

# SIPTHANE 360

Aliphatic Urethane Gloss Enamel

Product No. 6360

Product No. 6366

Product No. 6367

## Features

- High Gloss and Gloss Retention.
- Outstanding Colour Retention.
- Durable Film
- Excellent aged recoatability when cleaned with SIPCLEAN 615.
- Approved under APCS-1D, 1E, 1F & 26T.

## Recommended Use

- Transportation industry, chemical processing industry, pulp and paper industry, bridges, storage tanks, fishing fleets, passenger vessels and support vessels.
- Recommended for Steel, Aluminium, Masonry or Fibreglass when Properly Primed.

## Physical Data

**Finish** : High Gloss (6360)  
Also available in Leafing  
Aluminium (Ral 9006)  
Semi Gloss (6366)  
Matt (6367)

**Colours** : Various

**Volume Solids** : 56% (For Std. Colours)  
45% (for Alum. Ral 9006)

**Recommended Film Thickness:**

30 - 75 microns dry = 54 - 134 microns wet

**Theoretical Coverage:**

18.7 m<sup>2</sup>/ltr. at 30 microns

**Density (mixed)** : 1.3 kg/ltr.

**Drying Times :**

25°C / 65% RH  
Dry to Recoat : 04 Hours  
Hard Dry : 08 Hours  
Maximum Recoating time : 04 Weeks

**Heat Resistant** : 121°C dry

**Flash Point** : 38°C

## Specification Data

**Preparation**

All surfaces to be coated must be free of grease, dust, dry spray, moisture and other foreign matter and be properly primed with a compatible epoxy primer. To ensure the best appearance, the primer or undercoat should be smooth and free of any surface defects such as runs, dry spray or heavy orange peel.

Suitable primers/intermediate coats for steel, aluminium and masonry surfaces are SIPRIME 215/210 and SIPOXY-SHIELD 240, 275, 285, 655 or equivalent. For self recoating aged SIPTHANE 360 Enamel, use SIPCLEAN 615 Cleaner.

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## Application Data

### Mixing Ratio by Volume

Base : 6 parts  
Hardener : 1 part

### For Aluminium (RAL 9006) only

Base : 9 parts  
Hardener : 1 part

### Mixing Advice

SIPTHANE 360 Enamel is a two component product supplied in 5 ltr. and 20 ltr. Kits which contain the proper ratio of ingredients. The entire contents of each container must be mixed together. It is important that all mixing equipment is free of moisture and that moisture does not contaminate the coating. Mix the base portion to obtain a smooth, homogeneous condition. After mixing the base portion, add the hardener slowly with continued agitation. After the hardener add is complete, continue to mix for 5 minutes.

### Induction Time

Allow 15 to 20 minutes induction time before application.

### Thinning

Thinner 760

Thinning is not normally required or desired; however, at lower temperatures or in extreme conditions, small amounts (20% or less) of the Thinner 760 may be added. Excessive thinning can adversely affect the application and appearance properties.

**Note:** Use only Thinner 730 for thinning Aluminium (RAL 9006)

### Pot Life

8 hours at 25°C.

### Application Methods

SIPTHANE 360 Enamel can be applied by airless spray, air spray, roller or by brush.

### Application Details

Airless Spray - 30 to 1 Pump or equivalent and .013" to .019" range tip sizes. For proper film formation thinning to 20% may be necessary in extreme conditions. Best result is obtained by applying a mist coat and then applying a full wet coat to have a uniform film.

### Cleaning of Equipment

Use Thinner 760.

## Storage Information

### Pack Size

5 and 20 ltr. two component kits.

### Storage

Store generally in original sealed container, indoors, at a temperature between 5 and 40°C and relative humidity below 70%.

### Shelf Life

2 Years

## Safety Information

See the material safety data sheet and product label for complete safety and precaution requirements.

## Disclaimer

The information in this data sheet represent test results or experience under well defined conditions. Its accuracy or suitability under the actual conditions of any intended use is not guaranteed and must be determined by the user. All advice given about this product is given in good faith. Since as we have no control over conditions of substrate and application, manufacturer and seller can not accept any liability in connection with the use of the product relative to coverage, performance, injury or damage, unless we specifically agree in writing to do so. The information in this data sheet is subject to change without notice and it is the user's responsibility to ensure it is current. For further information and advice contact SIPCO Technical Services Department on Tel. (03) 847 2299, Fax (03) 847 3780.