

## 9640-Line DURATHANE FPX

GLOSS HIGH SOLIDS POLYURETHANE - LOW HAPS

9640 Line is a premium quality aliphatic polyurethane formulated to provide strong mechanical properties and is enhanced with fluoropolymer for extended weathering durability and exceptional colour retention.

### SPECIFICATION

**CMS-CT-101**

### OUTSTANDING CHARACTERISTICS

- Extended exterior durability
- Excellent flexibility
- Superior solvent and chemical resistance
- Low HAPS & V.O.C.

### PHYSICAL DATA

Finish:	Gloss
Colour:	Fed. Std. #17925
Weight Solids:	79.0 mixed
Volume Solids:	65.6 mixed
V.O.C.	≤420 g/l
Density:	N/A

### RECOMMENDED PRIMERS

- 4500-P-215Y MIL-PRF-23377 Ty. I, CI C2
- MIL-PRF-23377 Ty II, CL C2

Note: all physical and chemical resistance tests conducted after 7 or 14 day cure time at 20-25°C (70-75°F) on properly cleaned substrate.



### SURFACE PREPARATION

Pretreat with conversion coating MIL-DTL-5541, Class 1A, or anodize per MIL-A-8625



### INSTRUCTIONS FOR USE

Components:	Two
Activator:	9640-C-1
Mix Ratio:	1:1 by volume, Base / Activator
Induction Time:	N/A
Pot Life:	4 hours @ 25°C (75°F)
Reducer:	9600-S-1 or 4600-S-72 (MIL-T-81772 Ty I)



### MIXING INSTRUCTIONS

Mix 1:1 by volume Base/Activator thoroughly. Mix only sufficient material to use within the specified pot life. Always add reducer to the mixed product (base + activator), never the opposite.



### SPRAYING VISCOSITY

Recommended spray viscosity 20 - 26 seconds #4 Ford Cup  
Reduce with 9600-S-1



### APPLICATION METHOD

Allow for application loss and surface irregularities.  
Application: Conventional air spray, HLVP or air assisted airless are recommended for best atomization.

## RESISTANCE TABLE

<b>Impact Resistance</b>	No flaking or cracking when subjected to 80 inch pounds Impact direct and 80 inch pounds reverse.
<b>GE Impact</b>	40% Elongation
<b>Flexibility (half inch mandrel)</b>	Pass, no cracks (180°)
<b>Low Temperature Flexibility</b>	No cracking or adhesion loss 4" mandrel
<b>Low Temperature Shock</b>	No cracking or adhesion loss 4" mandrel
<b>Hardness</b>	Pencil Hardness H minimum
<b>Fuel Resistance (Immersion)</b>	<ul style="list-style-type: none"> <li>• 30 Days Skydrol</li> <li>• Mil-PRF-7808 14 Days</li> <li>• Mil-PRF-5606 14 Days</li> <li>• Reference Fuel B 14 Days</li> <li>• Water 7 Days</li> </ul>
<b>Salt Spray Resistance</b>	Aluminum > 3000 Hrs ASTM B117 over primer and properly prepared substrates
<b>Filiform</b>	Aluminum 1 Hour, 12N HCl, 30 Days Humidity
<b>Rain Erosion</b>	385 mph, 30 min
<b>Weathering (ASTM G155)</b>	3,000 hours Xenon Arc



## EQUIPMENT

Using a Binks Mach I HVLP with a 93P or 92AP air cap and a #92 Fluid tip, inlet pressure should be approximately 70-80 PSI (9 PSI at air cap) and 10-12 PSI on pressure pot. Devilbiss JJ502 conventional spray gun uses a 765-air cap and a .0425 needle nozzle with 45-55 PSI gun pressure and 10-12 on pressure pot.



## RECOMMENDED FILM BUILD THICKNESS & COVER RATE

Total Dry Film Recommendation 2.0 - 3.0 mils  
Calculated Coverage at:  
1.0 Mils: 1,053 sq.ft./US gallon  
25 Microns: 25.8 m<sup>2</sup> /litre



## ENVIRONMENTAL CONDITIONS

Temperature: 15-35°C (59-95°F)  
Relative Humidity: 20-75%  
Note: Substrate and air temperature must be a minimum of 3°C (5°F) above the Dew Point



## DRY TIME

Dry time at 25°C (75°F), 50% relative humidity May be force dried at 140-160° for 20-30 minutes.  
Tack Free: 4 hours  
Dry Through: 6-8 hours max



## CLEAN UP

Cleaner: 20-4301, S-10 or S-1



## STORAGE & SHIPPING

Flash Point: Refer to MSDS  
Shelf Life: 12 months unmix



## SAFETY PRECAUTIONS

Please refer to the Material Safety Data Sheet (MSDS) for information regarding health, physical and environmental hazards, handling precautions and recommended first aid procedures. For industrial and automotive use only.