Waterborne Topcoat

Technical Data Sheet: 341-26
W series

1. Introduction

ALEXSEAL Waterborne Topcoat is a water reducible two component paint based on polyurethane technology.After curing, the material is characterized by a high gloss retention and color resistance even under extreme climatic conditions. Moreover, the cured film is resistant to abrasion, scratching, solvents, chemicals, synthetic cooling agents and hydraulic oils. ALEXSEAL Waterborne Topcoat has been approved by IMO Resolution MSC.307 (88)-(FTP-Code 2010) as marine paint with low flame-spread characteristics. ALEXSEAL Waterborne Topcoat has been approved by IMO Resolution MSC.307 (88)-(FTP-Code 2010) as marine paint with low flame-spread characteristics.

2. Range of application

ALEXSEAL Waterborne Topcoat is used in engine rooms and lockers for example. The material should not be used directly on the engines as the heat may cause gloss and color changes. However, this does not affect the film´s protective properties.

3. Color

ALEXSEAL Waterborne Topcoat is available in white standard factory packaged only.

4. Coverage

Volume Solids catalyzed without reduction: 46 %.
Coverage for ALEXSEAL Waterborne Topcoat when applying 2 coats.
Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m² / liter	**m² / gal**	**sq. ft. / gal**	**Rec. DFT in µm (mils)**
Theoretical / Brush and Roller	12	45	484	40 - 50 (2)
Practical				
Conventional Air Spray Equipment	7.2	27.2	293	40 - 50 (2)
HVLP Air Spray Equipment	8.4	31.7	342	40 - 50 (2)

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust and grease. Due to its good adhesion properties ALEXSEAL Waterborne Topcoat may be applied directly to fiberglass.

6. Trade names & Packaging

W….	ALEXSEAL Waterborne Topcoat (Base Color)	1 Gal
C9929	ALEXSEAL Waterborne Topcoat Converter	1 QT

7. Mixing ratio

Spray:

4 parts by volume	W….	ALEXSEAL Waterborne Topcoat (Base Color)
1 part by volume	C9929	ALEXSEAL Waterborne Topcoat Converter
10 - 15 % by volume	Distilled Water	

Example: 4 : 1 : 1/2 to 3/4 = 20 % reduction

Brush / Rolling:

4 parts by volume	W….	ALEXSEAL Waterborne Topcoat (Base Color)
1 part by volume	C9929	ALEXSEAL Waterborne Topcoat Converter
5 - 10 % by volume		Distilled Water

Example: 4 : 1 : ¼ up to 1/2 = 5 - 10 % reduction

The amount of reducer required may vary depending on the application conditions.

Mixed material must be filtered before application.

Mix ALEXSEAL Waterborne Topcoat Base and ALEXSEAL Waterborne Topcoat Converter with a high-speed mixer for approximately 2 minutes. After this, adjust the application viscosity by adding water.

8. Application

Viscosity	Zahn #2: ≈ 37 - 50 sec, DIN 4 cup 4mm: ≈ 30 - 40 sec
Nozzle Size Gravity Gun	1.0 to 1.4 mm (0.040 to 0.050) - Conventional & HVLP
Nozzle Size Siphon Cup	1.2 to 1.6 mm (0.046 to 0.060) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.0 to 1.2 mm (0.040 to 0.042) - Conventional & HVLP
Atomizing Pressure	3.0 to 3.5 bar (42 to 50 PSI) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 20 PSI) - Conventional & HVLP

Professional Use Only

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Application by Spraying: Apply 2 coats to a wet film thickness (WFT) of 30 - 40 microns (1.1 – 1.6 mils) per coat. Allow 60 minutes flash time between coats. This will achieve a dry film thickness (DFT) of 30 - 40 microns (1.2 - 1.6 mils) for a 2 coat application. Maximum recommended film thickness during a spray application is 2 coats totalling 60 - 80 microns (2.5 - 3 mils) WFT, or 30 - 40 microns (1.2 - 1.6 mils) DFT.

Application by Brush / Roller: Apply 2 coats to a wet film thickness (WFT) of 30 - 40 microns (1.1 – 1.6 mils) per coat. Each coat should dry to a tape dry stage, 12 - 24 hrs. Sand with 320 - 400 between coats. This will achieve a dry film thickness (DFT) of 30 - 40 microns (1.2 - 1.6 mils) for a 2 coat application. Maximum recommended film thickness during an application is 2 coats totalling 60 - 80 microns (2.5 - 3 mils) WFT, or 30 - 40 microns (1.2 - 1.6 mils) DFT.

9. Pot life and Drying Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Time
Pot Life - approx.	2 - 3 hrs	2 - 3 hrs	2 hrs	1 ½ hrs	N/A
Dust Free (at 60 % relative humidity)	4 hrs	3 hrs	2 hrs	1 hr	N/A
Tape Dry	26 hrs	24 hrs	18 hrs	12 hrs	N/A
Fully Cured	21 days	18 days	14 days	12 days	N/A
Recoat after tack up with ALEXSEAL Waterborne Topcoat	90 min	60 min	60 min	60 min	24 hrs
Overcoat with another product. Preparation including sanding is required	24 hrs	24 hrs	18 hrs	12 hrs	N/A
Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity of reducer, and film thickness will affect actual times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.					

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