

OROMEL 614

POLYURETHANE ENAMEL

Mix 4:1 by volume with **OROCAT 714**

Two pack aliphatic polyurethane enamel, glossy finish and high outdoor resistance. Forms a hard and waterproof film, resistant to oils, salts and gasoline. Specially formulated for painting and decorating various properly primed metal substrates, plastic and concrete. Ideal as a top coat for epoxy-polyurethane systems.

Physical parameters	Base OROMEL 614	Catalyst OROCAT 714
Viscosity (Ford cup #4)	90 – 240" (depending on the colour)	11 – 15"
Specific gravity	0,95 – 1,30 g/cc (depending on the colour)	0,96 – 1.00 g/cc
Solids content	50 – 65% (depending on the colour)	40 – 45%
In-can appearance	Viscous liquid	Slightly viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	4:1 by volume (OROMEL 614:OROCAT 714)
Viscosity of the mixture	-"
Specific gravity of the mixture	0,95 – 1,20 g/cc (depending on the colour)
Solids content	50 – 60%
Colour	White and tinting bases (white base P and clear base TR)
Dry film appearance	Glossy finish with good adhesion and resistance
Spreading rate	9 – 11 m ² / L (90 – 130 g/m ²)
Gloss	>90%
Adhesion	100% (Max: GT0)
Pot life of mixture	3 – 4 hours
VOC	<500 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L

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Product use information

Surface	Iron, Steel, Concrete, Polyester
Surface preparation	Iron and steel surfaces must be clean, dry, without grease or rust. In the case of concrete surfaces, these must be clean, dry and unpolished. Finally, polyester has to be sanded and degreased
Product preparation	Stir thoroughly the contents of the container with a spatula. Make the mixture (by volume) 4 parts of OROMEL 614 (Base) to 1 part of OROCAT 714 (Catalyst). Do not let the OROCAT 714 come into direct contact with moisture.
Application method	Brush, Pneumatic spray
Dilution	Dilute up to 15% with ORODIS 720. Homogenize the mixture. Do not use other solvents.
Application	Apply 1 – 2 coats of 40 – 50 µm dry film thickness
Drying	Touch drying time: 1 – 2 hours Forced drying time: 10–15 min. at T _{room} and 20–30 min. at T = 70–80°C Drying time is very influenced by the dry film weight, type and state of the substrate and weather conditions.
Recoatable	12 – 24 hours
Cleaning	ORODIS 720

Application process

	Primer	Top coat
Iron, steel	OROPRIMER 485	OROMEL 614
Polyester	OROPRIMER 446	OROMEL 614
Concrete	OROLUR 388	OROMEL 614

Additional information

Safety	Consult package labelling. For further information, ask for the Material Safety Data Sheet
Storage	1 year

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