

# 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.

## 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 standard factory packaged colors only.

## 4. Coverage

Volume Solids catalyzed without reduction: 36 %.

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.*

|                                       | m <sup>2</sup> / liter | m <sup>2</sup> / gal | sq. ft. / gal | Rec. DFT in μm (mils) |
|---------------------------------------|------------------------|----------------------|---------------|-----------------------|
| <b>Theoretical / Brush and Roller</b> | 12                     | 45                   | 484           | 50 ( 2 )              |
| <b>Practical</b>                      |                        |                      |               |                       |
| Conventional Air Spray Equipment      | 7.2                    | 27.2                 | 293           | 50 ( 2 )              |
| HVLP Air Spray Equipment              | 8.4                    | 31.7                 | 342           | 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

|               |                 |  |
|---------------|-----------------|--|
| 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 : 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 : 1/4 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.

**Professional Use Only**

**Page 1 of 2**

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. Any liability on part of Mankiewicz for faulty applications and / or improper use is expressly excluded. revision 2018

# Waterborne Topcoat

Technical Data Sheet: 341-26  
**W series**

## 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  |

Application by Spraying: Apply 2 coats to a wet film thickness (WFT) of 60 - 80 microns (2.5 - 3 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 60 - 80 microns (2.5 - 3 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.

## 10. Packaging

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

**Professional Use Only**

**Page 2 of 2**

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. Any liability on part of Mankiewicz for faulty applications and / or improper use is expressly excluded. revision 2018