



## TECHNICAL DATA SHEET – ULTRATHANE 5410

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### PRODUCT DESCRIPTION

A fast cure 100% solids hot spray applied coating system designed to produce a tough, impact resistant surface designed for a number of applications.

### FEATURES

- No primer required onto EPS or PU foam.
- Fast cure for increased productivity
- Zero VOC's

### RECOMMENDED USES

Often used as a protective coating for wood in speaker cabinet applications ensuring an easy clean long lasting finish.

### PACKAGE SIZE

VOLUME	10 & 110 US Gallons 37.8 & 415.8 Liters
WEIGHT	39.9 & 438.7 kg

### PHYSICAL PROPERTIES

COLOR	A Component is Amber ISOCYANATE B Component is Black POLYOL Mixed product is Black
MIX RATIO BY VOLUME A:B	1:1
MIX RATIO BY WEIGHT A:B	1:1.13
SG	1:1
% SOLIDS BY VOLUME	100
FLASH POINTS, °C	149
GEL TIME AT 60°C/ SECONDS	5-10
RECOMMENDED DFT, MM	~0.75-1.50mm in one multi pass coat

### PERFORMANCE PROPERTIES

TENSILE STRENGTH, MPA	25-30
ELONGATION, %	20-30
TEMPERATURE RESISTANCE, °C	Maximum 65
THEORETICAL COVERAGE	1.0 L/m <sup>2</sup> /mm dft
HARDNESS, SHORE D	70-75
IMPACT RESISTANCE, KJ/M <sup>2</sup> (ISO 180)	31.5
GARDENER IMPACT, M/KG (ASTM D2795)	2.48

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### ORDERING INFORMATION

PACKAGING	1 gal kits (Includes Adhesion Promoter 1552)
SHIPPING WEIGHT	~ 12 lbs (5.5 kg)

### SURFACE PREPARATION

All substrates should be clean, dry and free from any oil or grease. Metal should be abrasive blasted to produce an SA 2 ½ finish with a minimum of 75 micron profile for optimum adhesion. Product should only be applied in conditions where the Temperature is 3°C above the dew point and Relative Humidity is <85%

### MIXING

The product is hot spray applied and mixing is an essential part of the operation occurring within the gun. (See Application section for further info)

### APPLICATION

- Prior to commencing use of the product ensure that the two components are stored at temperature no lower than 20°C, a temperature of around 25°C is preferable and can be achieved by storage in a heated room or the use of electrical jacket heaters. The B component should be thoroughly power mixed prior to use.
- Suitable dispensing equipment is required in order to apply this product. Equipment must be capable of, delivering product to the gun at ~ 120-170 bar, with each component accurately metered in a 1:1 ratio by volume. The output of the machine should be capable of matching the highest output of the gun being used. Accurate temperature control of the two components should be possible, typically up to 70°C, with this heating being incorporated into the hose up to or as close as possible to the gun.
- The spray gun must use high pressure impingement to achieve satisfactory mixing of the components immediately on triggering. Some static mixer modified guns are also suitable, consult ITW Polymers Sealants North America to discuss suitable systems.
- To achieve an even finish during application the gun should be held at right angles to the substrate at a distance of 30-70cm, this can depend on the output volume and pressure.
- Review the appropriate Specification Guideline for detailed application instructions.

### CURE TIME

	10°C	20°C	30°C
SURFACE DRY @ 1.0MM / MINUTES	5	2	1
CURE 100% @ 1.0MM / DAYS	2	1	1
RECOAT TIME MINIMUM / MINUTES	<8	<4	<2
MAXIMUM WITHOUT REACTIVATION / HOURS	15	8	1
ABRADE, DEDUST / HOURS	>15	>8	>1

### CLEAN UP

All equipment should be thoroughly cleaned directly after use using Mesamoll or suitable alternative. Spray guns should be cleaned using a proprietary cleaner as recommended by the manufacturer.

### SHELF LIFE & STORAGE

12 months from date of shipment when stored at room temperature (~22°C) in original unopened containers in a dry environment.

### PRECAUTIONS

For complete safety and handling information, please refer to Material Safety Data Sheets prior to using this product.

ITW Polymers Sealants North America, Inc. warrants its products to be free from defects in material and workmanship. ITW Polymers Sealants North America, Inc.'s sole obligation and Buyer's exclusive remedy in connection with the products shall be limited, at ITW Polymers Sealants North America, Inc.'s option, to either replacement of products not conforming to this warranty or credit to Buyer's account in the invoiced amount of the nonconforming products. Any claim under this Warranty must be made by Buyer to ITW Polymers Sealants North America, Inc. in writing within five days of Buyer's discovery of the claimed defect, but in no event later than the expiration of the applicable shelf life, or one year from the delivery date, whichever is earlier. Buyer's failure to notify ITW Polymers Sealants North America, Inc. of such nonconformance as required herein shall bar Buyer from recovery under this warranty.

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