850 Spraythane

AFTER 15 YEARS, STILL AUSTRALIA'S FAVOURITE

850

Easy to use and FAST.

850-series polyurethanes are among the most popular and easy coating systems in Australia – simply mix and start spraying for a fantastic result.

Amazingly rapid curing means turnaround from spraying to packing is minimised.

Available in gloss, sating and matt – as well as a virtually unlimited colour range.

Designed for evic group Xpress Tint In-house Tinting System

Key Product Features

- Part Bs provide solvent boil resistance in hot and humid conditions.
- Fast application with minimal dry times.
- Spraythane has rapid touch dry and can be print free in 2 hours @ 25°C.
- High gloss, mar-resistant, tile-like finish.
- Will cut and buff to a mirror finish if required.
- Virtual non-yellowing interior durability.
- Available in gloss, satin and matt.
- Virtually unlimited colour range.
- Three part B's available, intermixable to allow personalised curing rates.

Ideal Use

850 is being used throughout Australia and South East Asia by large and small companies alike for kitchens, bathrooms, furniture and commercial fixtures. Interior finishing only, excellent mar (scratch and chip) resistance. Chemical and stain resistant to all household cleaners, food and solvents.

Available Sizes

PART A (850A) is available in **1L, 3L, 6L, 9L** and **15L** cans

PART B (850B, 854B and 856B) is available in **1L** and **5L** sizes

Kits (A+B) in 4L, 8L, 12L and 20L are also available

MIXING RATIO (A:B) IS 3:1 – product must be applied strictly as specified.

Gloss Levels

850 Spraythane is available in full gloss (95-100%), satin (55-65%) and matt (25-35%) finishes. Textured finishes are available in 853 Vinyltex.

Colour Information

850 Spraythane is available in a range of virtually unlimited colours.

The extensive range is produced with high-grade lead-free pigments. Among the range many bright clean shades are available to meet the demands of architects, designers and colour stylists.

Coverage Rate

Approximately three square metres per mixed litre in practice. Variations to coverage and loss from overspray can occur due to many variables, including: shape and size of the substrate, gun type and settings, gloss level of the product and the colour selected.

Mixing

MIX BY VOLUME 3 part of "A" to 1 part of "B".

Stir separately Part "A" and Part "B" thoroughly. Ensure only the quantity that can be applied within the normal pot life is mixed at any one time. Stir thoroughly with a flat blade stirrer (not round) before use.

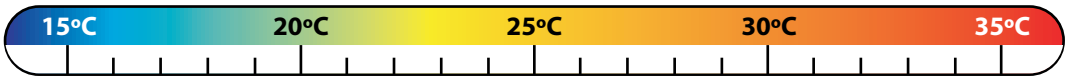
Thin Quantity

Thin up to 5% with 850S or 900S solvent if required.

850 Spraythane is generally ready to spray once mixed. Higher temperatures and some satin and matt may require up to 5% thinning.

Using a faster Part B (such as 850B) in hot or humid weather can lead to loss of flow and possible solvent boil. Using slower combinations (e.g. 856B and 5% solvent) in cool conditions may cause sagging, mild colour variation and longer through-cure times.

Working Temperature



PART B SELECTION

THINNER NOT NORMALLY REQUIRED – 850 IS READY FOR USE

Compatible Products

Compatible Primers: 145E etch primer (for metal substrates); and 730/731 polyurethane, and 750/766 polyester sanding primers (for timber/MDF)

Part B Hardener: 850B (for cool-mild conditions); 854B (for medium-hot conditions); and 856B (for hot-extreme conditions)

Spraying Solvents (only if required, see POT LIFE): 850S (solvent for normal conditions); and 900S (solvent for warm-extreme conditions)

Pot Life Estimates

The estimated pot life at 20°C is 2-3 hours.

Higher temperatures will affect pot life. During the pot life the material viscosity will increase. Slight thinning using either 850S or 900S towards the end of pot life may be required to maintain spraying viscosity.

Dry Times*

Touch Dry: 8-15 minutes

Print-Free: 2-3 hours

Recoat: 3-4 hours (if no sanding is required); overnight if sanding is needed

Time to Packing: 8-24 hours from final coat

*Stated times are based on using 850B in normal conditions. All dry times are dependent upon working temperature, part B and solvent selections.

Suggested Equipment

Conventional Spray Gun: Use a premium two-pack gun such as the Anest Iwata W200.15 at 275-310kpa (40-45psi).

Pressure Pot: Set pressure to 55kpa (8psi) and maintain gun pressure at 275kpa (40 psi).

Important Application Information

Mix or handle product in a spray booth or equivalent ventilated space. Spray application in a spray booth is required using a positive pressure air-fed face mask.

Pre-Prep

Air clean prepared surface, wipe over with a dampened lint-free cloth or tack cloth removing all dust or fine particles. Change cloth regularly.

Preparation

In order to ensure you achieve the true colour and uniform coverage in application, it is important to use a suitable base coat with all edges covered and no "rub throughs".

ALUMINIUM, ZINCALUME, GALVANISED & MILD STEEL (for interior use ONLY): Prepare and prime as per data sheet with Evic 145E Etch and Protect Primer. Available in light grey. If sanding is required, use 730/731 polyurethane primer.

MDF BOARD: Prepare and prime as per data sheet with either: 730/731 polyurethane primer; 750 Superbuild polyester primer; or 766 UltraSand polyester primer.

MELAMINE: Properly sand surface with 240 to 320 grit free-cut paper, removing any appearance of gloss. Solvent wash with 825S, de-dust and apply 850 Spraythane directly. **Warning -** 850 Spraythane does not stick to unsanded melamine. This surface must be prepared correctly (especially in corners or hard to reach areas). Melamine easily wears out sandpaper, further polishing the surface. This makes coating adhesion impossible.

Application

For best results, apply 850 Spraythane in two or three double-header cross coats overlapping each pass by 50% and allowing 2-10 minutes between each double header. Always spray away from yourself to minimise overspray.

For a higher gloss finish, apply two double header coats, rack and allow 45-60 minutes drying at 25°C, then follow (without sanding) with finishing flow coats. allowing minimal flash-off between coats.

If intercoat sanding is required, cut back with 320-500 grit sandpaper or the 3M P600 sanding disc.

Clean Up

Spraying equipment and mixing utensils should be thoroughly flushed clean with 800S or 825S solvent before the coating cures.

Baking

Allow 45–60 minutes flash off time then bake at up to 60ºC for one to two hours.

Buffing

After overnight cure, 850 Spraythane is easily cut and buffed if required. Denib the surface using 2000 grit microfine wet sandpaper or 800–1200 grit ultrafine dry sanding disc. Buff the surface with a foam waffle pad combined with 3M Perfect-It or AutoGlym buffing compound. Finer buffing or sanding scratches are removed by polishing with a black waffle pad and 3M's Foam Polishing Glaze or Ultrafine Glaze.

Buffing can have a slight effect on the appearance of colour, so care should be taken if you place buffed material adjacent to unbuffed surfaces.

After Care

To clean stains, marks or spills from 850 Spraythane once cured, use 3M Glass & Laminate Cleaner or equivalent. Spray directly onto the surface and wipe off with a clean, dry (preferably lint-free) cloth. Alternatively, for cleaning without chemicals and removing fingerprints and smudging, the Scotch-Brite High Performance Cloth is recommended.

Colour Matching

Because of the huge variations that occur in paint charts, samples, etc., it is your responsibility to ensure any colour we provide is correct or acceptable to you and your customer **before you use it**.

The Evic Group will not accept liability for any colour once it has been applied. We recommend reading Evic's **Guide to Colour** for comprehensive details of our colour matching services and terms and conditions of sale.

LEAD FREE COLOURS: The Australian Uniform Paint Standard requires that all paints used for any furniture application contain less than 0.1% lead by weight in the dry film. We encourage all applicators to adhere to this standard when using any Evic Group product.

To meet this requirement, all 850 Spraythane colours are manufactured with lead-free pigments. Caution: most bright yellows, oranges and reds will exhibit poor opacity with lead-free pigments. Extra paint will be required to achieve coverage – estimates for required paint should bear this in mind.

Colours can also be tinted using Evic's **Xpress Tint** In-House Tinting System.

GLOSS LEVELS: Products are manufactured to conform to the gloss levels shown ±5%. Levels are read using a 60º head according to AS1580 method 602.2.

Shelf Life

Up to 12 months if stored in properly sealed containers. Part "B" is moisture sensitive and should be stored in full containers with minimal air pad.

Note to Users

This is a specialised industrial coating and should only be applied by experienced and competent tradesmen and in accordance with the manufactures specification.

Please read Material Safety Data Sheets M850.

More Information

Go to **www.evic.com.au** for product and material safety data on all Evic products. Information is also available in booklet and CD-ROM form, or by e-mail and fax transmission.

For further enquiries, call the Evic Group on (freecall) 1800 761 761.

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