



Imron® HydroClearCoat HC300

2K Waterbased Clearcoat PUR

Description

Imron® HydroClearCoat HC300 is a waterbased 2-component polyurethane clearcoat especially developed for application on all types of commercial vehicles.
Composition based on acrylic resin.

Products

HC300	Imron® HydroClearCoat
HT202	Imron® HydroTopCoat Activator Standard
HT204	Imron® HydroTopCoat Activator High Temperature
HT300	Imron® HydroTopCoat Reducer
HT310	Imron® HydroTopCoat Spot Repair Reducer
HT802	Imron® HydroTopCoat PUR Matt Binder

Colours

- Not Applicable

Properties

- Excellent adhesion
- High mechanical resistance
- Offers different gloss levels
- Easy application
- Excellent anti-graffiti performance

Substrates

- All Axalta™ waterbased basecoats.

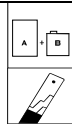

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<p>Pretreatment</p> <ul style="list-style-type: none"> • Basecoats must be completely dry (mat) before clearcoating.
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<p>Solvent content – ready for use (RFU) at maximum dilution</p> <ul style="list-style-type: none"> • 158 g/l







Product preparation

	<p>Mixing ratio</p>	<p>HC300.</p>	<p>Volume</p>	<p>Weight</p>
		<p>HT202/HT204</p> <p>Stir well with powered mixer.</p>	<p>2</p>	<p>100</p>
			<p>1</p>	<p>55</p>
	<p>Thinner</p>	<p>HT300</p>		
	<p>Pot life at 20°C</p>	<p>4 hours</p>		
	<p>Recommended dry film thickness</p>	<p>40-50 μ</p>		

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Application

		Application viscosity DIN 4 at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
	Gravity feed	20	20 -22	1.2-1.6	3-4	2
	Suction feed					
	(High pressure spraying)					
	HVLP	20	20-22	1.2-1.4	0.7 at nozzle	2
	(Low pressure spraying)					
	Pressure pot	20	20-22	1.1-1.2	3	2
	Membrane pump					
	(High pressure spraying)					
	Airless	20	20-22	Airless 0.23	170-200	1.5
	Airmix			Airmix 0.23	3-4 air Min 120 (material)	
	Electrostatic	According to the advice of the Axalta Technical Representative.				

Drying

Air drying at 20°C	
Dust dry	1-2 hours
Dry to handle	Overnight
Dry	Overnight
Forced drying	Flash time: 30 minutes (till completely transparent)
Drying time	20-30 minutes
Drying temperature	60-80°C object temperature



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Recoatability

Recoatable with itself according to the advice of the Axalta Technical representative.

Product data


Package viscosity	> 120 s Din 6
Flash point	> 93°C

RFU at max. dilution	Solids	Density	Theoretical coverage (at 40 μ)		Theoretical material consumption (at 40 μ)	
	Weight (%) +/- 1	(kg/l) +/- 0.01	m ² /l	m ² /kg	ml/m ²	g/m ²
HC300	40	1.03	9.0	8.7	111	115

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Remarks

	<ul style="list-style-type: none"> • Before adding HT300 for the viscosity correction, the activator has to be accurately mixed-in into the paint with a mechanical mixer for 3 to 4 minutes. • Avoid air-entrapment while stirring 		
Remarks	<ul style="list-style-type: none"> • The spray equipment has to be from stainless steel. All stirring rods / containers in use have to be from stainless steel or plastic. • Before applying the second coat, the first one must be fully transparent. • Before forced drying, the clearcoat must be fully transparent. • Material is frost-sensitive. • Material has to be stored at a temperature between 5°C and 35°C. • Material has to 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. 		
Data	Shelf Life (5-35°C) (months)	Density (kg/l) +/- 0.01	Theoretical VOC (g/l)
HC300 HT202 HT204 HT300 HT310 HT802	12 36 24 60 24 12	1.04 1.04 1.08 1.00 0.85 1.15	73 437 454 0 846 104

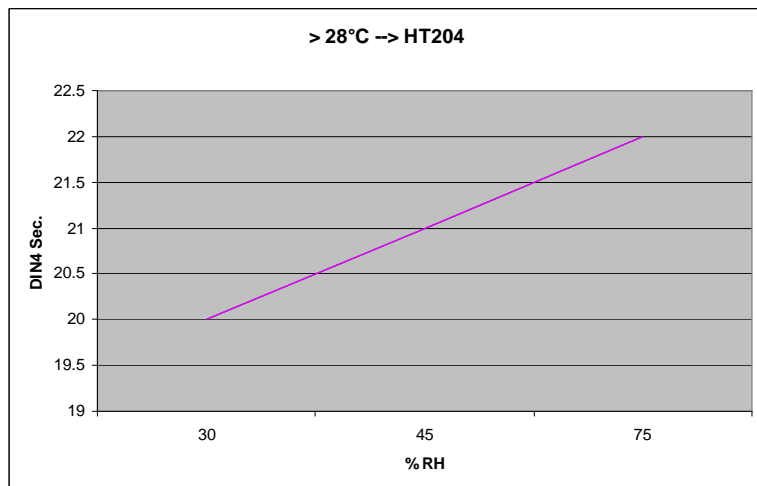
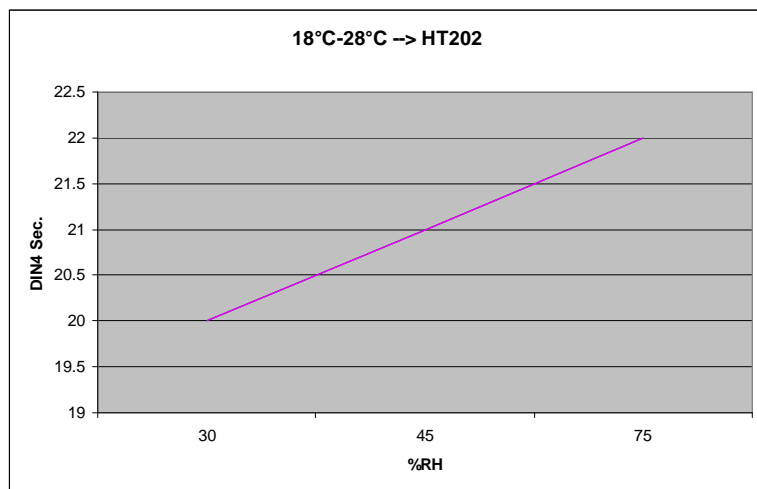


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Special Remark

- Depends on humidity and temperature following viscosity/activator can be suggested.



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REPAIR SYSTEMS

Spot repair

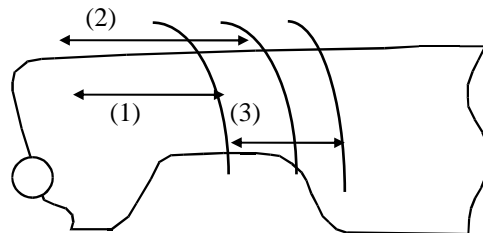
1. Clean surface with water and soap. Rinse and dry
2. Degrease with a correct Axalta preparatory cleaner. Wipe dry with a clean cloth.
3. Repair with recommended undercoats.
4. Sand treated spots as recommended.
5. Prepare complete fade-out area with a non-silicone containing rubbing compound or sand 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. HC300 | 2 |
| 2. HT202 | 1 |
| 3. HT310 | 3-4 |

Fade-out method

- 1 Apply 1st coat of Imron® HC300 over the basecoat, extending into the area surrounding the spot. Flash time : 5 min.
- 2 Apply 2nd coat Imron® HC300, extending further into the area surrounding the spot
- 3 Smoothen out the fade-out area with HT310 within 3 minutes.



OPTIONAL: If necessary, balance out the gloss level by polishing with a non-silicone containing polishing compound or a non-silicone containing final glaze, after complete hardening of the repair.



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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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