Addendum to Technical Data Sheet

Imron® HydroTopCoat 7200

2K Waterbased Topcoat PUR

CUSTOMER: UK RAIL

Description

Imron HydroTopcoat 7200 is a 2-component waterbased polyurethane anti-graffiti topcoat system specially developed for application on trains and other railway vehicles. Composition based on acrylic resin.

Products

Imron® HTC 7200	Imron® HydroTopCoat 7200
HT200	Imron® HydroTopCoat Activator Fast
HT201	Imron® HydroTopCoat Activator Standard
HT204	Imron® HydroTopCoat Activator High Temperature
HT300	Imron® HydroTopCoat Reducer
HT310	Imron® HydroTopCoat Spot Repair Reducer

Properties

- Excellent adhesion
- High mechanical and chemical resistance
- Available in a variety of colour and gloss levels
- Easy application
- Excellent anti-graffiti performance
- High durability and ease of maintenance and cleaning

Substrates

- 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

- OEM and old finish: sanded and degreased.
- 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® HTC 7200	2.5	100
	HT200/HT201/HT204	1	40
	Stir well with powered mixer.		
Thinner	HT300		
Pot life at 20°C	4 hours		
Recommended dry film thickness	40 – 60 µ		

Application

	Application viscosity DIN 4 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		
HVLP **HVLP** (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	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

Recoatability

Recoatable	Recoatable with itself and with Axalta solventbased and waterbased topcoats according of 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 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

	• Stir filler thoroughly before use for 3 to 4 minutes. • 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 the substrates need to be cleaned with a waterbased silicon remover.
Remarks	• 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.

	Shelf Life (5-35°C) (months)	**Density** (kg/l) +/- 0.01	**Theoretical VOC** (g/l)
Imron HTC 7200	24	1.00-1.35	60-100
HT201	24	1.07	448
HT204	24	1.08	454
HT310	60	0.85	846

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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.

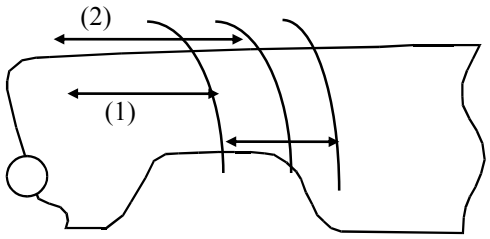
1.	I7200	2.5
2.	HT201	1
3.	HT310	5

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.

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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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