

OROMEL 610

POLYURETHANE ENAMEL

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

Two pack aliphatic polyurethane enamel, matt 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 610	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 610: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	Matt finish with good adhesion and resistance
Spreading rate	11 – 15 m ² / L (90 – 130 g/m ²)
Gloss	<20%
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

Instructions included in this technical data sheet and its advices have been got from our own experiences and they should be taken as guidelines, with no commitment from us. Values shown in this technical data sheet are only a reference and must not be considered as strict. The customer can and should check the goods provided by us, verifying they are right and valid for their offered purposes. It is completely out of our control the correct application of the product as well as its adequate use, variable working circumstances, etc, so this means the customer is responsible for them. This stated, we completely guarantee the quality of our products, as a consequence of our sales and delivery commitments previously established.

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OROMEL 610	OYR610XXXZZ	OROPAL	IRURENA GROUP	03.01.24	1	Any previous version	1/2	EN

Product use information

Surface	Iron, Steel, Concrete, Polyester
Surface preparation	Iron 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 610 (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 610
Aluminum	OROPRIMER 455	OROMEL 610
Polyester	OROPRIMER 446	OROMEL 610
Concrete	OROLUR 388	OROMEL 610

Additional information

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

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