



<p>DESCRIPTION</p>	<p>TrueKote CS155-S is a two component, spray or brush able, high performance urethane liquid elastomer, clear or color coating. TrueKote CS155-S is easy to apply using standard airless spray equipment and can be built up in multiple spray passes to a thick coating. It cures to a high performance urethane elastomer that has excellent physical properties and outstanding resistance to abrasion and wear. TrueKote CS155-S has better resistance to weathering than aromatic type urethanes, and with proper preparation most surfaces can be coated. TrueKote CS155-S may also be used as a coating for soft foam, floor coatings, flexible bumpers, synthetic rope coat, impact resistance pads for playgrounds and horse farms. TrueKote CS155-S may also be used as a protective coating for outstanding extended wear application on most metallic surfaces.</p>			
<p>PHYSICAL PROPERTIES (LIQUID)</p>	<p>Component</p>	<p>Resin Properties</p>	<p>Curative Component</p>	<p>Mixed Component</p>
<p>PHYSICAL PROPERTIES (CURED)</p>	<p>Color</p>	<p>Clear</p>	<p>Clear</p>	<p>Clear Amber</p>
	<p>Lbs. Per Gallon</p>	<p>8.18</p>	<p>8.08</p>	<p>8.16</p>
	<p>Weight Solids, %</p>	<p>80.0</p>	<p>51.0</p>	<p>75.0</p>
	<p>Volume Solids, %</p>	<p>77.39</p>	<p>47.30</p>	<p>72.30</p>
	<p>Viscosity, Brookfield ccps, @ 75°F</p>	<p>4000</p>	<p>4</p>	<p>1900</p>
	<p>Flash point, TCC</p>	<p>40°F</p>	<p>24°F</p>	<p>24°F</p>
	<p>VOC %</p>	<p>20.0</p>	<p>49.0</p>	<p>27.7</p>
	<p>*Percent VOC can be formulated to 15% per individual customer needs.</p>			
	<p>Tensile strength</p>	<p>ASTM D-412</p>	<p>4018 (psi)</p>	
	<p>Tear strength</p>	<p>ASTM D-412</p>	<p>829 (lbs./in.)</p>	
	<p>Elongation</p>	<p>ASTM D-412</p>	<p>468%</p>	
	<p>Hardness</p>	<p>85-95 Shore A</p>		
<p>HIGH OR LOW TEMPERATURE</p>	<p>TrueKote CS155-S has been successful at temperatures up to 180°F. Under wet or humid conditions at elevated temperatures, TrueKote CS155-S is superior to most other urethanes. Although TrueKote CS155-S becomes stiffer at lower temperatures, it still remains flexible at temperatures as low as -70°F.</p>			
<p>ABRASION RESISTANCE</p>	<p>TrueKote CS155-S has excellent abrasion resistance and will out wear many other materials when subjected to impingement or slurry abrasion. Taber abrasion: Wheel CS-17 @ 122 gram load (74°F) 4.4 mg/1000 rev abrasion loss</p>			
<p>CHEMICAL RESISTANCE</p>	<p>TrueKote CS155-S has excellent chemical resistance in the pH range of 2 to 12. Resistance to most oils at room temperature is good, but resistance to solvents is generally poor. The table below gives an indication of resistance to some chemicals; however, users should conduct their own tests.</p>			
	<p>Chlorinated Water*</p>	<p>E</p>	<p>Sea Water</p>	<p>E</p>
	<p>Nitric Acid, 5%</p>	<p>P</p>	<p>Toluene</p>	<p>P</p>
	<p>Hydrochloric Acid, 5%</p>	<p>P</p>	<p>Methyl Ethyl Ketone</p>	<p>P</p>
	<p>Phosphoric Acid, 10%</p>	<p>G</p>	<p>Ammonia</p>	<p>F</p>
	<p>Sodium Hydroxide, 10%</p>	<p>G</p>	<p>Kerosene</p>	<p>P</p>
	<p>G – Good</p>	<p>E – Excellent</p>	<p>F – Fair</p>	<p>P - Poor</p>
<p>CURE TIMES</p>	<p>The time required for TrueKote CS155-S to cure is dependent upon temperature. A 75% cure is generally sufficient for mild abrasion and submersion. The cure times shown below are for a 100-mil thick coating; cure times should be increased by 50% for a 250-mil thick coating.</p>			
		<p>50°F</p>	<p>75°F</p>	<p>120°F</p>
	<p>75% Cure</p>	<p>6 days</p>	<p>3 days</p>	<p>1 day</p>
	<p>95% Cure</p>	<p>15 days</p>	<p>7 days</p>	<p>3 days</p>
	<p>A 95% cure can be considered a complete cure for practical purposes, although all urethanes, including heat-cured urethanes, show improved physical properties after aging several weeks or months.</p>			



COVERAGE	The theoretical dry coverage of TrueKote CS155-S is 1158-mil square foot per mixed gallon of material. Overspray and waste must be taken into account when estimating the quantity of material required for a particular job.																		
EQUIPMENT	<p>A single component airless spray machine with a minimum air: fluid pressure ratio of 20:1 will provide a good spray pattern with .015 to .026 inch orifice spray tip. When using larger spray tips or long hose lengths, it is advisable to use a machine with a 30:1 air: fluid pressure ratio. The spray machine should be equipped with Teflon packings, Teflon or nylon hose and a 100-mesh outlet filter. A tip filter may be required for small tips. The spray hose should be conductive and the spray machine should be grounded to an earth ground when spraying.</p> <p>A Jiffy mixer or other propeller-type mixer used on air drill can be used to mix the urethane components.</p>																		
MIXING	<p>The resin portion of TrueKote CS155-S crystallize when exposed to temperatures below 40 F and the curative portion may crystallize when exposed to temperatures below 20 F. This does not harm the components; however, the resin component should be warmed to 90 – 100 F and the curative component to room temperature and each component mixed well before using. The components should not be overheated and should be cooled to room temperature before mixing together. After long term storage it is a good policy to stir each component before adding them together.</p> <p>DO NOT mix resin and curative components until ready to use. The correct mixing ratio is five parts component A to one part component B by weight. TrueKote CS155-S will not cure properly if the correct component mixing ratio is not used.</p> <p>Mix the components together in a clean container using a power drill until a uniform blend is achieved. Scrape the sides and bottom of the container with a straight edge several times during the mixing operation to prevent unmixed material from sticking to the container. The total time required to mix the components should be about five minutes.</p> <table border="1" data-bbox="370 968 1528 1373"> <tr> <td>1.</td> <td>Warm both components to room temperature before mixing.</td> </tr> <tr> <td>2.</td> <td>Remove lids with screw driver on one (1) gallon component A and one (1) quart component B can.</td> </tr> <tr> <td>3.</td> <td>Pour Color pack (½ pint can or metal tube) into component B (quart can).</td> </tr> <tr> <td>4.</td> <td>Pour all of component B (quart can) into component A (gallon can).</td> </tr> <tr> <td>5.</td> <td>Mix for three (3) minutes with drill and Jiffy mixer taking care not to mix in excess air.</td> </tr> <tr> <td>6.</td> <td>With a flat stick carefully scrape sides and bottom of container to ensure there are no unmixed components.</td> </tr> <tr> <td>7.</td> <td>Mix 1-½ additional minutes.</td> </tr> <tr> <td>8.</td> <td>Material will gel in 30 to 45 minutes depending on temperature hours. Material will be fully cured in 3 to 4 days (depending on temperature).</td> </tr> <tr> <td>9.</td> <td>Clean up equipment with Methyl Ethyl Ketone before material has fully cured.</td> </tr> </table>	1.	Warm both components to room temperature before mixing.	2.	Remove lids with screw driver on one (1) gallon component A and one (1) quart component B can.	3.	Pour Color pack (½ pint can or metal tube) into component B (quart can).	4.	Pour all of component B (quart can) into component A (gallon can).	5.	Mix for three (3) minutes with drill and Jiffy mixer taking care not to mix in excess air.	6.	With a flat stick carefully scrape sides and bottom of container to ensure there are no unmixed components.	7.	Mix 1-½ additional minutes.	8.	Material will gel in 30 to 45 minutes depending on temperature hours. Material will be fully cured in 3 to 4 days (depending on temperature).	9.	Clean up equipment with Methyl Ethyl Ketone before material has fully cured.
1.	Warm both components to room temperature before mixing.																		
2.	Remove lids with screw driver on one (1) gallon component A and one (1) quart component B can.																		
3.	Pour Color pack (½ pint can or metal tube) into component B (quart can).																		
4.	Pour all of component B (quart can) into component A (gallon can).																		
5.	Mix for three (3) minutes with drill and Jiffy mixer taking care not to mix in excess air.																		
6.	With a flat stick carefully scrape sides and bottom of container to ensure there are no unmixed components.																		
7.	Mix 1-½ additional minutes.																		
8.	Material will gel in 30 to 45 minutes depending on temperature hours. Material will be fully cured in 3 to 4 days (depending on temperature).																		
9.	Clean up equipment with Methyl Ethyl Ketone before material has fully cured.																		
APPLICATION	<p>Standard techniques used in airless paint spraying work well with TrueKote CS155-S. The proper spray tip should be selected for the job and the pressure of the pump should be adjusted to obtain an even spray pattern at the lowest pattern. The initial coat of TrueKote CS155-S should be a thin coat and should be applied from the bottom up so as to prevent overspray from depositing on the primed surface. On surfaces having a nap or rough texture, such as abraded rubber, optimum adhesive coats may be applied to a thickness of 20 to 30 wet mils, depending upon the position of the article being coated, the temperature and the elapsed time in the pot life. Each coat should be allowed to gel or dry to the touch, usually a period of 15-20 minutes, depending upon ambient temperatures, before the next coat is applied.</p> <p>TrueKote CS155-S should only be applied to surfaces that have been properly prepared. Most common materials such as steel, aluminum, fiberglass, rubber, urethane, brick, concrete, and wood can be coated with TrueKote CS155-S. To obtain maximum adhesion most substrates must be gritblasted, abraded or etched before applying Primer 350 and Primer 450 then applying TrueKote CS155-S. Metal surfaces should be gritblasted to SSPC-SP-10 "Near White Metal Blast" and should exhibit a 2 to 4 mil surface profile. Metallic substrates must always be dry and primed with Ultra-Prime 450 before TrueKote CS155-S is applied.</p>																		



REPAIR OF CURED COATING	TrueKote CS155-S may be repaired by priming surface with Ultra Prime 450 and the application of more TrueKote CS155-S.
POT LIFE	The pot life of TrueKote CS155-S is approximately 45 minutes at 75°F, 20 minutes at 100°F and After these times are exceeded for some additional time the material can still be sprayed using increased pressure or may be brushed or rolled on the substrate.
SAFETY	<p>Vapors from TrueKote CS155-S contain Isocyanates and solvents. Forced air ventilation must be used for all indoor applications. When working in tanks and other closed vessels or downstream from spray gun, fresh air breathing equipment should be worn. Chemical cartridge masks suitable for organic vapors may be used under some conditions with adequate ventilation. Protective clothing should be worn at all times. Both resin and curative components contain flammable solvents and should be protected from sparks and open flames.</p> <p>Avoid contact of components with skin and clothing as both resin and curative can cause skin and eye burns. In case of eye contact, immediately flush eyes with plenty of water for at least 15 minutes. If swallowed, DO NOT induce vomiting. Call a physician at once. Keep out of reach of children.</p>
CLEAN UP	<p>Equipment must be cleaned immediately after use to prevent buildup of cured urethane on internal parts of equipment. Solvents such as toluene or MEK works well for cleaning soiled spray equipment. As soon as urethane spraying is completed, solvent should be pumped through the pump, hose and spray gun until solvent comes out clear. The spray gun should then be removed from the hose and the end of the hose put in the solvent container near the pump suction and solvent should be circulated through the system for 15 – 20 minutes. The spray gun should then be attached to the hose and the system purged with fresh solvent. Dispose of all empty TrueKote CS155-S component containers in accordance with local, state and federal regulations. Empty component containers can be rendered non-hazardous by rinsing the containers with a small amount of mixed material and allowing the solvents to evaporate. The containers will then contain non-hazardous cured urethane.</p>
STORAGE AND SHELF LIFE	<p>TrueKote CS155-S components are shipped from the factory in sealed containers that are purged with dry nitrogen. The containers should be kept tightly sealed and stored in a cool and dry area that is protected from direct sunlight and moisture. Storage temperature should not exceed 80°F. The shelf life of factory seal containers stored under these conditions is one year.</p> <p>Containers that have been opened should be resealed immediately after material has been removed in order to prevent moisture contamination and solvent evaporation. Resin component containers should be purged with dry nitrogen if the contents are not used within 24 hours after opening.</p>
SHIPPING CLASS	Class 92.5 Hazardous