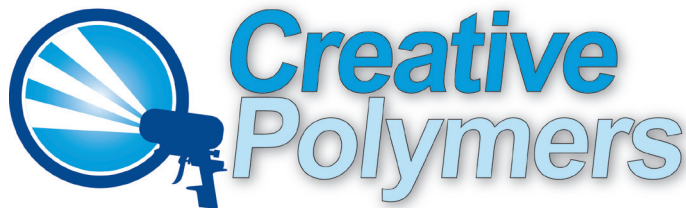


PLASTI-THANE 3600

PROTECTIVE FOAM HARDCOAT



DESCRIPTION

PLASTI-THANE 3600 is a two component, fast cure 100% solids aromatic polyurethane structural system. It is designed primarily as a “Hardcoat” for EPS and PUF foams. The system has been specifically designed to have a balance of flow out and gel time in order to produce a smooth surface. This product must be applied with heated plural component spray equipment.

TYPICAL USES & APPLICATIONS

Used as one multi-coat application to resist impact damage for Expanded Polystyrenes (EPS), Styrofoam, wood, urethane foam and phenolic foam board stock. Protect enhances aesthetic appeal for various surfaces and can be top-coated with other CP products. • As a “Hardcoat for EPS and PU foams.

- Can be sprayed in molds to produce various textures.
- As a coating for wood

ADVANTAGES

- 100% Solids,, meets VOC regulations
- 1:1 Mix ratio
- Fast cure and cycle times increase production
- Seamless elastomer
- Outstanding waterproofing properties
- Thermal shock resistant for freeze/thaw cycles
- Cures at lower temperatures
- Excellent impact resistance
- Low permanence rate
- Chemical resistant to many petroleum products (gasoline, oil, solvents)
- Durability prolongs substrate life

PACKAGING

Container Sizes	10 & 100 Gallon Kits
Shipping Weights	11 lb/gal (5 kg/gal)

SURFACE PREPARATION

Surface must be clean of all oil, grease or other contaminants.

PRIMERS & TOP COATS

This product may use primers or be top-coated. Please consult us for details.

PHYSICAL DATA

Properties	Specifications
Solids By Volume	100%
Theoretical Coverage	1604 mil ft ² /gal
Volatile Organic Compounds	0 lbs / gal (0 gm/L)
Thinned	N/A
Recommended DFT	30-125 mils
Number of Coats	1 or more
Mix Ratio	1 “A” to 1 “B”
Shelf Life	12 months
Color	Neutral, Colors Available
Flash Point - PMCC	>300° F (148° C)
Viscosity- LV4/60 RPM	
Component A	900
Component B	700

SPECIFICATION DATA

Tensile Strength [ASTM D 412]	2500 psi
Elongation [ASTM D 412]	50-60 %
Hardness [ASTM D 2240]	Shore D 65
Density [ASTM D 790]	60-65 pcf

POT LIFE

Pot life is less than 5 seconds. Plural mix equipment only.

MIXING

“A” compound does not require mixing, “B” compound should be mixed daily or every 8 hours.

APPLICATION INFORMATION

	Material	Surface	Ambient
Minimum	135 ° F	40 ° F	40 ° F
Maximum	170 ° F	120 ° F	120 ° F

APPLICATION PARAMETERS

PLASTI-THANE 3600 must be sprayed using (1:1 by Volume), heated, high pressure, plural component air-less equipment only. Material should be maintained at 75-85 F prior to application. When ready to spray this material, the proportioning unit must be capable of supplying the correct pressure and heat which is mandatory in order to apply the product in a consistent, efficient manner. Pressures of 2,500-3,000 psi with heated hose that can maintain material temperature of 135-150 F at the gun tip. Proportioner heaters and drum heaters are required that can assist in maintaining the temperatures. Use 2:1 transfer pumps or greater for material supply to the equipment.

MOLD TEMPERATURES

In order to achieve proper curing, mold temperatures, should be between 75-130 F. Parts not preheated to these temperatures will affect the final properties and results. Finished parts will reach full cure after 24 hours. Heating parts several hours after de-molding will enhance the strength of the part and quicken the full cure rate.

DE-MOLDING TIME

Most parts can be demolded in 5-20 minutes depending on the size and weight of the piece. Larger and shape critical parts may need to be supported or jiggged to prevent initial warping during the curing process. Always permit the parts to cool naturally.

CLEAN UP/DISPOSAL

Each day the drums of material should be resealed with a blanket of inert gas and all gun parts and equipment properly cleaned and lubricated. The un-cured isocyanate and resin portions should be disposed of according to local, state, and federal laws.

STORAGE

Materials should be stored in a dry, enclosed environment. Urethane coatings must be protected from moisture contamination. Store containers in a dry location at 60-90 F. Unused material must be kept sealed with a positive feed of dry air, nitrogen blanket or desiccant cartridge.

SAFETY & HANDLING

MSDS will be mailed with order. All personnel should read and understand the safety recommendations. All application personnel must use fresh air respirators or fresh air hoods. Protective clothing is recommended including gloves and eye protection. Make sure that adequate air exchange and ventilation is available in enclosed areas. Fumes or skin contact may cause severe allergic reaction. This product is for industrial use by trained professional applicators and should be kept away from children at all times.

DISCLAIMER

Please read all information in the general guidelines, product data sheets, guide specifications and material safety data sheets before applying material. Published technical data and instructions are subject to change without notice. Contact a Creative Polymers representative or visit our website for current technical data and instructions.

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