

641JB: Base 641J9: Curing Agent 941JB

Description:	ACRYLITHANE™ HS POLYURETHANE is a two component, high performance polyurethane topcoat formulated for spray usage in areas requiring VOC less than 3.5 lbs /US gallon. It offers a full gloss, high quality appearance with exceptional color and gloss retention, while offering exceptional chemical resistance.
Recommended use:	For use on automobiles, trucks, trailers, bulk tanks, chemical trailers and commercial architectural applications that require a premium topcoat appearance.
Features:	Uses same catalyst as UREPRIME® 2.8 PRIMER Excellent gloss and color retention Chemical resistant Low VOC Wide color and metallic offering
Service temperatures:	Maximum, dry service exposure only: 120°C/248°F
Availability:	Not included in Group Assortment. Availability subject to confirmation.

PHYSICAL CONSTANTS:

Shade no./Color:	1L000 (formerly J-B 45070) / White*
Finish:	Full Gloss
Volume solids, %:	55 ± 1
Theoretical spreading rate:	14.3 m ² /litre - 38 microns 588 sq.ft./US gallon - 1.5 mils
Flash point:	77°F/25°C
Specific Gravity:	1.3 kg/litre – 10.9 lbs/US gallon
Dry to touch:	4 hours at 20°C/68°F
Through Dry to handle	6 hours
Viscosity	25" / Zahn 3
VOC content:	393 g/litre [<3.3 lbs/US gallon] <i>*wide range of colors and metallic available via Acrylithane™ HS Tint System</i>

The physical constants stated are nominal data according to approved formulas.

APPLICATION DETAILS:

Version, mixed product	641JB
Mixing ratio:	BASE 641J9 (formerly JB 45070) : CURING AGENT 941JB (formerly JB 99955) 3:1 by volume
Application method:	<u>Airless spray</u> <u>Air spray</u>
Thinner (max.vol.):	0832 (formerly J-B 21092) Medium Reducer 0-5% 5 – 15%
Pot life:	4.0 hours at 20°C/68°F
Nozzle orifice:	0.011"-.0.013" airless / 0.110" or 2.8 MM fluid cap (air spray)
Nozzle pressure:	138 bar [2,000 psi] <i>(Airless spray data are indicative and subject to adjustment)</i>
Cleaning of tools:	MEDIUM REDUCER 0832 (formerly J-B 21092)
Indicated film thickness, dry:	38 – 75 microns / 1.5 – 3.0 mils
Indicated film thickness, wet:	69 - 136 microns / 2.7 – 5.5 mils
Overcoat interval, min:	3 hours (20°C/68°F); 2 hours w/ 1.0 oz./mixed gallon of 99056 accelerator (formerly JB 99011)
Overcoat interval, max:	See REMARKS overleaf

Safety: Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult Safety Data Sheets and follow all local or national safety regulations.

- SURFACE PREPARATION:** Prime according to specification.
- APPLICATION CONDITIONS:** Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 7°C / 44°F. The temperature of the paint itself should be: 15-25°C / 59-77°F. In confined spaces provide adequate ventilation during application and drying. Thinning may be necessary in the case of very long spray hoses and/or paint temperatures below 15°C / 59°F. This will cause lower film build and longer drying time. Alternate reducers such as Acetone may be used to reduce product without adding VOC.
- PRECEDING COAT:** UREPRIME® 2.8 or CHEM-O-GARD LOW VOC PRIMER or CHEM-O-PON EPOXY PRIMER or according to specification.
- SUBSEQUENT COAT:** None or ACRYLITHANE™ HS or according to specification.
- REMARKS:**
- Mixing:** Mix thoroughly before use. Add 1 quart of catalyst to a 1 gallon unit of ACRYLITHANE™ HS ENAMEL (3:1) and mix thoroughly again. Only apply when air and surface temperature are between 7°C – 38°C / 44°F - 100°F.
- Thinning:** Add 08EJB (*formerly 21102 Fast Spray Reducer*) as required. When temperature is over 20°C/68°F, use 08320 (*formerly JB 21092 Medium Reducer*). Add 08BJB (*formerly JB 21093 Slow Reducer*) to reduce dry spray and orange peel, if required. 085JB (*formerly JB 21078 Special Urethane Retarder*) can be added to help add a wet edge for spraying large parts.
- Drying:** Under normal conditions, dries to touch in 4 hours and dries for overcoat in 3 hours for spray applications. Low temperature, high humidity, poor ventilation and thick films will retard drying. Addition of 99056 accelerator (*formerly JB 99011*) at the rate of 1.0 fl. /oz. per mixed gallon will shorten dry times to spray overcoat at 2 hours and to touch at 2.5 hours. Addition of 99056 at 2.0 oz. per mixed gallon will result in an overcoat time of 1.5 hours and to touch in 2.0 hours.
- Pot life:** Pot life is approximately 4 hours after mixing. Mix only the amount of material that can be used in 4 hours. Pot life is decreased with an increase in temperature. Mixed material should be kept in as cool a location as possible. Flush mixed material from pressure pot and lines immediately after use.
- Cleaning:** Clean paint tools or spills immediately with MEK, or lacquer thinner carefully observing cautions on paint and thinner labels. Dried paint may need to be removed by scraping.
- Overcoating:** Sanding is recommended if overcoating after 2 weeks.

Note: **ACRYLITHANE™ HS is for professional use only.**

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This Product Data Sheet supersedes those previously issued.
For explanations, definitions and scope, see "Explanatory Notes" available on hempel.com. Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.
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