

## Technical Data Sheet

# Indothane 4080HB

### Polyurethane High Build High Performance Finish

### Product Description

Two component Aliphatic Hardener cured high build PU finish provides excellent weather resistance and colour retention properties. It gives excellent toughness, high film build and chemical resistance properties and recommended for use in coastal and chemical environment.

### Recommended Use

Indothane 4080HB is recommended where matt or satin finish is needed. It has excellent weathering resistance and is recommended as topcoat over epoxy or PU primers for better aesthetics and corrosion resistance. It is recommended for Oil Refineries, Fertilizer Plants, Petrochemical & Chemical Plants, Transportation and Heavy Vehicle Industries, Power Plants, Rail coach & Chemical wagon exteriors, Offshore Structures etc.

### Physical Data

Colour	: Any IS/ RAL/ Custom Shades
Finish	: Matt to Eggshell (20-40GU at 60° angle)
Soild by Volume	: 60 ± 2%
Supply Weight (Kg/ Ltr)	: 1.30±0.05
Flash Point	: 29° C
Dry Heat Resistance	: Intermittent : 120°C, Continuous: 100°C
Shelf Life	: 12 months

### Film Thickness

#### Recommended film thickness per coat

Dry Film Thickness	: 60-120μ in single coat
Wet Film Thickness	: 100-200μ in single coat
Therotical Coverage Rate	: 10.00 sq.mt / lit at recommended DFT of 60μ

### 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.

**Primed Surface:** Indothane 4080HB should be always be applied over anti corrosive primed surface. For final smooth finish, proper sanding of already coated primer is recommended. Existing system should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

**Maintenance:** Area of damage or rework etc should be prepared as per specified standards, either by power tool cleaning or other means. A patch primer should be applied before application of Indothane 4080HB for desired performance of the product.

## Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: 9 Part (Base) : 1 Part (Hardener)
Pot Life	: Three Hours at 30°C
Thinner and Cleaner	: Indothane PU Thinner (IK.1701/ IK.1705)
Airless Nozzle Orifice	: 0.48 - 0.53mm
Nozzle Pressure	: 155 kg/cm <sup>2</sup> 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 recommences 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	: 24 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 Mastic, Epoxy Zinc Rich, Polyurethane
Subsequent Coating	: Polyurethane, Acrylic

## Product Features

The gloss level mentioned above and surface finish are dependent on paint application method. Whenever possible application should be done with one method only. The best results in terms of gloss and appearance will always be obtained by air spray application.

When overcoating after aging, coating should be fully cleaned to remove all surface contamination such as oil, grease, salts, traffic fumes etc.

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 4080HB 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 an inferior film formation.

When applying Indothane 4080HB 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 4080HB 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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