Apply only when air temperature is 40°F (4°C) or higher and when surface temperature is at least 5°F (3°C) above the dew point. The solvents contained in these products can lift some alkyd, oil based and other coatings that are not resistant to strong solvents. A test patch application is recommended. Not recommended for dimensionally unstable substrates, such as large expanses of wood, or for immersion service. Do not apply to concrete surfaces below grade or in other applications where hydrostatic pressure is present. Not intended for residential use. Color begins to change at 275°F (135°C). Drying times listed may vary depending on temperature, humidity and air movement. Spray equipment must be handled with due care and in accordance with manufacturer's recommendation. High-pressure injection of coatings into the skin by airless equipment may cause serious injury.

Pitthane® Ultra Gloss Urethane Enamels are recommended as topcoats in coating systems where color and gloss retention are primary considerations. They also provide superior chemical resistance and heat resistance.

Recommended Uses
- Aluminum
- Ferrous Metal
- Galvanized Steel
- Concrete, Stucco, Plaster, Masonry

Features / Benefits
- PPG's best urethane coating
- Fully 2.8 VOC compliant
- Superior gloss and color retention
- Virtually infinite color capability with the PERFORMACOLOR® system
- Mar and abrasion resistant
- Superior chemical resistance
- Surpasses Level 3 of SSPC-36 paint specification

Limitations of Use

Recommended Uses

Product Data
- Gloss: +70 (20° Gloss Meter)
- VOC*: 2.01 lbs/gal 241.00 g/L
- Coverage: 375 to 572 sq ft/gal (35 to 53 sq. m/3.78L)
  Note: Does not include loss due to varying application method, surface porosity, or mixing.
- DFT: 2.0 minimum to 3.0 maximum
- Weight/Gallon*: 11.6 lbs. (5.3 kg) +/- 0.3 lbs. (136 g)
- Volume Solids*: 70.4% +/- 2%
- Weight Solids*: 82.7% +/- 2%
- Mix Ratio: 5 parts Component A to 1 part Component B
- Clean-up: 97-730, 97-725, 97-727, 97-734, 97-735, 97-736
- PPG Thinners
  Results will vary by color, thinning and other additives.

Drying Time:
- To Touch: 2 hours
- To Handle: 4.5 hours
- Accelerated Potlife: 1 hour
- Accelerated Handle: 30 minutes
- Accelerated Recoat: 30 minutes

Pot Life: 3 hours

In Service Temperature:
- Dry Heat (F): 350°
- Dry Heat (C): 177°

Flash Point:
- 95-812 84°F, (28.9°C)
- 95-819 331°F, (164°C)
General Surface Preparation

The surface to be coated must be dimensionally stable, dry, clean, and free of oil, grease, release agents, curing compounds, and other foreign materials. Where appropriate bare areas should be primed with a suitable primer. Job conditions may dictate the choice of an alternate primer. Consult PPG HD systems or your PPG Sales Representative if this is the case. WARNING: Removal of old paint by sanding, scraping or other means may generate dust or fumes which contain lead. EXPOSURE TO LEAD DUST OR FUMES MAY CAUSE ADVERSE HEALTH EFFECTS, ESPECIALLY IN CHILDREN OR PREGNANT WOMEN. Controlling exposure to lead or other hazardous substances requires the use of proper protective equipment, such as properly fitted and approved (e.g., NIOSH-approved) respirator and proper containment and cleanup. For additional information, contact the USEPA/Lead Information Hotline at 1-800-424-LEAD or the regional Health Canada office.

PREVIOUSLY PAINTED SURFACES: Old coatings should be tested for adhesion of the existing system and lifting by the proposed topcoat. COATING SYSTEMS: 241-HD, 242-HD, 243-HD, 245-HD, 246-HD, 247-HD, 248-HD, 249-HD.

### Recommended Primers

<table>
<thead>
<tr>
<th>Material</th>
<th>Primers</th>
</tr>
</thead>
<tbody>
<tr>
<td>Galvanized Steel</td>
<td>97-145, 97-946</td>
</tr>
<tr>
<td>Concrete, Smooth Masonry</td>
<td>97-145, 97-946</td>
</tr>
<tr>
<td>Ferrous Metal</td>
<td>97-680, 97-145, 97-946</td>
</tr>
<tr>
<td>Aluminum</td>
<td>97-687</td>
</tr>
<tr>
<td>See Surface Prep Section</td>
<td>Refer to HD Coating Systems.</td>
</tr>
</tbody>
</table>

### Application Information

#### Recommended Spread Rates:

<table>
<thead>
<tr>
<th>Wet Mils</th>
<th>Dry Mils</th>
</tr>
</thead>
<tbody>
<tr>
<td>minimum to maximum</td>
<td>minimum to maximum</td>
</tr>
<tr>
<td>minimum to maximum</td>
<td>minimum to maximum</td>
</tr>
</tbody>
</table>

#### Application Equipment:

Changes in application equipment, pressures and/or tip sizes may be required depending on ambient temperatures and application conditions.

**Conventional Spray:** Fluid Nozzle: DeVilbiss MBC gun, with 777 or 78 air cap with E or F tip and needle, or comparable equipment. Atomization Pressure: 55 - 70 Fluid Pressure: (Can not specify, dependent on numerous factors)

**Airless Spray:** Pressure 1800 psi, tip 0.013" - 0.015"

**Brush:** High Quality Natural Bristle Brush

**Roller:** 3/8" nap solvent resistant core

#### Thinning:

95-812: See the PerformaColor VOC software to determine the allowable thinning for VOC compliance. 97-735 thinner can be added to obtain a 2.8 lb/gal (340 g/l) VOC for normal brush, roll, or spray application. Use 97-736 for a faster solvent at equal volume as recommended above. Both 97-735 and 97-736 increase the conductivity of the mixed paint. If desired, other thinners (97-730 or 97-727 for spray, 97-734 for brush or roller) may be used.

### Permissible temperatures during application:

<table>
<thead>
<tr>
<th>Material</th>
<th>Ambient</th>
<th>Substrate</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>60 to 90°F</td>
<td>40 to 140°F</td>
</tr>
<tr>
<td></td>
<td>16 to 32°C</td>
<td>4 to 60°C</td>
</tr>
</tbody>
</table>

PPG believes the technical data presented in this bulletin is currently accurate; however, no guarantee of accuracy, comprehensiveness, or performance is given or implied. Improvements in coatings technology may cause future technical data to vary from what is in this bulletin. For complete, up-to-date information visit our web site or call 1-800-441-9695.

### Bulletin: 95-812

Additional copies of this bulletin can be obtained from our web site or by calling 1-800-428-7806.