

### Kit Code: 645J1; Base 645J9; Curing Agent 97050

Formerly Jones-Blair 4600

- Description:** Acrylithane HS4 is a high performance polyurethane topcoat formulated for use in areas requiring VOC less than 100 grams / liter. It offers a full gloss, high quality appearance.
- Recommended use:** For use on automobiles, trucks, trailers, bulk tanks, chemical trailers and commercial architectural applications that require a premium topcoat appearance.
- Features:**
- Uses same catalyst as Ureprime HS4 primer.
  - Excellent color and gloss retention.
  - Chemical resistant.
  - Ultra-low VOC.
- Service temperatures:** Maximum, dry service exposure only: 120°C/248°F.

### Physical constants:

Color/Shade code:	White/10000 (other colors available)
Finish:	High gloss
Volume solids:	59% ± 1
Theoretical spreading rate:	946 ft <sup>2</sup> /US gallon [23.6 m <sup>2</sup> /liter] – 1 mils [25 microns]
Flash point:	46°F/8°C
Specific gravity:	10.2 lbs/US gallon [1.22 kg/liter]
Viscosity:	20" – 30", Zahn 3
Touch dry:	8 hours, 68°F/20°C
Through dry:	12 hours, 68°F/20°C
VOC content:	64 g/liter [0.53 lbs/US gallon]

*The physical constants stated are nominal data according to the Hempel Group's approved formulas. VOC may be dependent on color.*

### Application details:

Product / Mix ratio:	Base 645J9 : Curing agent 97050/ 4 : 1 by volume
Application method:	Airless spray / Air spray / Brush or Roller
Thinner (max. vol.):	None, thinning not required (see Additives on Page 2)
Pot life:	1.5 hours, 68°F/20°C
Nozzle orifice:	0.011" – 0.013" airless / 0.110" or 2.8 MM fluid cap conventional
Nozzle pressure:	2,000 psi [138 bar] <i>(Airless spray data are indicative and subject to adjustment)</i>
Cleaning of tools:	08320 Medium Reducer
Indicated film thickness, dry:	1.5 – 3 mils [38 – 76 microns]
Indicated film thickness, wet:	2.3 – 4.8 mils [60 – 120 microns]
Overcoat interval, min:	4 hours, 68°F/20°C and 3 hours, 68°F/20°C if using accelerator
Overcoat interval, max:	See Overcoating Page 2

- Application conditions:**
- Surface must be completely clean and dry at the time of application.
  - Ensure adequate ventilation.
  - Air and surface temperature must be above the dew point to avoid condensation.
  - Paint temperature should be between 59°F – 77°F [15°C – 25°C] for best performance.
  - Only apply when air and surface temperatures are above 44°F/7°C.

**Preceding coat:** According to specification. Recommended system is: Ureprime HS4.

**Subsequent coat:** None, or according to specification. Recommended system is: Acrylithane HS4.

### Additional information:

**Additives:**

*Jones-Blair numbers and names in parentheses*

- 08EJB (21102 Fast Spray Reducer): For viscosity adjustment in non-VOC restricted areas.
- 08320 (21092 Medium Reducer): For temperatures over 70°F/21°C.
- Use exempt solvents such as acetone to maintain low VOC.
- Accelerator (90056) may be added at the rate of 1.0 fl oz per mixed gallon to reduce dry time

**Storage/shelf life:**

- Store in a cool area to ensure full shelf life. Recommended temperature: 75°F/23°C.
- Shelf life: 645J9, 3 years; 97050, 2 years.

**Safety:**

Handle with care. Use with adequate ventilation. Before and during use, observe all safety labels on packaging and paint containers, consult product Safety Data Sheets and follow all local or national safety regulations.

**Overcoating:**

No Accelerator Spray

Min Recoat.....4 hours

Max Recoat..... It is recommended to first test for adhesion by wiping the surface with solvents listed for thinning. If the film shows a slight “tack”; the surface is suitable for recoating without abrading to create profile.

With .5 fl oz/gal 99056

Min Recoat.....3 hours

Max Recoat..... It is recommended to first test for adhesion by wiping the surface with solvents listed for thinning. If the film shows a slight “tack”; the surface is suitable for recoating without abrading to create profile.

**Note:**

**Acrylithane HS4 is for professional use only.**

**Issued by:**

Hempel (USA) – 645J1

This Product Data Sheet (“PDS”) relates to the supplied product (“Product”) and is subject to updating from time-to-time. Accordingly, the buyer/applicator should have regard to the PDS supplied together with the relevant batch of the Product (and not an earlier version). In addition to the PDS, the buyer/applicator may receive some or all of the following specifications, statements and/or guidelines as listed below or as are available from the Hempel website under ‘Products’ at [www.hempel.com](http://www.hempel.com) (the “Additional documents”):

No.	Document description	Location/comments
1.	Technical Statement	One-off specific advice provided on request for specific projects
2.	Specification	Only issued for specific projects
3.	PDS	This document
4.	Explanatory Notes to the PDS	Available at <a href="http://www.hempel.com">www.hempel.com</a> and contain relevant information about the Product testing parameters
5.	Application Instruction	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>
6.	Generic technical guidelines (e.g. on application and surface preparation)	Where available, at <a href="http://www.hempel.com">www.hempel.com</a>

In the event of a conflict of information between the PDS and the Additional documents, the order of priority of information shall be in the order as set out above. In such event you should also contact your representative at Hempel for clarification. Furthermore, the buyer/applicator must have full regard to the relevant Safety Data Sheet provided with each Product and which can also be downloaded from [www.hempel.com](http://www.hempel.com).

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