

**645J1: Base 645J9: Curing Agent 95070**  
**645J2: Base 645J9: Curing Agent 95042**

**Description:** Acrylithane HS4 Polyurethane is a two component, high performance polyurethane topcoat formulated for use in areas requiring VOC less than 100 grams / liter. It offers a full gloss, high quality appearance with exceptional color and gloss retention and good chemical resistance.

**Recommended use:** For use on automobiles, trucks, trailers, bulk tanks, chemical trailers and commercial architectural applications that require a premium topcoat appearance.

**Features:** Uses same catalyst as Ureprime HS4 primer  
Excellent color and gloss retention  
Chemical resistant  
Ultra-Low VOC

**Service temperatures:** Maximum, dry service exposure only: 120°C/248°F

**Availability:** Not included in Group Assortment. Availability subject to confirmation.

### Physical constants:

Colors/shade Nos.: White/10000\* (JB 4600-040)  
Finish: High gloss  
Volume solids, %: 59 ± 1  
Theoretical spreading rate: 23.6 m<sup>2</sup>/l - 25 μ946 sq. ft./US gal. - 1 mil  
Flash point: 46°F/8°C  
Specific gravity: 1.22 kg/liter - 10.2 lbs/US gallon  
Dry to touch: 8 hours at 20°C/68°F  
Through dry to handle: 12 hours  
Viscosity, mixed: 20-30" / Zahn 3  
VOC content: 95 g/liter [0.79 lbs/US gallon]  
*The physical constants stated are nominal data according to the Hempel Group's approved formulas.  
\*Wide range of colors available via Acrylithane™ HS Tint System.*

### Application details:

**Version, mixed product** **645J1 / 645J2**  
Mixing ratio: BASE 645J9 : curing agent 95070 or 95042 (JB 99961)  
4:1 by volume

Application method: Airless spray / Air spray / Brush & Roll  
Thinner (max.vol.): None / None / None  
(exempt solvents such as acetone, dimethyl carbonate or t-butyl acetate as needed)

Pot life: 1.5 hours at 20°C/68°F  
Nozzle orifice: 0.011" – 0.013" airless / 0.110" or 2.8 MM fluid cap conventional  
Nozzle pressure: 138 bar [2,000 psi]  
*(Airless spray data are indicative and subject to adjustment)*

Cleaning of tools: Medium Reducer 08320 (formerly JB 21092)  
Indicated film thickness, dry: 38 – 76 μ / 1.5 – 3.0 mils  
Indicated film thickness, wet: 60 – 120 μ / 2.3 – 4.8 mils  
Overcoat interval, min: 6 hours (20°C/68°F); 4 hours w/ 0.5 oz./mixed gallon of 99LJB accelerator (formerly JB 99041)  
Overcoat interval, max: See Remarks overleaf

**Safety:** Handle with care. Before and during use, observe all safety labels on packaging and paint containers, consult Hempel Safety Data Sheets and follow all local or national safety regulations.

<b>Surface preparation:</b>	Prime according to specification.
<b>Application conditions:</b>	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 7°C/44°F. The temperature of the paint itself should be: 15–25°C/59–77°F. In confined spaces provide adequate ventilation during application and drying. Thinning may be necessary in the case of very long spray hoses and/or paint temperatures below: 15°C/59°F. This will cause lower film build and longer drying time. Alternate reducers such as Acetone may be used to reduce product without adding VOC's.
<b>Preceding coat:</b>	According to specification. Recommended systems are: Ureprime HS4; Chem-O-Gard Low VOC Primer.
<b>Subsequent coat:</b>	None, or according to specification. Recommended systems are: Acrylithane HS4.
<b>Remarks:</b>	<p>Mixing: Mix thoroughly before use. Add 1 quart of catalyst to a 1 gallon of Acrylithane™ HS4 and mix thoroughly again. Only apply when air and surface temperature are between 44–100°F/7–38°C.</p> <p>Thinning: If using in California South Coast Air Quality Management District, use Acetone or tertiary butyl acetate. If using in other VOC regulated zones, then add 08EJB (JB 21102 Fast Spray Reducer) as required. When temperature is over 70°F, use 08320 (JB 21092 Medium Reducer). Add 08BJB (JB 21093 Slow Reducer) to reduce dry spray and orange peel, if required. 085JB (JB 21078 Special Urethane Retarder) can be added to help add a wet edge for spraying large parts.</p> <p>Brush/roller: Use 08DJB (JB 21099 Brush/Roll Additive) for a smoother film.</p> <p>Drying: Under normal conditions, dries to touch in 8 hours and dries for overcoat in 6 hours. Low temperature, high humidity, poor ventilation and thick films will retard drying. Addition of accelerator 99LJB (JB 99041) at the rate of 0.5 fl. /oz. per mixed gallon will shorten dry times to overcoat at 4 hours and to touch at 7 hours.</p> <p>Pot life: Approximately 1 ½ hours after mixing. Mix only the amount of material that can be used in 1 ½ hours. Pot life is decreased with an increase in temperature. Mixed material should be kept in as cool a location as possible. Flush mixed material from pressure pot and lines immediately after use.</p> <p>Cleaning: Clean paint tools or spills immediately with 08320 (JB 21092 Medium Reducer), MEK, or lacquer thinner carefully observing cautions on paint and thinner labels. Dried paint may need to be removed by scraping.</p>
<b>Overcoating:</b>	Sanding or roughening of surface is recommended if overcoating after 2 weeks.

**Note:** Acrylithane HS4 Urethane is for professional use only.

**Issued by:** Hempel (USA) – 645J100010 / 645J200010

This Product Data Sheet supersedes those previously issued.

For explanations, definitions and scope, see "Explanatory Notes" available on [hempel.com](http://hempel.com). Data, specifications, directions and recommendations given in this data sheet represent only test results or experience obtained under controlled or specially defined circumstances. Their accuracy, completeness or appropriateness under the actual conditions of any intended use of the Products herein must be determined exclusively by the Buyer and/or User.

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