

## 1 PACK POLYURETHANE

### INTENDED USE

#### VEHICLE REFINISH - and the ORIGINAL COATING of VEHICLES or TRAILERS

An air drying, high build, high gloss finish with longer drying and wet edge times compared to 1 Pack Polyurethane QD, and with less tendency for 'dry or over spray'. Excellent for application by brush.

Often used for spraying large commercial vehicles when a long wet edge or open time is beneficial, particularly if sprayshop temperatures rise above 25C.

VOC classification is 2004/42/IIB(d)(420)(420)

**ARTICLES - that are not part of a building structure** (and are therefore outside the scope of the building products VOC Product Directive)

Used as a refurbishment or maintenance coating for items such as :

**INSIDE BUILDINGS** Machinery, fixed plant, movable equipment, fork lift trucks, trolleys, frames, guards etc Chosen for its high gloss, hard wearing, and resistance to most common cutting oils and some mild chemicals.

**OUTSIDE BUILDINGS** Tanks, pipework, process plant, towers, bridges, or any structure which is not part of a building

#### METAL FINISHING

Only occasionally used in this sector, when application would normally be by brush on items that cannot easily be sprayed.

**Niche end uses** are for Narrow Boats, externally above the water line, classic vehicles, tractors, traction engines, coaches, buses, trucks, and steam engines.

See also the Manor supplementary information sheet 'Guide to the UK VOC legislation' to understand how the VOC content of a coating determines its suitability for use in any application

### SUITABLE SUBSTRATES AND PREPARATION

Surfaces must be dry, sound and free from dirt, dust, oil and grease. For spray application prime / undercoat with Manor UPF, and for brush application prime / undercoat with Manor CV Primer Undercoat. Previously painted glossy surfaces should be lightly abraded prior to application to promote adhesion. Any non-ferrous metals should first be pre-treated with Manor Wash Primer or Manor 1 Pack Etch Primer CT. Previously painted glossy surfaces should be abraded prior to prime / undercoating, in order to gain adhesion.

### AVAILABILITY

5 litres, available in an extensive range of colours from the MANORMIX mixing scheme.

### PRODUCT INFORMATION (TYPICAL FIGURES)

**Composition** Based on a medium oil urethane modified alkyd resin and pigments specially selected for their light fastness and exterior durability.

**Volume Solids** 48%

**Weight Solids** 56 - 65%

**VOC content** 395 - 420 gm/litre

**Typical film thickness** 40 microns dry and 80 microns wet

**Theoretical Coverage** 12.5 sq. metres/litre at 40 microns dft

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**Dry heat resistance** 80°C

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**Flash Point** HIGH FLASH within the range 32 – 55°C

**APPLICATION DETAILS**

**PREFERABLY BRING PAINT TO 15-25°C AND STIR WELL BEFORE USE.**

**Airless spray** Ready for use for vehicle chassis, for METAL FINISHING or ACE up to 5% thinners may be added to suit equipment, for ACE, hot airless spray is often used.  
**(hot or cold)** Typical tip size 11-13 thou. or 0.27-0.33 mm.  
Typical fluid pressure 140 kg/sq. metre or 2000 p.s.i.

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**Conventional spray** **To comply with the EU Vehicle Refinish VOC regulations** the paint must be applied without thinners, using a pressure pot, or hot spray at 60-80°C.

For METAL FINISHING or ACE , up to 15% thinners may be used

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**Brush** Ready for use – but up to 3% of Low Odour White Spirit can be added to suit application conditions.

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**Thinner** Synthetic Thinner CV or Low Odour White Spirit

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**Film thickness per coat**

	Dry	Wet
<b>Minimum</b>	30 microns	60 microns
<b>Maximum</b>	50 microns	100 microns

**DRYING AND RECOATING**

**Approximate drying times at 40 microns d.f.t.**

Substrate temperature	Touch dry	Overcoating times	
		Minimum	Maximum
10°C	6 hours	24 hours	7 Days
20°C	3 hours	16 hours	(see note)

**Environmental Conditions** The air temperature should be at least 5°C with the surface temperature 3°C above the dew point and the relative humidity below 90%. The drying times will be significantly extended in cold, damp conditions.

**Overcoating/Repainting** Usually applied wet on wet.  
If left for more than 3 days between coats, it is important to lightly abrade the coating to provide good intercoat adhesion. To repair runs and sags allow the first coat to dry such that the film can be lightly abraded to remove the defect, then leave the flatted surface to “heal up” overnight before re-coating .

**SHELF LIFE**

Store in cool, dry conditions, typically 5-25°C. After a period of storage the product should be thoroughly stirred. Usable life is 2 years from date of manufacture in unopened containers.

**SAFETY PRECAUTIONS**

REFER TO THE MANOR SAFETY DATA SHEET

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**Reference No. SP1PP-7 ISSUED 03/2010**  
THIS DATA SHEET SUPERCEDES ALL PREVIOUS ISSUES