

OROMEL 607

TEXTURED POLYURETHANE ENAMEL

Crosslink by mixing 5:1 by volume with **OROCAT 714** catalyst

2-component textured aliphatic polyurethane enamel. Satin finish with high resistance to the outdoor environment (high protection from UV rays). Forms a hard, waterproof film that is resistant to oils, salts and petrols. Specially formulated to finish different metal substrates, suitably primed, that require a coarse finish.

Physical parameters	Base OROMEL 612	Catalyst OROCAT 714
Viscosity	13000-17000 cP (depending on colour) (Brookfield 10 rpm)	11 – 15" (Ford n°4)
Specific weight	1.2 - 1.35 g/ml (depending on colour)	0.96 – 1.00 g/cc
Solids	67-70% (depending on colour)	40 – 45%
Appearance in the container	Viscous liquid	Low viscous liquid
Stability (unopened)	12 months at 10 - 25°C	12 months

Mixing characteristics	
Mixing ratio	5:1 by volume (OROMEL 607:OROCAT 714)
Viscosity of the mixture	-"
Specific weight of the mixture	1.17 - 1.29 g/ml (depending on colour)
Mix solids	62-65%
Colour	White and colour-mixing bases (White base P and Transparent base TR)
Dry film appearance	Textured satin with good adhesion and strength.
Coverage	14 – 12 m ² /l (85 – 110 g/m ²)
Gloss	20-40%
Adhesion	100% (Max: GT0)
COV	<500 g/l Limit value (2010) according to Directive 2004/42/EC for this product (sub. cat. A/j): 500 g/l
Pot life of the mixture	3 – 4 hours

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OROMEL 607	OYR607XXXZZZ	OROPAL	IRURENA GROUP	03.01.24	1	All of the above	1/2	EN

Using the product

Substrate	Iron, steel, polyester
Preparing the substrate	Iron, aluminium and steel surfaces must be clean, dry and free of grease and rust. Concrete must be clean, dry and unpolished. Finally, the polyester must be sanded and degreased. In the event of old paint, sand and ensure good adhesion.
Preparing the product	Stir the contents of the container thoroughly with a spatula. Mix with the catalyst (by volume), 5 parts OROMEL 607 (base) to 1 part OROCAT 714 (catalyst). Do not allow moisture to enter the OROCAT 714 catalyst
How to apply	Spray gun
Diluting	Up to 10% of ORODIS 707 or ORODIS 728. Do not use other solvents
Application	1 - 2 coats of 30 - 40 µm
Drying/curing	Touch dry: 1 – 2 hours. Forced drying: 10 – 15 min. at ambient temp. and 20-30 min. at temp = 70 – 80°C Drying time is highly influenced by weight, type and condition of the substrate, and environmental conditions.
Repainting	12 – 24 hours
Cleaning	ORODIS 720

Recommended system

	Primer	Finish
Iron, steel	OROPRIMER 485	OROMEL 607
Aluminium, galvanised steel	OROPRIMER 475	OROMEL 607
Polyester	OROPRIMER 446	OROMEL 607

Further information

Safety	See package labelling. Ask for the Material Safety Datasheet for more information.
Shelf life	1 year

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