

# Waterborne Topcoat

- 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.
- 2. Range of application** ALEXSEAL® Waterborne Topcoat is used in engine rooms and lockers as well as other surfaces where a waterborne product is desired.
- 3. Color** ALEXSEAL® Waterborne Topcoat is available in standard factory packaged white colors.
- 4. Coverage** Coverage for ALEXSEAL® Waterborne Topcoat when applying 2 coats.
- Volume Solids catalyzed without reduction: 36 %.
- Theoretical:** 12 m<sup>2</sup> / l (484 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).
- Practical:** **Conventional Air Spray Equipment:** 7.2 m<sup>2</sup> / l (293 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).  
**HVLP Air Spray Equipment:** 8.4 m<sup>2</sup> / l (339 sq. ft. per gallon) at recommended dry film thickness of 50 microns (2 mils).  
**Brush / Roller and Airless Spray Equipment:** 12 m<sup>2</sup> / l (484 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® Waterborne Topcoat may be applied directly to fiberglass.
- 6. Trade names**
- |               |       |   |
|---------------|-------|---|
| Base Material | W.... | ALEXSEAL® Waterborne Topcoat (Base Color) |
| Converter     | C9929 | ALEXSEAL® Waterborne Topcoat Converter    |
| Reducer       |       | distilled water                           |
- 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 : ½ to ¾ = 10 - 15 % reduction
- |                  |                    |       |   |
|------------------|--------------------|-------|---|
| Brush / Rolling: | 4 parts by volume  | W.... | ALEXSEAL® Waterborne Topcoat (Base Color) |
|                  | 1 part by volume   | C9929 | ALEXSEAL® Waterborne Topcoat Converter    |
|                  | 0 - 10 % by volume |       | distilled water                           |
- Example: 4 : 1 : 0 up to ½ = 0 - 10 % reduction
- Mix ALEXSEAL® Waterborne Topcoat Base and ALEXSEAL® Waterborne Topcoat Converter with a high speed mixer for approx. 2 minutes. After this, adjust the application viscosity by adding water.

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Technical Data Sheet:  
342-52 / W Series

<b>8. Application</b>	Viscosity (DIN4)	approx. 60 sec
	Fluid Nozzle Size	1.2 to 1.6 mm (.046 to .060) - 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

Application by Spraying: Apply 2 coats to a wet film thickness (WFT) of 60 - 80 microns (1.2 - 1.6 mils) per coat. Allow 20 - 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 / Rolling: Apply 2 coats to a wet film thickness (WFT) of 60 - 80 microns (1.2 - 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

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, humidity, and film thickness will effect actual times during application.					
Minimum temperature during drying phase: 15°C (60°F). Ideal temperature: 25°C (77°F). Relative Humidity: 30 - 70 %.					

<b>10. Packaging</b>	W....	ALEXSEAL® Waterborne Topcoat (Base Color)	1 Gal
	C9929	ALEXSEAL® Waterborne Topcoat Converter	1 QT

**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