HPC/Industrial Maintenance

PITHANE® ULTRA Gloss Urethane Enamels

These products are designed to be tinted with PERFORMACOLOR® colorants. Use formulas from the PITHANE Ultra section of the formula book or from the PERFORMACOLOR Software. Do not tint with 96 line custom colorants.

- 95-8000 Neutral Base
- 95-8001 White Base
- 95-8002 Yellow Base
- 95-8003 Red Base
- 95-801 Safety Red
- 95-802 Safety Yellow
- 95-805 Safety Orange
- 95-812 Porcelain White
- 95-814 Black
- 95-819 Component B Catalyst

**Product Data**

<table>
<thead>
<tr>
<th>Gloss:</th>
<th>+70 (20° Gloss Meter)</th>
</tr>
</thead>
<tbody>
<tr>
<td>VOC*:</td>
<td>2.01 lbs/gal 241.00 g/L</td>
</tr>
<tr>
<td>Coverage:</td>
<td>376 to 565 sq ft/gal (35 to 52 sq. m/3.78L)</td>
</tr>
</tbody>
</table>

*Note: Does not include loss due to varying application method, surface porosity, or mixing.

- DFT: 2.0 minimum to 3.0 maximum
- Weight/Gallon*: 11.6 lbs. (5.3 kg) +/- 0.3 lbs. (136 g)
- Volume Solids*: 70.4% +/- 2%
- Weight Solids*: 82.7% +/- 2%
- Mix Ratio: 5 parts Component A to 1 part Component B
- Clean-up: 97-727, 97-730, 97-734, 97-735, 97-736, 97-739
- PPG Thinners

Results will vary by color, thinning and other additives.

*Product data calculated on mixed 95-812

**Drying Time:**

- To Touch: 2 hours
- To Handle: 4.5 hours
- To Reccoat: 4.5 hours
- Accelerated Potlife: 1 hour
- Accelerated Handle: 30 minutes
- Accelerated Reccoat: 30 minutes

**Dry Time @77°F (25°C): 50% relative humidity**

<table>
<thead>
<tr>
<th>Pot Life:</th>
<th>3 hours</th>
</tr>
</thead>
<tbody>
<tr>
<td>Induction Time:</td>
<td>None</td>
</tr>
<tr>
<td>In Service Temperature:</td>
<td></td>
</tr>
<tr>
<td>Dry Heat (F):</td>
<td>350°</td>
</tr>
<tr>
<td>Dry Heat (C):</td>
<td>177°</td>
</tr>
</tbody>
</table>

**Flash Point:**

- 95-812 84°F, (28.9°C)
- 95-819 331°F, (166°C)
General Surface Preparation

The surface to be coated must be dimensionally stable, dry, clean, and free of oil, grease, release agents, curing compounds, and other foreign materials. Where appropriate bare areas should be primed with a suitable primer. Job conditions may dictate the choice of an alternate primer. Consult PPG HD systems or your PPG Sales Representative if this is the case. WARNING! If you scrape, sand, or remove old paint, you may release lead dust or fumes. LEAD IS TOXIC. EXPOSURE TO LEAD DUST OR FUMES CAN CAUSE SERIOUS ILLNESS, SUCH AS BRAIN DAMAGE, ESPECIALLY IN CHILDREN. PREGNANT WOMEN SHOULD ALSO AVOID EXPOSURE. Wear a properly fitted NIOSH-approved respirator and prevent skin contact to control lead exposure. Clean up carefully with a HEPA vacuum and a wet mop. Before you start, find out how to protect yourself and your family by contacting the USEPA National Lead Information Hotline at 1-800-424-LEAD or log on to www.epa.gov/lead. In Canada contact a regional Health Canada office. Follow these instructions to control exposure to other hazardous substances that may be released during surface preparation.

PREVIOUSLY PAINTED SURFACES: Old coatings should be tested for adhesion of the existing system and lifting by the proposed topcoat. COATING SYSTEMS: 241-HD, 242-HD, 243-HD, 245-HD, 246-HD, 247-HD, 248-HD, 249-HD.

Recommended Primers

<table>
<thead>
<tr>
<th>Substrate</th>
<th>97-145, 97-946</th>
<th>97-145, 97-946</th>
<th>97-680, 97-145, 97-946</th>
<th>97-687</th>
<th>See Surface Prep Section</th>
</tr>
</thead>
<tbody>
<tr>
<td>Galvanized Steel</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>Refer to HD Coating Systems.</td>
</tr>
<tr>
<td>Concrete, Smooth Masonry</td>
<td>97-145, 97-946</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Ferrous Metal</td>
<td>97-680, 97-145, 97-946</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Aluminum</td>
<td>97-687</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

Directions for Use

Mix Component "A" thoroughly before blending. (If 97-722 Accelerator is used, add it to the "A" Component and mix well prior to the addition of the "B" Component. Add up to 6 oz. of 97-722 per mixed gallon). Add Component "B" to Component "A" and mix well. A mechanical mixer is recommended. Explosion-proof equipment must be used when coating with these materials in confined areas. Keep containers closed and away from heat, sparks, and flames when not in use. USE ADEQUATE VENTILATION. KEEP OUT OF REACH OF CHILDREN. Read all label and Material Safety Data Sheet (MSDS) information prior to use. MSDS are available through our website or by calling 1-800-441-9695.

Permissible temperatures during application:

- Material: 60 to 90°F (16 to 32°C)
- Ambient: 40 to 100°F (4 to 38°C)
- Substrate: 40 to 140°F (4 to 60°C)

Application Information

Recommended Spread Rates:

<table>
<thead>
<tr>
<th>Material Type</th>
<th>Wet Mils</th>
<th>Min to Max</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet Microns</td>
<td>2.8</td>
<td>4.3</td>
</tr>
<tr>
<td>Dry Mils</td>
<td>2.0</td>
<td>3.0</td>
</tr>
<tr>
<td>Dry Microns</td>
<td>50.8</td>
<td>76.2</td>
</tr>
</tbody>
</table>

Application Equipment: Changes in application equipment, pressures and/or tip sizes may be required depending on ambient temperature and application conditions. Spray equipment must be handled with due care and in accordance with manufacturer's recommendation. High-pressure injection of coatings into the skin by airless equipment may cause serious injury.

Conventional Spray: Fluid Nozzle: DeVilbiss MBC gun, with 777 or 78 air cap with E or F tip and needle, or comparable equipment. Atomization Pressure: 55 - 70 Fluid Pressure: (Can not specify, dependent on numerous factors)

Airless Spray: Pressure 1800 psi, tip 0.013" - 0.015"

Brush: High Quality Natural Bristle Brush

Roller: 3/8" nap solvent resistant core

Thinning:

For a 2.8 lb/gal (340 g/L) VOC, do not exceed 15% thinning. Use 97-739 to obtain a 2.08 (250 g/L) VOC. Use 97-739 for normal application, 97-735 thinner can be added for normal brush, roll, or spray application. Use 97-736 for a faster solvent. 97-735 and 97-736 increase the conductivity of the mixed paint. May use 97-730 or 97-727 for spray, 97-734 for brush or roller.

Packaging: 1-Gallon (3.78L) 5-Gallon (18.9L) Quart (946 mL) Not all products are available in all sizes. All containers are not full-filled.