



OA 5450 Permathane Aliphatic Polyurethane

Product Data/ Application Instructions

- **Excellent covering**
- **Good adhesion to new & weathered surfaces**
- **Easy to apply**
- **Quick drying**
- **Attractive glossy finish**
- **Rejects soil pick-up**
- **Weather resistant**
- **Ultraviolet light resistant.**
- **Abrasion resistant**

A tough Aliphatic Polyurethane with many applications. It has an attractive glossy finish which is resistant to a wide range of polluted industrial and marine environments. Excellent weather resistance, unaffected by ultra violet rays. Can be used over many substrates in interior and exterior conditions.

Typical Uses

Permathane OA 5450 can be used to seal and provide a glossy finish to textured finishes. It can be used to protect suitably primed steel or concrete.

Application data summary

For complete information on procedures, equipment and safety precautions, see the application instruction as accompanying shipment. Like all high-performance coatings OA 5450 Permathane must be applied as recommended to obtain the maximum performance.

Physical Data

Finish	Glossy
Color	See Color Chart
Surface	Suitable for Primed Concrete and Steel
Components	2
Curing mechanism.....	Solvent release and chemical reaction between components.
Volume Solids.....	58%
Dry film thickness	25 - 50 microns (2mil) percoat
Number of Coats	1
Calculated Coverage.....	11.6 m ² /ltr at 50 microns (2 mils)
	allow for application losses, surface irregularities etc.
Application	Airless or Conventional Spray.
Pot life.....	20 hrs at 20 °C
Drying times	
Dry to touch	1 hour at 21°C
Dry to through.....	8 hours at 21°C
Note :	Pot life, drying times and curing time dependent on temperature.
Mixing ratio	4 parts Resin to (by volume) 1 part cure.
Temperature Resistance	
Continuous	93°C dry
Intermittent.....	121°C dry
Thinner	OA 65
Cleaner.....	OA 12
Flash points (Closed cup) OA 5450	
Resin	30°C
Cure.....	30°C
OA 65.....	27°C
OA 12.....	3°C

**Volume solids is measured in accordance with ASTM-D-2697. Variations may occur due to colour and testing variance

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Surface Preparation

Clean off all surface dirt. Use detergent and water to remove oily deposits if present.

Can be applied over textured coatings such as:

Amertex 2269

Amertex 2270 and

OA 5064 Epoxy Primer

OA 5383 Epoxy

Application Equipment

AIRLESS SPRAY - Standard airless spray equipment

Dilute with Amercoat 65 Thinner only as required to achieve an even spray pattern (5-10% max)

CONVENTIONAL SPRAY – Standard Industrial equipment. Separate air and fluid pressure regulators. Mechanical pot agitator and a moisture and oil trap in the main air supply line are recommended. Dilute with AM 65 Thinner only as required to achieve an even pattern (5-10% max)

ROLLER - For touch up purposes.

MIXER - Use power mixer powered by an air motor or an explosion proof electric motor.

Application Data

Substrate Suitable for Primed Concrete and Steel

Application methods Roller, Airless or conventional spray

Environmental Conditions (during application and drying)

Air temperature: 0 to 50°C 32 - 122°F

Surface temperature: 0 to 60°C 32 - 140°F

Drying times

Dry to touch 1 hour at 21°C

Dry to through 8 hours at 21°C

- Depending on ambient temperature & surface conditions.

Surface temperature must be at least 3°C/5°F above dew point to prevent moisture condensation on the surface. Never apply coatings under adverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation and elimination of solvents.

NOTE: drying times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions. Times are proportionally shorter at higher temperature and longer at lower temperatures. Prior to recoating ensure the surface is clean. Maximum recoating time intervals are dependent on temperature, degree of weathering and service conditions of the complete coating system. Consult your OAL representative for specific recommendations.

Thinners OA 65

Cleaner OA 12

OA 5450 Permthane

Application Procedure

OA 5450 Permthane is packed in the proper mixing proportions of resin base and curing solution which must be mixed together.

- 14 ltr resin in 20 ltr can
- 3.5 ltr cure in 1 US Gallon can

1. Flush equipment with OA 12 before use.
2. Stir both resin base and curing solution to an even consistency with a Power mixer.
3. Add curing solution to resin solution and continue stirring for 5 minutes.
Note : donot mix more material than will be used with 20 hours at 21°C. Pot life is shortened by higher temperatures.
4. Dilute with OA 65 thinner only as required to achieve an even spray pattern.
5. For conventional spray, thin only as needed for workability within not more than 10 vol% of OA 65. Thinning is normally not required.
6. Application 25-50 microns dry film thickness per coat is to be advised.
7. Ventilation with air is required during application and drying
8. Clean all equipment after application with OA 12 Cleaner.

Safety Instructions

1. Ventilate work area.
2. Check to ensure that fire or explosion risks are eliminated.
3. Cover all cuts or wounds.
4. Avoid inhaling or ingesting product. (Use mask and goggles for all spray applications).
5. Cover skin as much as possible.
6. Wash hands regularly. Use suitable soft soap.
7. Protect eyes. If product gets into eyes wash out with water until clear. Seek medical assistance.
8. In the event of accidental ingestion seek immediate medical assistance.
9. Take extra care when using airless spray equipment to avoid accidental injury.

Shipping Data

Packing	
Resin	14 ltr
Cure.....	3.5 ltr
Shipping Weight	
Resin	21.95 Kg approx
Cure.....	3.96 Kg approx.
Storage	out of sun light.
Shelf life.....	1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C.

OA 5450 Permathane

Caution

This product is flammable. Keep container closed. Use with adequate ventilation. Avoid prolonged and repeated contact with skin. If used in confined areas, observe the following precautions to prevent hazards of fire or explosion or damage to health:

1. circulate adequate fresh air continuously during application and drying;
2. use fresh air masks and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking.

Do not empty into drains. Take precautionary measures against static discharges. For specific information on hazardous ingredients, required ventilation, possible consequences of contact, exposure and safety measures see Safety Data Sheet.

Safety

Since improper use and handling can be hazardous to health and cause of fire or explosion, safety precautions included with Product Data/Application Instruction and Material Safety Data Sheet must be observed during all storage, handling, use and drying periods.

Warranty

OAL warrants its products to be free from defects in material and workmanship. OAL's sole obligations and Buyer's exclusive remedy in connection with the products shall be limited, at OAL's option, to either replacement of products not conforming this warranty or credit to Buyer's account in the invoiced amount of the non-conforming products. Any claim under this warranty must be made by Buyer to OAL in writing within five (5) 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 OAL of such non-conformance as required herein shall bar Buyer from recovery under this

warranty.

OAL makes no other warranties concerning the product. No other warranties, whether express, implied or statutory, such as warranties of merchantability or fitness particular purpose, shall apply. In no event shall OAL be liable for consequential or incidental damages.

Any recommendations or suggestion relating to the use of the products made by OAL, whether in its technical literature, or response to specific enquiry, or otherwise, is based on data believed to be reliable; however, the products and information are intended for use by Buyer's having requisite skill and know-how in the industry, and therefore it is Buyer to satisfy itself of the suitability of the products for its own particular use and it shall be deemed that Buyer has done so, as its sole discretion and risk. Variation in environment, changes in procedures of use, or extrapolation of data may cause unsatisfactory results.

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Due to OAL's policy of continuous product improvement, the information contained in this Product Data/Application Instructions sheet is subject to change without notice. It is the Buyer's responsibility to check that this issue is current prior to using the product. For the most up-to-date Product Data/Application Instructions always refer to the OAL Protective & Marine Coatings website at www.oasisameronpaints.com

To avoid any confusion that may arise through translation into other languages, the English version of the Product Data/Application Instructions will be the governing literature and must be referred to in case of deviations with product literature in other languages.

Condition of Sale

All our transactions are subject to our Terms and Conditions of Sale.

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