



Imron® 7230 High Build HydroBaseCoat

2K Waterbased Topcoat PUR

Rail segment

| Description | |
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| <p>Imron 7230 High Build HydroBaseCoat is a 2-component water based polyurethane basecoat system specially developed for application on trains and other railway vehicles. It is designed to be used as a high build basecoat in combination with water or solvent based clearcoats.</p> | |
| Products | |
| Imron® 7230 | Imron® 7230 High Build HydroBaseCoat |
| HT200 | Imron® HydroTopCoat Activator Fast |
| HT201 | Imron® HydroTopCoat Activator Standard |
| HT202 | Imron® HydroTopCoat Activator Standard |
| HT203* | Imron® HydroTopCoat Activator Standard |
| HT204 | Imron® HydroTopCoat Activator High Temperature |
| HT300 | Imron® HydroTopCoat Reducer |
| HT310 | Imron® HydroTopCoat Spot Repair Reducer |
| * BGA - free | |

| Properties |
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| <ul style="list-style-type: none"> • Excellent adhesion • High mechanical and chemical resistance • Available in a variety of colour and gloss levels • Easy application |

| Substrates |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> • Cured, solvent resistant, well preserved and scuff sanded OEM or old finish. • Primed water and solvent based surfaces • Cleaned and pretreated thermoplastics and different types of GRP (see section 'Remarks'). |

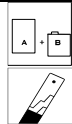

| Surface preparation |
|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <ul style="list-style-type: none"> • OEM and old finish: sanded and degreased with water-based degreaser • Primer / Filler: according to their specifications • Degrease before recoating. |






| Theoretical VOC – ready for use (RFU) at maximum dilution | |
|-----------------------------------------------------------|---------|
| • White | 140 g/l |
| • Black | 138 g/l |

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|-----------------------------------------------------------------------------------|---------------------------------------|-------------------------------|---------------|---------------|
|  | Mixing Ratio | | Volume | Weight |
| | | Imron® 7230 | 4 | 100 |
| | | HT200/HT201/HT203/HT204 | 1 | 22 |
| | | Stir well with powered mixer. | | |
| | Thinner | HT300 | | |
|  | Pot life at 20°C | 4 Hours | | |
| | Recommended dry film thickness | 40-60 µm | | |

| <u>Application</u> | Application viscosity DIN4 at 20°C (s) | Thinner (%) | Spray nozzle (mm) | Pressure (Bar) | Number of coats |
|------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------|------------------------|----------------------------------|---------------------------|----------------------------|
|  Gravity feed | 25 - 30 | 5 - 10 | 1.2 - 1.4 | 3 - 4 | 2 |
|  Suction feed (high pressure spraying) | | | 1.5 - 1.8 | | |
|  HVLV (Low pressure spraying) | 25 - 30 | 5 - 10 | 1.2 - 1.4 | 0.7 | 2 |
|  Pressure pot / Feed pump (high pressure spraying) | 25 - 30 | 5 - 10 | 1.0 - 1.2 | 3 - 4 | 2 |
|  Electrostatic | According to the advice of the Axalta Technical Representative | | | | |
| Application | After first coat is applied allow at least 30 minute flash before second coat is applied, ensuring all water has evaporated. | | | | |



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| Drying | |
| Air drying at 20°C | |
| Dust dry | 1-2 hours |
| Dry to handle | Overnight |
| Dry | Overnight |

| | |
|---------------------------|------------------------------|
| Forced drying | Flash time: 30-45 minutes. |
| Drying time | 30 - 60 minutes |
| Drying temperature | 60 – 80°C object temperature |

Clearcoat application

| | |
|------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Clearcoat | Clearcoat must be applied after proper drying (30-60' @ 60°C or overnight at 20°C) Overcoat able with Axalta solventbased and waterbased clearcoats. See TDS of clearcoat used for technical details. |
|------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|

Product Data

| | |
|--------------------------|------------------|
| Package viscosity | Colour dependent |
| Flash point | > 95°C |



| | Solids | Density | Theoretical coverage | | Theoretical material consumption | |
|-----------------------------|---------------|----------------|-----------------------------|--------------------|-----------------------------------------|------------------|
| | Weight (%) | (kg/l) | (at 40 µ) | | (at 40 µ) | |
| RFU at max. dilution | +/- 1 | +/- 0.01 | m ² /l | m ² /kg | ml/m ² | g/m ² |
| White | 50 | 1.17 | 9.8 | 8.4 | 102 | 119 |
| Black | 42 | 1.04 | 9.3 | 8.9 | 108 | 112 |

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Remarks

| | | | |
|-----------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------|-----------------------------------------|
|  | <ul style="list-style-type: none"> Stir Imron 7230 HydroBasecoat thoroughly before use for 3 to 4 minutes. Before adding HT300 for viscosity correction, the activator must be accurately mixed-in into the paint with a mechanical mixer for 3 to 4 minutes. Preferably, a blade of 1/3 the size of the container is used. Avoid air entrapment while stirring. | | |
|  | <ul style="list-style-type: none"> Before application the substrates need to be cleaned with a water-based silicon remover. | | |
| <p>Remarks</p> | <ul style="list-style-type: none"> The spray equipment must be from stainless steel. All stirring rods / containers in use must be from stainless steel or plastic. Material is frost sensitive. Material must be stored at a temperature between 5°C and 35°C. Material must be at room temperature (18-25°C) before use. Close can of activator tightly immediately after use, as these products will react with humid air and water and lose their hardening effect. Activated material should not be returned to original can of non-activated material. Due to the variety of plastics and application methods, tests must be carried out before mass production can be started in order to check properties. | | |
| | <p>Shelf Life (5-35 °C) (months)</p> | <p>Density (kg/l) +/- 0.01</p> | <p>Theoretical VOC (g/l)</p> |
| Imron 7230 HBC | 18 | 1.00 – 1.35 | 60-100 |
| HT200 | 36 | 1.05 | 368 |
| HT201 | 36 | 1.06 | 422 |
| HT202 | 36 | 1.04 | 436 |
| HT203 | 36 | 1.06 | 447 |
| HT204 | 24 | 1.08 | 452 |
| HT300 | 24 | 1.00 | 0 |
| HT310 | 60 | 0.85 | 848 |

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REPAIR SYSTEMS

Spot repair

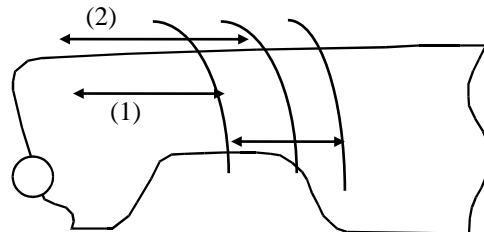
1. Clean surface with water and soap. Rinse and dry
2. Degrease with a correct Axalta preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area with a non-silicone containing rubbing compound or sand wet with P2000
6. Rinse with water and dry
7. Degrease with a correct Axalta final cleaner / degreaser. Wipe dry with a clean cloth.
8. Tack rag.

Prepare paint.

- | | |
|----------|---|
| 1. I7230 | 4 |
| 2. HT201 | 1 |
| 3. HT310 | 5 |

Fade-out method

- 1 Apply 1st coat Imron® HBC 7230.
Flash time: 5 min.
- 2 Apply 2nd coat Imron® HBC 7230
beyond the previous one.
- 3 Smoothen out the fade-out area with
HT310.





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Safety

Consult the Safety Data Sheet prior to use.
Observe the precautionary notices displayed on the container.

Information

The information provided herein corresponds to our knowledge on the subject at the date of its publication. This information may be subject to revision as new knowledge and experience becomes available. The data provided fall within the normal range of product properties and relate only to the specific material designated; these data may not be valid for such material used in combination with any other materials or additives or in any process, unless expressly indicated otherwise. The data provided should not be used to establish specification limits or used alone as the basis of design; they are not intended to substitute for any testing you may need to conduct to determine for yourself the suitability of a specific material for your particular purposes. Since Axalta cannot anticipate all variations in actual end-use conditions Axalta makes no warranties and assumes no liability in connection with any use of this information. Nothing in this publication is to be considered as a license to operate under or a recommendation to infringe any patent rights.

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