



Imron® HydroBaseCoat 8200

Waterbased Basecoat

Description

Imron® HydroBaseCoat 8200 is an innovative waterborne base coat system which has been specially developed for coating large areas, e.g. on commercial vehicles, buses or railway rolling stock. It combines easy application with excellent mottling control and outstanding UV-resistance for particularly long-lasting finishes. Excellent adhesion and mechanical properties are achieved thanks to a special activator.

Products

Imron® HydroBaseCoat 8200	Imron® HydroBaseCoat 8200 Fac Pac
HB202	Imron® HydroBaseCoat Activator Standard
HT300	Imron® HydroTopCoat Reducer

Colours

Solid and effect colours.

VOC content – ready for use (RFU)

- The VOC content of this product in ready to use form is max. 420 g/l

Substrates

- Primed surfaces.
- Cured, solvent resistant, well preserved and scuff sanded old finish.
- Cleaned and pre-treated thermoplastics.

Product data

RFU without thinner	Solids	Density	Theoretical coverage		Theoretical material consumption	
	Weight (%) +/- 1	(kg/l) +/- 0.01	(at 20 µm) m²/l	(at 20 µm) m²/kg	(at 20 µm) ml/m²	(at 20 µm) g/m²
White	38	1.18	12.6	10.7	79	93
Silver	17	1.02	7.1	7.1	141	141


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Preparation





Surface preparation

- Primer / Filler: according their specifications
- Old finish: sand and degrease.
- Degrease before recoating.

Product preparation

	Pot life at 20°C		2 hours
Activation	HB202	in combination with Clear Coat waterborne (HC300)	5 % 20:1 by weight 20:1 by volume
	HB202	in combination with Clear Coat solventborne (PFT 8330)	10 % 10:1 by weight 10:1 by volume
Thinning	Imron® 8200 is designed to be used without thinning. If preferred, thin with HT300.		
Application viscosity	Ready for use or 25-40 s DIN 4.		
Recommended dry film thickness	Solid colours: 15-25 µm Metallic colours: 10-15 µm Pearl colours: 15-20 µm		



Application

		Application viscosity	Spray nozzle	Pressure	Material pressure	Number of coats
		4 mm, +20°C, DIN 53211	(mm)	(bar)	(bar)	
	Gravity feed	ready for use	1.3-1.4	2-2.5	-	1.5 coats = 1 spray operation 1 full coat + 1 finish / effect coat
	HVLP (Low pressure spraying)	ready for use	1.3-1.5	0.7 at nozzle	-	1.5 coats = 1 spray operation 1 full coat + 1 finish / effect coat
	Pressure Membrane Pump	ready for use	1.0-1.1	2.5 2.5	0.8-1.0 0.8-1.0	1.5 coats = 1 spray operation 1 full coat + 1 finish / effect coat
	Electrostatic	According to the advice of the technical representative.				
Remark	With low-opacity colours it may be necessary to apply one more coat (wet-on-wet). With pressure pot and feed pump, it is necessary to gauge the material capacity. The material capacity should be 350-400 g/min. We recommend to add 10% Imron® Reducer HT300 when humidity is below 30% and/or the temperature above 35°C. Flash off can be accelerated by using stationary air diffusing units (e.g. ceiling system) or low baking.					

Drying

Air drying at 20°C	until surface is completely flat
Forced drying	10 - 30 minutes 60 °C object temperature

Remarks

	<ul style="list-style-type: none"> The activator has to be accurately mixed 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, a colour comparison is recommended.
	<ul style="list-style-type: none"> The spray equipment has to be from stainless steel. Material should be at room temperature (18-25 °C) before use. Material is frost-sensitive and has to be stored at a temperature between 5°C and 35°C. Close can of activator tightly immediately after use, as it 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. Type of tape: water suitable tape is required (local supplier to be contacted). Maximum time before applying clearcoat: 3 days

Shelf life	Shelf Life (5-35°C) (months)
Imron® HydroBaseCoat 8200	12 months
Imron® HydroBaseCoat HB202 Activator Standard	24 months

<p>Safety</p> <p>Consult the Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.</p>
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Technical Data Sheet

Imron® HydroBaseCoat 8200

Waterbased Basecoat



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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