

ALPHAGAM

TECHNICAL DATA SHEET

Topcoats TDS

2K PU Topcoat Industrial Matt

2K PU TOPCOAT INDUSTRIAL MATT 40% GLOSS

PRODUCT INFO

Fast drying 2K polyurethane acrylic paint for industrial coating of machines, components, constructions, agricultural machinery and construction vehicles.

TECHNICAL CHARACTERISTICS

Colour : All RAL Shades in various Gloss levels

Approx Coverage: 8 - 10 m²/L at 40 - 50 µm DFT.

FEATURES

- ☒ short drying time
- ☒ electrostatic application possible
- ☒ highly water-resistant
- ☒ UV- and weather-resistant
- ☒ heat resistance : short-term heat exposure: 60°C
: permanent heat exposure: 100°C

SURFACE PREPARATION

Remove oil, grease, rust, mill scale, rolling skins, as well as other substances impairing the function of the coating.

Attention: A direct adhesion cannot be taken as granted due to most different kinds of metals, alloys, metallic and conversion coatings and so on. The adhesion must therefore be tested on the original metal substrate.

Steel:

- ☒ Blast to cleaning degree Sa 2½, remove blast residues and overcoat promptly
- ☒ De-rust with hand and power tools to degree of cleanliness St3
- ☒ Degrease with 1-UP Silicon Remover Degreaser

Galvanized and Aluminium substrates:

- ☒ Clean the surface with Alphabond cleaning agent. Degrease with 1-UP Silicon Remover Degreaser, sand thoroughly with sandpaper P 180/220 and clean subsequently with 1-UP Silicon Remover Degreaser.

Proposed coating structure :

- ☒ 2-coat system

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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SURFACE PREPARATION

Galvanized substrates:priming coat : **2K Epoxy Anti Corrosive Primer Surfacer RAL 7034** with 50 - 70 µm dry film thicknessfinishing coat : **2K PU RAL Colors** with 50 - 60 µm dry film thickness**Aluminium:**priming coat: **2K Epoxy Anti Corrosive Primer Surfacer RAL 7034** with 50 - 70 µm dry film thickness
finishing coat: **2K PU RAL Colors** with 50 - 60 µm dry film thickness.

Application Method

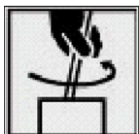
Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity spray gun (high pressure)	1.6 - 2	1.3 - 1.5	1 - 2	0 - 25
HVLP (low pressure)	1.6 - 2	1.3 - 1.8	1 - 2	0 - 25
Airmix / Airless	100 - 120	0.23 - 0.33	1 - 2	0 - 5
Brushing, Rolling	-	-	-	0 - 5

**Pot life :**

1 hour @ 30°C

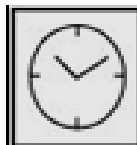
**Hardener :**

1-UP 2K PU MS Standard Hardener

**Thinner :**

1-UP 2K PU Standard Thinner

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Drying time :

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatible
30°C	20 - 30 min	2 - 3 h	6 - 8 h	NA	NA
60°C	NA	NA	30 min	NA	NA

Technical Information

	Colour : ALL RAL Shades
	Mixing Ratio : 4:1 (by volume)
	Spraying Viscosity : 20 - 22 s 4mm DIN
	Flash Off Time : 10 - 15 min between coats
	Dry Coat Thickness : 50 - 60 µm

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Specialnotes:

For professional use only.

Especially UV-resistant pigmentations (e.g. pastel shades for facades) are available on request of RAL shades.

Check colour shade prior to application

In case of application by means of an Airmix/Airless device, it is recommended testing beforehand the equipment for its suitability. If micro foam or blistering emerge during the application with an Airmix/Airless device, it is recommended adding more thinner or using the additives. Further more, the film thickness should be kept as low as possible.

If required we also offer hardeners and cleaning agents that are suitable for 2-component mixing and dosing units. Please contact your technical adviser or our application technicians.

Storage :	1year from the date of manufacturing at 30° C, if stored in a dark dry place in a tightly closed container.
VOC Regulation :	—
Processing Conditions :	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.