

OROMEL 612

POLYURETHANE ENAMEL

Catalyzed at 4:1 ratio by volume with **OROCAT 714**

Two pack aliphatic polyurethane enamel, satin finish and high outdoor resistance (high protection against U.V.rays). Forms a hard and waterproof film, resistant to oils, salts and gasoline. Good direct adherence on any metal surface. Specially formulated for painting and decorating metal substrates, plastic and concrete. Ideal as a top coat for epoxy-polyurethane systems. C3-C5 tests validated by CIDETEC technology centre.

Physical parameters	Base OROMEL 612	Catalyst OROCAT 714
Viscosity (Ford cup #4)	90 – 240 (depending on the colour)	11 – 15"
Specific gravity	0,95 – 1,30 g/CC (colour depending)	0,96 – 1,00 g/cc
Solids content	50 – 65% (depending on the colour)	40 – 45%
In-can appearance	Viscous liquid	Slightly viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	4:1 by volume (OROMEL 612:OROCAT 714)
Viscosity of the mixture	-"
Specific gravity of the mixture	0,95 – 1,20 g/cc (depending on the colour)
Solids content	50 – 60%
Colour	White and tinting bases (white base P and clear base TR)
Dry film appearance	Satin finish with good adhesion and resistance
Spreading rate	9 – 11 m ² / L (90 – 130 g/m ²)
Gloss	40 – 60%
Adhesion	100% (Máx: GT0)
VOC	<500 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L
Pot life of mixture	3 – 4 hours

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Product use information

Surface	Iron, Steel, Concrete, Polyester
Surface preparation	Iron, aluminum and steel surfaces must be clean, dry, without grease or rust. In the case of concrete surfaces, these must be clean, dry and unpolished. Finally, polyester has to be sanded and degreased. On old paints, sand and ensure good adhesion.
Product preparation	Stir thoroughly the contents of the container with a spatula. Make the mixture (by volume) 4 parts of OROMEL 612 (Base) to 1 part of OROCAT 714 (Catalyst). Do not let the OROCAT 714 come into direct contact with moisture.
Application method	Brush, Pneumatic spray
Dilution	Up to 15% with ORODIS 720. Homogenize the mixture. Do not use other solvents.
Application	Apply 1 – 2 coats of 40 – 50 µm dry film thickness
Drying	Touch drying time: 1 – 2 hours Forced drying time: 10–15 min. at T _{room} and 20–30 min. at T = 70–80°C Drying time is very influenced by the dry film weight, type and state of the substrate and weather conditions.
Recoatable	12 – 24 hours
Cleaning	ORODIS 720

Application process

	Primer	Top coat
Iron, steel	OROPRIMER 485	OROMEL 612
Aluminum	OROPRIMER 455	OROMEL 612
Polyester	OROPRIMER 446	OROMEL 612
Concrete	OROLUR 388	OROMEL 612

Additional information

Safety	Consult package labelling. For further information, ask for the Material Safety Data Sheet
Storage	1 year

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