

## “APM” PU-630 SF-74 CLEAR MATT

SOFT-TOUCH PLASTIC COATING

### Product Description

2-component elastic polyester coating with soft-feel finish for plastic substrates

### Recommended Use

ABS and Polycarbonate

### Design Features

Velvety, rubber-like touch  
High abrasion and scratch resistance  
High chemical resistance  
Excellent adhesion

### Physical Characteristics

Theoretical Coverage	8 – 10 m <sup>2</sup> /kg	
Dry Film Thickness Range	25 ~ 30 μ , Max 60 μ	
Specific Gravity	1.01 ± 0.02	
Finish	Matt	
Color	Clear	
Standard Packing Size	Base : 4 Kg	Hardener : 1 Kg

### Application Method

Air Spray	Recommended method of application. Apply single coat with 4 – 5 passes		
Mixing Ratio (by weight)	Base	Hardener	Thinner
	SF-74 Clear Matt	PU-630 SF	#650
	100	40	40
	Spray viscosity Iwata NK#2 cup at 10~12 seconds		
Settings	Tip Size	1.2 – 1.5 mm	
	Pressure	4.0 – 5.0 kg/cm <sup>2</sup>	

### Drying Time (Oven-dry)

Temperature	Duration	Flash Off Interval	
60 °C	≥ 45 minutes	Minimum	Maximum
80 °C	≥30 minutes	5 minutes	8 hours



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## Useful Information

Thinner	Thinner #650
Storage	Temperature must not fall below +5°C or exceed +25°C during storage and transport. Keep hardener tightly lidded to protect against moisture
Pot Life	3 hours at 25°C and 2 hours at 30°C
Shelf Life	1 year from date of production in unopened, original container
Disposal	Always keep container in a secure upright position. Use sand to contain any spillage. Dispose of paint in accordance with the appropriate Environmental Quality Regulations.

## Surface Preparation

The service and life span and the service performance of paints are directly related to the degree of surface preparation.  
To prevent condensation of moisture onto substrate prior to coating application, relative humidity should not exceed 85% and substrate temperature should be more than 3°C above Dew Point.  
Dust, oil or mold release agent on the substrate must be removed before coating. Use IPA for the purpose.

## Coating Specifications

Substrate	1 <sup>st</sup> Coat
ABS and Polycarbonate	APM PU-630 SF74 Clear Matt

## Notes

The coating specifications provided above are typical. For specific recommendations to suit individual applications, please refer to your Asia Paint Representative.  
Mix thoroughly for paint, hardener and thinner with a proper mixing device. Do not use any thinner other than specified.  
Ambient temperature air dry curing is not recommended for this product.  
Force cure using oven within 8 hours of application. Prolonged exposure to air prior to curing may adversely affect adhesion strength on substrate.

## Safety Precaution

Avoid contact with eyes and skin. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves.  
Do not use in poorly ventilated areas, do not breathe in vapour or spray mist.  
In case of fire, use normal foam or dry agent.

## First Aid

Eyes	Wash off in flowing water or shower.
Skin	Flush with plenty of water.
Inhalation	Remove to fresh air, loosen collar, keep patient rested.
Ingestion	If swallowed, seek medical attention. Do not induce vomiting unless directed to do so by medical personnel.

For further safety information, please refer to our **Safety Data Sheet (SDS)**



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## Disclaimer

The information provided on this data sheet is not intended to be complete and is provided as general advise only. It is the responsibility of the user to ensure that the product is suitable for the purpose for which he wishes to use it. As we have no control over the treatment of the product, the standard of surface preparation of the substrate, or other factors affecting the use of this product, we are not responsible for its performance, nor would we accept any liability whatsoever or howsoever arising from the use of this product unless specifically agreed to in writing by us. The information contained in this data sheet may be modified by us from time to time, and without notice, in light of our experience and product development.

## Performance Properties of APM PU600 SF74 Matt Clear on ABS and PC

	Test Item	Result	Test Method
1	Adhesion (Cross-cut tape)	100/100	1mm grid cross-cut tape test
2	Cross-cut and eraser rub	100/100	10 times
3	Hardness	2H	Pencil scratch, no exposure of substrate
4	Humidity Resistance Appearance after test Adhesion after test	Not affected 100/100	40°C at 95% RH for 240 hours
5	Alcohol Resistance	Not Affected 100/100	95% ethanol, rubbing 50 times
6	Heat Cycle Resistance	Not affected 100/100	60°C X 3 hours followed by -20°C X 3 hours. Perform test for 10 cycles