

Interior Coating

1. Introduction

ALEXSEAL® Interior Coating is a two component, polyurethane based material used where an extremely durable coating is required. Good adhesion properties on a variety of substrates, combined with high resistance values make ALEXSEAL® Interior Coating suitable for many areas of application.

The cured film is resistant to abrasion, scratching, solvents, chemicals, synthetic cooling agents and hydraulic oils.

This coating is recommended for interior applications only. If objects exposed to extreme weather conditions are not cleaned regularly, UV rays will cause slight gloss and color changes. However, this does not affect the film's protective properties.

2. Range of application

ALEXSEAL® Interior Coating is used for parts in the engine room and the yacht's interior.

3. Color

ALEXSEAL® Interior Coating is available in standard factory packaged colors and, upon request, in custom colors. Refer to the color card or price list for part numbers.

4. Coverage

Coverage for ALEXSEAL® Premium Topcoat 501 when applying 2 coats.

Volume Solids catalyzed without reduction: 43 %.

Theoretical:

8.6 m² / l (352 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).

Practical:

Conventional Air Spray Equipment: 5.2 m² / l (211 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).

HVLP Air Spray Equipment: 6.2 m² / l (264 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).

Brush / Roller and Airless Spray Equipment: 8.6 m² / l (352 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust and grease. Due to its good adhesion properties ALEXSEAL® Interior Coating is applied directly onto the appropriately cleaned and pretreated substrate, even if substrates are difficult to coat, e.g. aluminium.

For optimum corrosion protection use of primer may be required. Consult your ALEXSEAL® representative for more information regarding primers.

6. Trade names

Base Material	N....	ALEXSEAL® Interior Coating (Base Color)
Converter	C6402	ALEXSEAL® Interior Coating Converter
Reducer	R6062	ALEXSEAL® Interior Coating Reducer

7. Mixing ratio

Spray:

4 parts by volume	N....	ALEXSEAL® Interior Coating (Base Color)
1 part by volume	C6402	ALEXSEAL® Interior Coating Converter
20 to 30 % by volume	R6062	ALEXSEAL® Interior Coating Reducer
	R6068	ALEXSEAL® Interior Coating Reducer Slow

Example: 4 : 1 : 1 to 1 ½ = 20 to 30 % reduction

Brush and Rolling:

4 parts by volume	N....	ALEXSEAL® Interior Coating (Base Color)
1 part by volume	C6402	ALEXSEAL® Interior Coating Converter
5 % by volume	R6062	ALEXSEAL® Interior Coating Reducer
Or	R6068	ALEXSEAL® Interior Coating Reducer Slow

Example: 4 : 1 : ¼ = 5 % reduction

Professional Use Only

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The information contained in this data sheet is based on our level of research and development. Revisal by the user with regard to the intended aim is necessary due to the diverse processing and application possibilities. revision January 2008

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- 8. Application**
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| <p>Application by Spraying:</p> <p>Application by brush/rolling:</p> | <p>Viscosity (Zahn #2) approx. 18 to 22 sec</p> <p>Fluid Nozzle Size 1.3 to 1.6 mm (0.050 to .060) - Conventional & HVLP</p> <p>Atomizing Pressure 3.0 to 3.5 bar (42 to 50 PSI) – Conventional & HVLP</p> <p>Pot Pressure 0.7 to 1.5 bar (10 to 20 PSI) – Conventional & HVLP</p> <p>Apply 2 coats to a wet film thickness (WFT) of 50 - 75 microns (2 - 3 mils) per coat. Allow 20 - 60 minutes flash time between coats. This will achieve a dry film thickness (DFT) of 50 - 75 microns (2 - 3 mils) for a 2 coat application. Maximum recommended film thickness during a spray application is 2 coats totalling 120 - 140 microns (5 - 6 mils) WFT, or 60 - 70 microns (2.5 - 3 mils) DFT.</p> <p>Apply 2 to 3 coats to a wet film thickness (WFT) of 50 - 75 microns (2 - 3 mils) per coat. Each coat should dry to a tape dry stage, 12 - 24 hrs. This will achieve a dry film thickness (DFT) of 50 - 75 microns (2 - 3 mils) for a 2 coat application. For a 3 coat application, this will achieve a dry film thickness (DFT) of 50 - 112 microns (2 - 4.5 mils).</p> |
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9. Pot life and Drying

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.	18 hrs	12 hrs	9 hrs	6 hrs	18 hrs
Dust Free	40 - 60 min	30 - 45 min	20 - 30 min	15 - 20 min	40 - 60 min
Tape Dry	32 hrs	24 hrs	16 hrs	12 hrs	32 hrs
Fully Cured	14 days	7 days	5 days	3 days	N/A
Recoat after tack up with ALEXSEAL® Interior Coating	40 - 60 min	30 - 45 min	20 - 30 min	15 - 20 min	40 - 60 min
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, choice of reducer speed, and film thickness will effect actual times during application.					
Minimum temperature during drying phase: 15°C (60°F). Ideal temperature: 25°C (77°F).					

- 10. Packaging**
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|-------|---|-------|
| N.... | ALEXSEAL® Interior Coating (Base Color) | 1 Gal |
| C6402 | ALEXSEAL® Interior Coating Converter | 1 QT |
| R6062 | ALEXSEAL® Interior Coating Reducer | 1 Gal |
| R6068 | ALEXSEAL® Interior Coating Reducer Slow | 1 Gal |