

643JB : BASE 643J9: CURING AGENT 941JB

Description:	Acrylithane™ 2.8 Polyurethane 643JB is a two component, high performance polyurethane topcoat formulated for spray usage in areas requiring VOC less than 2.8 lbs/US gallon. It offers a high quality appearance with exceptional color and gloss retention, as well as 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:

Color/Shade no.:	Deep White Base/01300* (JB 4700)
Finish:	High Gloss
Volume solids, %:	56 ± 1
Theoretical spreading rate:	22.4 m ² /l – 25 μ 898 sq. ft./US gal. – 1 mil ² 25°C / 78°F
Specific Gravity:	1.3 kg/liter – 10.8 lbs/US gallon
Dry to touch:	4 hours at 20°C/68°F
Dry to handle:	6 hours at 20°C/68°F
Viscosity:	30-35" / Zahn 3
VOC content:	333 g/liter [2.8 lbs/US gallon] <i>The physical constants stated are nominal data according to approved formulas. *Wide range of colors and metallic effects available via Acrylithane™ HS Tint System.</i>

Application details:

Version, mixed product	643JB
Mixing ratio:	BASE 643J9 (JB 4700) : CURING AGENT 941JB (JB 99955) 3:1 by volume
Application method:	Airless spray / Air spray
Thinner (max.vol.):	0832 (J-B 21092) Medium Reducer 0-5% / 5-15%
Pot life:	4 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 (JB 21092)
Indicated film thickness, dry:	38 – 75 μ / 1.5 – 3 mils
Indicated film thickness, wet:	67 – 133 μ / 2.7 – 5.2 mils
Overcoat interval, min:	3 hours (20°C/68°F); 2 hours w/ 1.0 oz./mixed gal. of 99056 accelerator (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 Hempel Safety Data Sheets and follow all local or national safety regulations.
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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°C–25°C/59°F–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:	According to specification. Recommended systems are: Ureprime® 2.8 or Chem-O-Gard Low VOC Primer or Chem-O-Pon Epoxy Primer.
Subsequent coat:	None, or Acrylithane™ 2.8, or according to specification.
Remarks:	<p>Mixing: Mix thoroughly before use. Add 1 quart of catalyst to a 1 gallon unit of Acrylithane™ 2.8 Enamel (3:1) and mix thoroughly again. Only apply when air and surface temperature are between 7°C–38°C/44°F–100°F.</p> <p>Thinning: Add 08EJB (21102 Fast Spray Reducer) as required. When temperature is over 20°C/68°F, use 08320 (JB 21092 Medium Reducer). Add 08BJB (JB 21093 Slow Reducer) to reduce dry spray and orange peel, if required. 085JB (JB 21078 Special Urethane Retarder) can be added to help add a wet edge for spraying large parts.</p> <p>Pot life: 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.</p> <p>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 (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. The addition of 99056 of 2.0 oz. per mixed gallon will result in an overcoat time of 1.5 hours and to touch in 2 hours.</p> <p>Cleaning: Clean paint tools or spills immediately with 08320 (21092 Medium Reducer), MEK, or lacquer thinner carefully observing cautions on paint and thinner labels. Dried paint may need to be removed by scraping.</p>
Overcoating note:	Sanding or roughening of surface is recommended if overcoating after 2 weeks.

Note: **ACRYLITHANE™ 2.8 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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