

ALPHAGAM

TECHNICAL DATA SHEET

Topcoats TDS
Topcoat Solid Colors

TOPCOAT

Single Stage Solid Colors

PRODUCT INFO

Two component solid colors for repairing commercial vehicles and automotive refinishing.

Technical Characteristics:

Color : Mixing System

Approx Coverage: 10 - 14 m²/l at 40 - 50 µm DFT

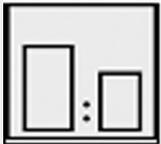
SURFACE PREPARATION

- Dry disc with P320 - 400 or Wet flat with P600–800 grade paper
- Wash off residues and dry thoroughly.
- Degrease with Silicon Remover Degreaser. The use of a tack 0 rag is recommended.

PROCESSING INSTRUCTIONS



Colour :
Transparent



Mixing Ratio :
Stir well before use. Twice per day for 15 mins on the mixing machine.

	By volume
1-UP 2K PU HS Hardener	1: 0.5
1-UP 2K PU MS Hardener	1: 0.6

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Pot life :

- 1 hr with 1-UP 2K PU HS Standard Hardener @ 30°C
- 2 hr with 1-UP 2K PU HS & MS Medium Hardener @ 30°C
- 3 hr with 1-UP 2K PU HS & MS Slow Hardener @ 30°C



Hardener :

For complete paint work

- 1-UP 2K PU HS Medium & Slow Hardener
- 1-UP 2K PU MS Medium & Slow Hardener

For partial paint work

- 1-UP 2K PU HS Fast Hardener
- 1-UP 2K PU MS Fast Hardener



Thinner :

- 1-UP 2K PU Standard Thinner @ 0 - 30%
- 1-UP 2K PU Medium Thinner @ 0 - 30%
- 1-UP 2K PU HF Slow Thinner @ 0 - 30%



Spraying Viscosity :

18 - 20 s 4mm DIN



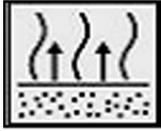
Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity spray gun (high pressure)	2.5 - 3	1.3 - 1.4	1.5 - 2	0 - 30
HVLP (low pressure)	2.5 - 3	1.3 - 1.4	1.5 - 2	0 - 30

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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Flash Off Time :
5 - 10 min between coats



Dry Coat Thickness :
40 - 50 µm



Drying time :

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30°C	20 - 30 min	5 - 6 h	12 h	NA	NA
60°C	15 - 20 min	30 min	After cooling	NA	NA

Storage :	1year from the date of manufacturing at 30° C, if stored in a dark dry place in a tightly closed container.
VOC Regulation :	EU limit value for this product (category B/d): 420 g/l This product contains max. 420 g/l of VOC.
Processing Conditions :	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.
Processing instructions :	To avoid too thick layers (very high solids content as HS quality) strictly observe the recommended number of coats. Check colours before application. Always check colours after having added the hardener. The polishability of some colours may be limited due to the system.

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