Technical Data Sheet

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

Description

Imron® HydroTopCoat 7200 is a 2-component waterbased polyurethane topcoat system specially developed for application on busses, trailers, constructors and other utility vehicles.
Composition based on acrylic resin.

Products

Imron® HTC 7200	Imron® HydroTopCoat 7200
HT800	Imron® HydroTopCoat PUR Brilliant Binder
HT802	Imron® HydroTopCoat PUR Matt Binder
HT803	Imron® HydroTopCoat Large Surface Binder CV
HTXX	Imron® HydroTopCoat Tint
HT202	Imron® HydroTopCoat Activator Standard
HT204	Imron® HydroTopCoat Activator High Temperature
HT300	Imron® HydroTopCoat Reducer
HT310	Imron® HydroTopCoat Spot Repair Reducer

Colours

Industrial and standard colour registers.

Properties

- Broad application window and fast drying.
- Offers different gloss levels.
- Combines low material consumption with good sagging resistance and final appearance.
- Has excellent mechanical, chemical and weather-resistance.

Substrates

- Cured, solvent resistant, well preserved and scuff sanded OEM or old finish.
- Primed surface.
- Cleaned and pretreated thermoplastics and different types of GRP (see section ‘Remarks’).

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

Surface preparation
• OEM and old finish: sanded and degreased. • Primer / Filler: according their specifications • Degrease before recoating.

Theoretical VOC – ready for use (RFU) at maximum dilution	
• White	201 g/l
• Black	188 g/l

Product preparation

Mixing Ratio		**Volume**	**Weight**
	Imron® HTC 7200 HT202/HT204 Stir well with powered mixer.	3 1	100 34
Thinner	HT300		
Pot life at 20°C	2 hours		
Recommended dry film thickness	40-50 µm		

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

Application

	Application viscosity DIN 4 at 20°C (s)	Thinner (%)	Spray nozzle (mm)	Pressure (bar)	Number of coats
Gravity Feed **Suction Feed** (High pressure spraying)	21-22	10-15	1.2-1.6	3-4	2
HVLP **HVLP** (Low pressure spraying)	21-22	10-15	1.2-1.4	0.7	2
Pressure pot **Feed pump** (high pressure spraying)	21-22	10-15	1.0-1.2	3	2
Airless **Airmix**	25-50	0-5	Airless 0.23 0.28 Airmix 0.23	170-200 3-4 (air) min.120 (material)	1.5
Electrostatic	According to the advice of the Axalta Technical Representative. The use of an isolated installation is needed.				

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

Drying

Air drying at 20°C	
Dust dry	1-2 hours
Flash off between coats:	20 minutes at 20°C with ventilation ON
Dry to handle	Overnight
Dry	Overnight

Forced drying	Flash time: 45 minutes, with ventilation ON
Drying time	20 - 30 minutes
Drying temperature	60 - 80°C object temperature

Recoatability

Recoatable with itself and with Axalta 2K Clearcoat (waterbased or solventbased) according to the advice of the Axalta Technical representative.

Product data

Package viscosity	Colour dependent
Flash point	> 95°C

	Solids	**Density**	**Theoretical coverage**		**Theoretical material consumption**	
	Weight (%)	(kg/l)	(at 40 µm)		(at 40 µm)	
RFU at max. dilution	+/- 1	+/- 0.01	m^2/l	m^2/kg	ml/m^2	g/m^2
White	49	1.17	9.6	8.2	104	122
Black	39	1.04	8.8	8.4	115	119

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

Remarks

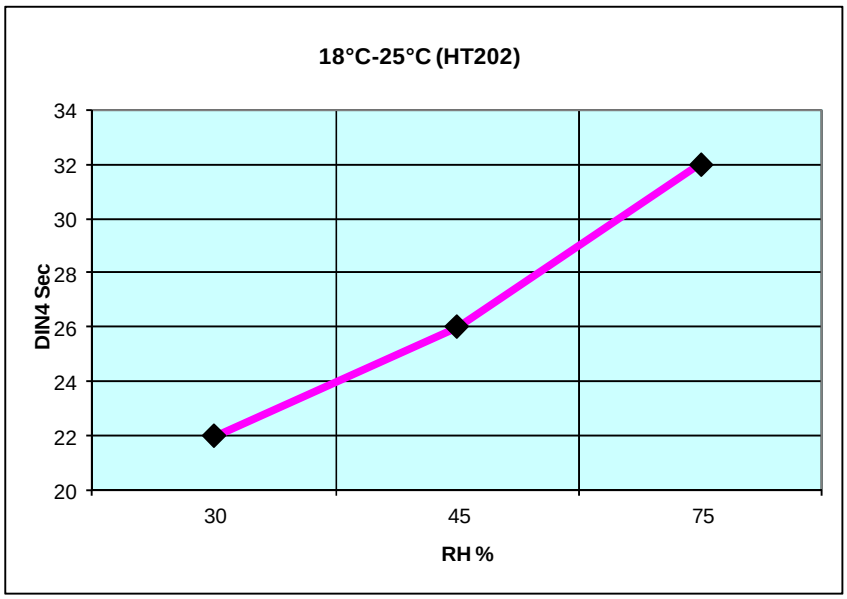
	• Stir tints and binders thoroughly before use. • Stir the mixture well after the weigh-out of the components. • Before adding HT300 for viscosity correction, the activator has to be accurately mixed-in into the paint with a mechanical mixer for 3 to 4 minutes. • Preferably, a blade of 1/3 the size of the container is used. • Avoid air entrapment while stirring.
	• Before application a colour comparison is recommended.
Remark	• The spray equipment has to be from stainless steel. All stirring rods / containers in use have to be from stainless steel or plastic. • 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. • 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.

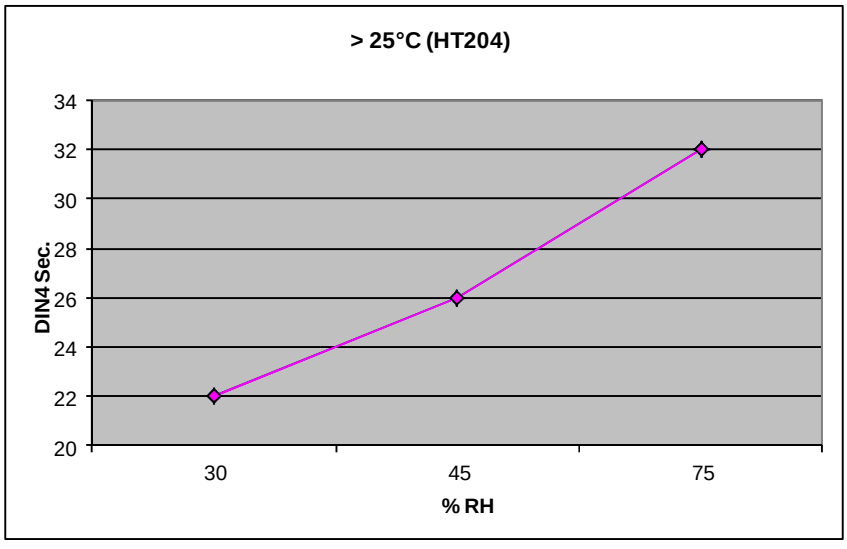
Data	**Shelf Life (5-35°C)** (months)	**Density** (kg/l) +/- 0.01	**Theoretical VOC** (g/l)
Imron® HTC 7200	18	1.00-1.35	60-100
HT800	24	1.04	166
HT802	12	1.15	67
HT803	6	1.05	109
HTXX	36	1.05-1.56	-
HT32/HT47/HT54	18	1.05-1.56	-
HT202	36	1.04	437
HT204	24	1.08	454
HT300	24	1.00	0
HT310	60	0.85	846

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

Special Remark	• Depends on humidity, temperature and object size, following viscosity/activator can be suggested.





Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

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.

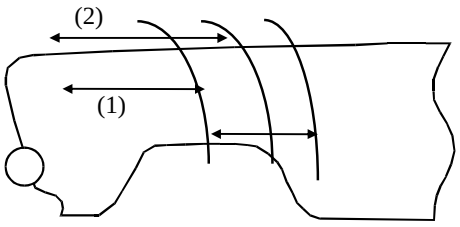
1.	I7200	4
2.	HT202	1
3.	HT310	5

Fade-out method

1 Apply 1st coat Imron® HTC 7200.
Flash time: 5 min.

2 Apply 2nd coat Imron® HTC 7200 beyond the previous one.

3 Smoothen out the fade-out area with HT310.



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.

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

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.
This Technical Data Sheet supersedes all previous issues.