



Product Information

Chempro 64 Exterior - 410-13XX

PRODUCT DESCRIPTION

410-1310	Flat
410-1320	Low Gloss
410-1340	Satin Gloss
410-1360	Semi-Gloss
410-1390	Full Gloss

Chempro 64 is a single component, high performance, exterior, polyurethane coating. Chempro 64 is used in many exterior wood applications including especially for the coating of exterior wood doors.

FEATURES

Chempro 64 is the best coating to use for a hard finish with good mar resistance, chemical resistance and excellent durability.

Chempro 64 is designed for finishing of exterior surfaces such as wood doors but can be used for all types of interior finishing such as furniture, cabinets, millwork, etc

The coating dries to a completely crosslinked polymer network of polyurethane which provides excellent exterior durability.

Chempro 64 is designed to have high toughness and elongation properties along with ultra-violet light protection

SPECIFICATION VALUES

Gloss:	As required
Flash Point:	15°C (60°F)
Specific Gravity:	0.87
Weight per Gallon:	7.25
Solids by Weight:	36%
Solids by Volume:	29%
Viscosity at 25°C (77°F):	30"Z#2
VOC:	545 g/l
Lbs. VOC/Gallon:	4.42
Lbs. VOC/Lbs. Solids:	1.67
Lbs. VHAPs/Lbs. Solids:	0.75

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

Shelf Life: Six months recommended if unopened and stored between 15°C - 25°C (59°F - 77°F).

Always rotate stock.

Pot Life: N/A.

Coverage: Coverage is 480 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: N/A.

Reduction: This product is to be applied unreduced.

Sealers: Chempro 64 Exterior is recommended to be used as a self-seal product.

Surface Preparation: Substrate must be sanded using 120, 150 or 180 grit paper prior to staining or coating. When sealing, the sealer coat should be sanded prior to being coated with 280/320 grit steared paper. The sealer should be topcoated within eight hours of being sanded. This product is designed to be used as a self-seal. When recoating, the previous coat of Chempro 64 must be sanded and the next coat applied within eight hours.

Directions for Use: Agitate material before use. Chempro 64 must be agitated constantly to ensure product consistency and consistent gloss.

Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 240/280 grit steared paper. Repeat coats every 4 hours until desired build is achieved. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Full cure of Chempro 64 is obtained after 5-7 days at 25°C (77°F) or 24 hours at 50°C (122°F).

Maximum film build of Chempro 64 should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure. The completed coating system should be checked for required properties prior to start-up of production.

APPLICATION

Method of Application:	Viscosity	Wet Film	Dry Film
Spray - Conventional	Z #2/25-30"	3-5 mils	0.6-1.1 mils
- Airless	Z #2/25-30"	3-5 mils	0.6-1.1 mils
- HVLP	Z #2/25-30"	3-5 mils	0.6-1.1 mils

All measurements recommended are based on results at temperatures of 20°C (68°F). Viscosity will vary depending on the temperature of the liquid.

Drying Times:

At 20°C (68°F)	(Minimum Required)	At 50°C (122°F)	(Minimum Required)
Tack Free:	30-40 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	4 hours	Dry to Sand:	2-4 hours
Dry to Stack:	Overnight	Dry to Stack:	8 hours
Full Cure:	5-7 days	Full Cure:	24 hours

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 18°C (64°F) must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

Clean-Up: Use lacquer thinners (if compliance allows) or Acetone (800-5500) for clean-up.

Chemcraft Coatings Technology views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.