications where extreme protection and high gloss are required.

### PRODUCTS

Toners	<b>DISOLAC</b>	20 (w)
Binder	<b>PUR 840-G</b>	80 (w)
Hardener	<b>E9005 - medium</b>	4:1 (v)
	<b>E9003 - slow</b>	4:1 (v)
	<b>E9006 - fast</b>	4:1 (v)
	<b>E9105 – concentrated high solids medium</b>	8:1 (v)
	<b>E9103 – concentrated high solids slow</b>	8:1 (v)
	<b>E9106 – concentrated high solids fast</b>	8:1 (v)
Reducer	<b>UNIVERSAL SOLV 5 - medium</b>	0-30% (v)
	<b>UNIVERSAL SOLV 3 - slow</b>	0-30% (v)
	<b>UNIVERSAL SOLV 6 – fast</b>	0-30% (v)
	<b>R225 – exempt VOC &amp; 0 HAPS reducer</b>	0-30% (v)

*\*For use with E-910X the amount of reducer has to be increased about 10%.*

### CHARACTERISTICS OF PUR 840-G

<b>Appearance</b>	High gloss	
<b>Gloss</b>	>90 at 60°, 70-80 at 20°	
<b>Specific weight</b>	8.3-9.2 lb/gal @68°F	
<b>Solid content (binder)</b>	52-58% (weight)	42-48% (volume)
<b>Solid content RFU (without reducer)</b>	48-57 % (weight)	38-43 % (volume)
<b>Dry film thickness</b>	2.4-2.8 mils (2 coats)	
<b>Theoretical coverage per Gallon of mixing without dilution @ 1 mil DFT</b>	670-770 ft <sup>2</sup>	
<b>Corrosion category system 840-G (ISO 12944)</b>	C3 Medium / C4 Low (5.1 mils)	
	<b>Salt spray resistance</b>	240 h
	<b>Humidity resistance</b>	120 h
<b>Pencil hardness</b>	H	

## VOC

E-9005								
% reducer	VOC REGULATORY Univ. Solv. 5		VOC ACTUAL Univ. Solv. 5		VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L
0	4,3	514,1	4,3	514,1	4,3	514,1	4,3	514,1
10	4,5	542,8	4,5	542,8	4,3	514,1	4,0	475,7
20	4,7	568,0	4,7	568,0	4,3	514,1	3,7	443,4
30	4,9	589,5	4,9	589,5	4,3	514,1	3,5	414,6

E-9105								
% reducer	VOC REGULATORY Univ. Solv. 5		VOC ACTUAL Univ. Solv. 5		VOC REGULATORY R225		VOC ACTUAL R225	
	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L	lb/gal	g/L
0	3,9	466,1	3,9	466,1	3,9	466,1	3,9	466,1
10	4,2	502,1	4,2	502,1	3,9	466,1	3,6	427,8
20	4,5	533,2	4,5	533,2	3,9	466,1	3,3	396,6
30	4,7	558,4	4,7	558,4	3,9	466,1	3,1	367,9

\*VOC in the table is average, for specific colors check on iCrom






## SUSTRATE AND PREPARATION OF THE SURFACE

	CLEAN	SANDED	FINAL CLEAN
Old paint	DA93	P320/400	DA93
Steel	DA93	P320/400 (optional)	--
Galvanized steel	DA93	P320/400 (optional)	--
Aluminum	DA93	P320/400 (optional)	--
<b>PRIMERS</b>			
Primanyl 5011	DA93	--	--
Primapox 6021	DA93	Optional (P320)	DA93
Primapox 6041	DA93	Optional (P320)	DA93
Primapur 9051	DA93	Optional (P320)	DA93


For other substrates consult with the Technical Assistance (SAT).

## APPLICATION






	PIECE		BIG SURFACE	
T(°F)	Hardener	Reducer	Hardener	Reducer
64-77	E9005/E9006 E9105/E9106	UNIVERSAL SOLV 5 or 6 / R225	E9005 E9105	UNIVERSAL SOLV 5 / R225
77-90	E9005 E9105	UNIVERSAL SOLV 5 / R225	E9003 E9103	UNIVERSAL SOLV 3 / R225
>90	E9005/E9003 E9105	UNIVERSAL SOLV 3 / R225	E9003 E9103	UNIVERSAL SOLV 3 / R225

	Application	% reducer (Vol.)	Viscosity – 68°F (Ford Cup 4)	Pressure (psi)	Product pressure (psi)	Nozzle (mm)	Num. Of coats x dry mil	Flash off (min)
	Gravity feed spray gun	20-30%	20-25"	26-36	---	1.3-1.6	2x0.8-1.4	10-15' 68°F
	Airless	10-20%	28-40"	---	1500-2200	9-13	1.5x3-4	10-15' 68°F
	Air assisted airless	10-20%	28-40"	5-15	1000-1700	9-13	2x2-2.4	10-15' 68°F
	Pressure pot	20-30%	20-25"	20-30	5-15	1-1.4	2x0.8-1.4	10-15' 68°F

If the application requires the use of an additive, it should be taken into account in the addition of reducer.

Pot life	59°F	68°F	86°F
	3h 30'	3h	2h 15'

## DRYING

 TEMPERATURE	 DUST DRY	 TO TOUCH	 TO HANDLE	 TO RECOAT
68° F (air dry)	10-15 min	2h 30'-3h	4-4h30'	24h
86°F	5-10 min	2h-2h30'	3-3h 45'	24h
140° F (30' forced dry)	---	---	30'	24h

Drying at lower temperature or higher thickness increases drying time.  
The product reaches its maximum performance after 15 days of drying in the air (ambient temperature 64-72°F) or in a shorter time at higher temperature.

## ADDITIONAL ADDITIVES FOR SPECIAL USES

SITUATION	ADDITIVE	DESCRIPTION	EFFECT
Craters	<b>Anti-crater additive</b>	Film protection against external contaminations.	Anti-crater, film protection.
Outdoor resistance / UV filters	<b>UV additive</b>	Film protection against UV rays.	Increases film durability.
Sensitivity to spray / Too fast film drying	<b>Flow additive</b>	Improves the applicability, for example in wide superficies or drying weathers.	Increases open film time.
Resistivity adjustment	<b>Electrostatic additive</b>	It's used to adjust the coating resistivity according to the equipment used.	Decreases coating resistivity.
Slip / cleaning	<b>Ultraclean additive</b>	Increases the slip power of the film and facilitate the cleanliness.	More slip and easy to clean.
Anti-slip	<b>Textured additive</b>	Convert smooth coatings to textured coatings increasing the film hardness and gives a powder paint effect.	Anti-slip, film hardness.
Sagging resistance	<b>Tixo additive</b>	Sagging resistance and it is used to have higher film thicknesses.	Higher film thicknesses with sagging resistance.

For use and instructions of the additives consult the technical data sheet of each product.

## REMARKS

- Recommended to be used in ventilated spray booth at 68°F.

## EQUIPMENT CLEANING

- Use a cleaning thinner before the pot life has expired.

## SAFETY

- Follow instructions on product label.
- For more information check the Safety Data Sheet.
- Compliant with the National Statutory Regulation for Health and Safety at Work and Waste Disposal.

## STORAGE

- Store the product in a ventilated place far from direct exposure to sunlight.
- Keep between 41 and 86°F.

## SHELF LIFE

- One year in unopened original packaging.

## ANNEX A

Brightness table (60° angle)

PUR 840G	PUR 840M	E9005 (in volume)	GLOSS (^60°)	CATEGORY
100	0	4:1	>90	HIGH GLOSS
75	25	4:1	70-90	GLOSS
50	50	4:1	40-70	SEMI-GLOSS
25	75	4:1	20-40	SATIN
0	100	4:1	<20	FLAT

*Degree of gloss obtained through the mixture ratio Toner / Binder (20/80).*

*The degree of gloss depends on the color applied, dry thickness, substrate, drying temperature...*

*These products are for professional use only. The Safety Data Sheet should be consulted before use and the precautionary warnings on the product packaging should be observed. Its correct use, according to its purpose and respecting its technical and security data, provided in these documents, is the sole and exclusive responsibility of the user. ROBERLO S.A.U declines any liability due to the incorrect use of any product.*

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