

# ALEXSEAL® Interior Coating

Technical Data Sheet: 462-44  
**N Series**

## 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

Volume Solids catalyzed without reduction: 40 %.

Coverage for ALEXSEAL® Interior Coating when applying 2 coats.

*Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.*

	m <sup>2</sup> / liter	m <sup>2</sup> / gal	sq. ft. / gal	Rec. DFT in µm (mils)
<b>Theoretical / Brush and Roller</b>	8	30.3	326	50 ( 2 )
<b>Practical</b>				
Conventional Air Spray Equipment	5	19	204	50 ( 2 )
HVLP Air Spray Equipment	6	22.7	244	50 ( 2 )
Airless Spray Equipment	8	30.3	326	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® Interior Coating is applied directly onto the appropriately cleaned and pretreated substrate, even if substrates are difficult to coat, e.g. aluminum.

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
	R6068	ALEXSEAL® Interior Coating Reducer Slow

## 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 1/2 = 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 : 1/4 = 5 % reduction

The amount of reducer required may vary depending on the application conditions. Mixed material must be filtered before application.

**Professional Use Only**

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## 8. Application

Viscosity	Zahn #2: ≈ 15 - 18 sec, DIN 4 cup 4mm: ≈ 12 - 18 sec
Nozzle Size Gravity Gun	1.2 mm - 1.6 mm ((0.047 to 0.060) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.0 to 1.3 mm (0.040 to 0.050) - Conventional & HVLP
Atomizing Pressure	3.0 to 5.0 bar (42 to 70 PSI) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 20 PSI) - Conventional & HVLP
Airmix Equipment	0.18 to 0.28 mm (0.007 to 0.011) Inlet pressure 3.0 to 5.0 bar (42 to 70 PSI)

Application by Spraying: 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 30 - 50 microns (1.5 - 2 mils) for a 2 coat application. Maximum recommended film thickness during a spray application is 2 coats totalling 180 - 220 microns (7 - 9 mils) WFT, or 60 - 70 microns (2.5 - 3 mils) DFT.

Application by Brush/Rolling: 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).

## 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.	18 hrs	12 hrs	9 hrs	6 hrs	NA
Dust Free	40 - 60 min	30 - 45 min	20 - 30 min	15 - 20 min	NA
Tape Dry	32 hrs	24 hrs	16 hrs	12 hrs	NA
Fully Cured	14 days	7 days	5 days	3 days	N/A
Recoat after tack up with ALEXSEAL <sup>®</sup> Interior Coating	40 - 60 min	30 - 45 min	20 - 30 min	15 - 20 min	4 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 and or choice of reducer, and film thickness will effect actual tack up, recoat, overcoat, and drying 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.

## 10. Packaging

N...	ALEXSEAL <sup>®</sup> Interior Coating (Base Color)	1 Gal
C6402	ALEXSEAL <sup>®</sup> Interior Coating Converter	1 QT
R6062	ALEXSEAL <sup>®</sup> Interior Coating Reducer	1 Gal
R6068	ALEXSEAL <sup>®</sup> Interior Coating Reducer Slow	1 Gal

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