



AMERLUX



Protective Coatings

Product Data/ Application Instructions

- Self-priming polyurethane coat
- Outstanding weather resistance
- Excellent colour and gloss retention
- Resists soil pick up - easily cleanable
- Hard, tough, flexible, and abrasion resistant
- Cure through a wide temperature range
- Re-coatable with itself

Typical Uses

Permathane OA 2605 ZP is a self-priming zinc phosphate acrylic aliphatic polyurethane. A self-priming polyurethane with good anti corrosive properties. It can be applied directly to steel substrate. It can be used where single coat is needed to protect the steel from corrosion and exterior weather conditions. As required by manufacturing plants, steel frames, containers etc.

Systems Using Permathane 2605 ZP

Permathane 2605 ZP can be applied directly on steel, over epoxy primers, Zinc rich primers, or as a glossy finish coat over high build epoxies.

Outstanding Characteristics

Permathane 2605 ZP is an Acrylic Aliphatic Polyurethane coating, which has excellent anti corrosion properties, resistance to weathering, provides durability in chemical, industrial and marine environments. Permathane 2605 ZP forms a hard, tough, flexible and abrasion resistant coating with excellent colour and gloss retention.

Permathane 2605 ZP

Acrylic Aliphatic Polyurethane

Physical Data

Finish.....	Gloss, SG, Matt
Colour.....	RAL and BS colours*
Components	2
Mixing ratio (volume).....	4 part resin to 1 part cure
Curing mechanism	solvent evaporation and reaction
	between
components Volume solids	62 ± 3% *
Dry film thickness	50 - 150 microns per coat
Number of coats.....	1 or 2
Theoretical coverage.....	12.4 m ² /L at 50 microns.
	allow for application losses, due to surface irregularities etc.
Temperature resistance °C	
Continuous.....	92 dry
Intermittent	120 dry
Flashpoints °C	
Cure.....	30
Resin	30
Thinner 55	24
Thinner	OA 55
Cleaner.....	OA 55
	.
	*Volume solids is measured in accordance with ASTM-D-2697. Variations may occur due to colour and testing variances

Permathane OA 2605 ZP Acrylic Aliphatic Polyurethane

Surface Preparation

STEEL- Prepare surface in accordance with Application instructions for the specific primer being used. Be sure primed area is clean and dry when Permathane 2605 ZP is applied. Permathane 2605 ZP can be applied directly on steel surface prepared as per SSPC-SP10.

Application equipment

The following equipment is listed as a guidance. Suitable equipment from other manufacturers may be used. Adjustments of pressures and of tip sizes may be Needed to obtain the proper spray characteristics.

AIRLESS PRAY- Standard airless spray equipment such as Graco with a 0.38 o 0.43mm (0.011 o 0.019 inch) orifice/ tip.

CONVENTIONAL SPRAY- Industrial equipment such as Devilbiss MBC or JGA gun with 78 or 765 air cap and " E" fluid tip.

MIXING- Use power mixer. Mixer must be powered by an air motor or an explosion proof electric motor.

Application Data

Substrates Primed Steel substrate

Surface preparation Refer to the Product Data Sheets of specific primer or Intermediate coat as recommended.

Application method Airless or conventional spray, brush or roller.

Environmental conditions

Air temperature 0-50 °C 32-122 °F

Surface temperature 0-60 °C 32-140 °F

Surface temperature must be at least 3°C / 5°F above the dew point to prevent moisture condensation on the surface.

Pot life (21°C) 6 hours

Drying times (°C) 40°C 32°C 21°C

Dry to touch 30 min 45 min 1 hr

Dry through (hours) 2 h 4 h 8 h

Fully cured (days) 3 d 5 d 7

Over Coating Minimum Maximum
3 h Unlimited

Thinner OA 55

Equipment cleaner OA 55

* Permathane OA 2605 ZP can be recoated with itself when dry through. However, surfaces must be clean, dry and free of contamination immediately prior to recoating. OAL Technical Service team can advise on suitable cleaning methods.

Permthane OA 2605 ZP Acrylic Aliphatic Polyurethane

Application Procedure

Permthane 2605 ZP is packed in the proper mixing Proportions of resin base and curing solution which must be mixed.

16 ltr resin in 20 ltr can
4 ltr cure in 5 ltr can

1. Flush equipment with Thinner 55 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: Do not mix more material than will be used with 20 hours at 21°C. Pot life is shortened by higher temperatures.
4. For conventional spray, thin only as needed for workability within not more than 10 vol % of Thinner 55. Thinning is normally not needed.
5. Apply a wet coating even parallel pass. Overlap each pass 50% to avoid bare areas, pinholes, or holidays.
6. Give special attention to corners, welds, rough areas, edges etc.
7. The application of 88 microns will normally provide 50 microns (2 mills) dry film.
8. Check thickness of dry coating with a non-destructive dry film thickness gauge. Such as Mikrotest or Elcometer. If less than specified thickness, apply additional material as needed.
9. Small damaged or bare areas and random pinholes or holidays can be touched up by brush. Repair large areas by spray.
10. In confined areas ventilate with clean air during Application and drying until all solvents are removed. Temperature and humidity of ventilating air must be such that condensation will not form on surface.
11. Clean all equipment with Thinner 55 immediately after use or at least at the end of each working day or shift. When left in spray equipment, Permthane OA 2600 will cure and cause clogging'.

Drying & Curing times(at 50 microns)

To touch 1- 2 hours 21°C
Dry through 8 hours 21°C

Curing time is temperature dependent.
At 21°C seven days are required for a full cure.
For mild atmospheric exposure, coating may be placed in service before it is fully cured

Repair

For repair, or application of additional thickness, Permthane 2605 ZP has a long-term over coating period with itself. Ensure surface is clean, dry and free from contamination immediately prior to application.

Packaging

Resin 16 L
Cure 4 L

Shipping weight

Resin..... approx. 27.00 kg
.....
Cure approx. 4.30 kg

Minimum shelf life

Resin and cure, 1 year from shipment date when stored indoors in unopened, original containers at 5 to 40°C (41 to 104°F)

Permthane OA 2605 ZP Acrylic Aliphatic Polyurethane

Caution

This product is flammable. Keep away from heat and open flame. 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 the 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 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.

Oasis Ameron 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.

Limitation of Liability

OAL's liability on any claim of any kind, including claims based upon OAL's negligence or strict liability, for any loss or damage arising out of, connected with, or resulting from the use of the products, shall in no case exceed the purchase price allocable to the products or part thereof which give rise to the claim. In no event shall OAL be liable for consequential or incidental damages.

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 website at www.oasisameron.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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