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**PRODUCT DESCRIPTION**

A two pack, aliphatic, high solid, flexible polyester modified polyurethane coating, Highly adhesion promoted, zinc phosphate pigmented and UV resistant.

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**INTENDED USES**

PU DTM Flexi HB can be used as a Direct to Metal Primer/Finish or as a topcoat on various primers for highly corrosive environments on mild steel, stainless steel, aluminium, galvanized iron and other metals.

Used as a finish coat for exterior of tanks, equipment, structural steel, concrete or any surface where weathering, chemical resistance, toughness and UV stability are required.

PU DTM Flexi HB is excellent for the refurbishment of metal roof sheeting of industrial warehouses, processing facilities etc.

Perfect replacement of traditional two or three coat systems as a one coat system for protection of steel up to a C4-L environment.

Other applications include but are not limited to:

- Steel Roofs
- Processing equipment, pumps, valves etc.
- floors & Demarcation (can also be made non-slip)
- Automotive truck and trailer
- Agricultural and earth moving equipment
- power generation equipment

The polyester backbone of the PU DTM Flexi HB gives excellent chemical resistance against industrial fallout, superior scratch/mechanical resistance and flexibility against direct and reverse impact.

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**CHARACTERISTICS**

- Stress & Impact resistant
  - High build
  - Tough and durable with excellent scratch resistance
  - Anti-corrosive properties
  - Excellent colour and gloss retention
  - Excellent obliteration/coverage
  - Non-chalking & non-yellowing
  - Excellent flexibility and durability
  - Resistant to mild chemicals, salt water, mineral and vegetable oils, paraffin's, aliphatic solvent, dilute industrial chemicals & aqueous solutions
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**PRODUCT INFORMATION**

<b>Colour</b>	Full Tintometric System (+15,000 colours) Aluminium
<b>Finish</b>	High Gloss
<b>Density</b>	1.10 kg/litre
<b>Volume Solids</b>	60% ± 3%
<b>Mix Ratio (volume)</b>	4 : 1 (A:B)
<b>Typical Film Thickness</b>	60-80 microns dry per coat (100-140 WFT per coat)
<b>Theoretical Coverage</b>	7.5 m <sup>2</sup> /litre at 80 microns dft, allow loss factors
<b>Method of Application</b>	Airless Spray, Brush, Conventional Spray, Roller
<b>Activator</b>	PU Activator 75
<b>Solvent</b>	Solvent XL

<b>Drying Information</b>	0°C	5°C	10°C	25°C	40°C	
Touch Dry	-	6 hrs	3 hrs	1.5 hrs	1 hr	-
Hard Dry	-	16 hrs	8 hrs	4 hrs	2 hrs	-
<b>Overcoating Data – See Limitations</b>						
Substrate Temp.	0°C	5°C	10°C	25°C	40°C	
Minimum	-	12 hrs	6 hrs	3 hrs	1.5 hrs	
Maximum	Extended					
Cure Time	-	15 d	10 d	7 d	4 d	

**Note** Drying and overcoating times quoted are measured at 50 microns DFT, at higher film thickness times will be increased.  
\*See Limitations

**CERTIFICATIONS**

Consult Speccoats™ Technical Representative for details

**SYSTEMS AND COMPATIBILITY**

PU DTM Flexi HB can be applied direct to correctly prepared metal.

It can be applied over a recommended priming system for added performance properties. Consult Speccoats™ Technical Representative for coating system solutions.

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**SURFACE PREPARATION**

The performance of this product will depend upon the degree of surface preparation. The surface to be coated must be cleaned and free from contamination. Prior to paint application all surface should be assessed and treated in accordance with ISO 8504:2000.

Accumulated dirt and soluble salts must be removed. Dry bristle brushing will normally be adequate for accumulated dirt. Soluble salts should be removed by fresh water rinsing. Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

**Mild Steel**

Product should be applied to surfaces prepared by abrasive blast cleaning to SA 2½ in accordance with International Standard ISO 8501:2007 and SSPC-SP6.

Or

Hand / Power tool clean to a minimum of St2 (ISO 8501-1:2007) or SSPC-SP2

**Primed Surfaces**

PU DTM Flexi HB should always be applied over a suitable priming/anti-corrosive system. The primed substrate should be dry and free from any contamination and PU DTM Flexi HB must be applied within the coating intervals specified in the relevant product data sheet.

Damaged or broken down areas where the substrate has been exposed must be prepared to the specified standard (e.g. SSPC-SP6 or Sa2½ (ISO 8501-1:2007), Abrasive blasting, or SSPC-SP11, Power Tool Cleaning) and primed prior to the application of PU DTM Flexi HB

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**APPLICATION**

**Mixing**

Material is supplied in two containers as a kit. Always mix a complete kit in the quantities supplied. Once mixed the product should be used within the pot life specified

Stir the base component well with a flat-bottomed paddle or mechanical mixer until product is uniform. Continue stirring and add the entire contents of the activator container. Continue stirring until the mixture is homogeneous.

Ensure that sufficient material be mixed so that the product can be applied within its use-able life

The temperature of the mixed product should preferably be above 10°C, otherwise extra solvent may be required to obtain application viscosity.

Too much solvent results in reduced sag resistance and slower cure

Thinner should be added after mixing both component's

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<b>Mix Ratio</b>	4 part(s) base : 1 Part(s) PU Activator 75 by volume		
<b>Pot Life</b>	2 hours at 20°C		
<b>Airless Spray</b>	Recommended	Tip range 11-17 Thou. Pressure at the tip should not be less than 140 bar (2000 PSI)	
<b>Air Spray (Pressure Pot)</b>	Recommended	Gun Fluid Tip	Pressure Feed 1.1 mm to 1.6 mm
<b>Air Spray (Conventional)</b>	Suitable	Gun Fluid Tip	Gravity Feed 1.1 mm to 1.6 mm
<b>Brush</b>	Suitable	Typically 40-50 microns can be achieved	
<b>Roller</b>	Suitable	Typically 40-50 microns can be achieved	
<b>Thinner</b>	Solvent XL	0-20% Depending on application method	
<b>Cleaner</b>	SA65 Thinner	For dry paint and equipment	
<b>Work Stoppage</b>	Do not allow material to remain in spray equipment after use, thoroughly flush and clean all equipment with SA65 Thinner. Once the kit has been mixed they should not be re-sealed and it is advised that of prolonged stoppages, work recommences with freshly mixed units		
<b>Clean Up</b>	Clean all equipment immediately after use with SA65 Thinner. It is advisable to periodically flush out spraying equipment during the course of the working day. Frequency of cleaning is dependant of upon the amount sprayed, temperature and elapsed time. Work strictly in accordance with the specified pot life of the material.		
<b>Environment</b>		Surface Temperature	Ambient Temperature
	Minimum	5°C*	10°C
	Maximum	40°C	45°C
			Relative Humidity
			No lower limit 85%
	*Or 3°C above the dew point		

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**LIMITATIONS**

- This product is not suitable for immersion conditions
  - For brush and roller application, two coats may be required to give uniform coverage especially when applying PU DTM Flexi HB over dark colours. The best practice is to choose a primer or intermediate coat with a compatible colour.
  - Low temperature, high relative humidity and condensation occurring during or immediately after application may result in a matt finish and inferior film.
  - Premature exposure to water will cause colour change, especially in dark colours and at low temperatures.
  - Overcoating information is given for guidance only and is subject to local climate and environmental conditions. Consult a Speccoats™ representative for specific recommendations
  - Apply in good weather. Temperature of the surface to be coated must be at least 3°C above the dew point. For best results bring the material temperature between 20-30°C, unless specifically instructed otherwise, prior to mixing with and application.
  - Unmixed material (in closed containers) should be maintained in protected storage in accordance with information given in the STORAGE section of this data sheet.
  - Technical and application data herein is for the purpose of establishing a general guideline of the coating application procedures.
  - Test performance results were obtained in a controlled laboratory environment and Speccoats™ makes no claim that the exhibited published test results, or any other tests, accurately represent results found in all field environments. As application, environmental and design factors can vary, due care should be exercised in the selection and verification of the performance and use of the coating
  - Overcoating aged finishes/topcoats; although no maximum overcoating time is given in the data sheet, certain precautions must be taken prior to overcoating. Slight chalking will have occurred due to UV exposure and the surface will have been exposed to pollutants in the atmosphere. These surface contaminants must first be removed by washing with Hydrosolve and light abrasion using Scotchbrite pads followed by rinsing with drinking quality water.
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**UNIT SIZE**

Kit Size	Part A		Part B	
	Volume	Pack	Volume	Pack
<b>5 lt</b>	4.00 lt	5 lt	1.0 lt	1 lt
<b>20 lt</b>	16.00 lt	20 lt	4.0 lt	5 lt

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**STORAGE**

<b>Shelf Life</b>	Part A	24 months minimum at 25°C
	Part B	12 months minimum at 25°C

Subject to inspection thereafter. Store in dry conditions out of direct sunlight away from source of heat or ignition

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**IMPORTANT NOTE**

Whilst we endeavour to ensure that all advice we give about the product is correct, the information given in this data sheet is not intended to be exhaustive and any person using the product for any purpose other than that specifically recommended in this sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so entirely at his own risk. As conditions of use, method of application and suitability of the substrate prior to painting are beyond our control, no guarantee is implied by the recommendations contained herein. We therefore do not accept any liability whatsoever or howsoever arising from the performance of this product or for any loss or damage arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and ongoing product development programmes. It is the user's responsibility to ensure that this sheet is current prior to using the product

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**PRECAUTIONS**

For complete safety and handling information please refer to the appropriate **Safety Data Sheets** prior to using this product.

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