

OROMEL 623

POLYURETHANE ENAMEL

Mix 4:1 by volume with **OROCAT 781**

2 pack high solids finishing primer based on aliphatic polyurethane resins. It forms a hard semi-glossy film and it's waterproof and resistant to U.V rays, oils, salts and gasolines. Especially formulated for painting one coat on structures that require a high protection against oxidation. It exceeds the 720 hours of salt spray required for C4 systems.

Physical parameters	Primer OROMEL 623	Catalyst OROCAT 781
Viscosity (Ford cup nº 6)	280 – 340"	150 – 200"
Specific gravity	1,24 – 1,35 g/mL	1,05 – 1,10 g/cc
Solids	70 – 75%	75%
In-can appearance	Viscous liquid	Viscous liquid
Stability (without opening the can)	12 months at 10 – 25°C	12 months

Characteristics of the mixture		
Mixture ratio	4:1 by volume (OROMEL 623:OROCAT 781)	
Mixture viscosity	150 - 170"	
Mixture specific gravity	1,20 – 1,30 g/mL	
Sólidos de la mezcla	70 – 75%	
Colour	White (ask for colours)	
Dry film appearance	Semi-gloss finish with good adherence and very resistant	
Spreading rate	4 – 8 m ² / L (320 – 160 g/m ²)	
Gloss	60-80 %	
Adhesion	100% (Máx: GT0)	
VOC	<500 g/L	Limit value (2010) according to directive 2004/42 / CE for this product (subcategory A / j): 500 g / L
Mixture Pot life	2 hours	

Product use information	
Surface	Iron, Steel,
Surface preparation	Iron and steel surfaces must be clean, dry, free of grease and rust.
Product preparation	Stir thoroughly the contents of the container with a spatula. Make the mixture with the catalyst (by volume) of 4 parts of OROMEL 623 (Base) with 1 part of OROCAT 781 (Catalyst). Do not let moisture enter the OROCAT 781 catalyst
Application method	Brush, Pneumatic spray
Dilution	Brush: Dilute max. 5% with ORODIS 720 Spray: Dilute max. 10% with ORODIS 721

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OROMEL 624	OYR623XXXZZ	OROPAL	IRURENA GROUP	03.01.24	1	Any previous version	1/2	EN

Application	Apply 1 coat of 75-150 µm dry film thickness
Drying	Touch drying time: 2 – 3 hours Forced drying: 10 - 15 min. (Room temp.) and 20-30 min. at T = 70-80 ° C Drying time is very influenced by the applied quantity, the environment and the substrate's type and condition.
Recoatable	12 – 24 hours
Cleaning	ORODIS 720

Application process	Primer	I	Top coat
Iron, Steel	-----		OROMEL 623

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

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