Topcoat

Single-Stage Solid Topcoat

Product Description

Double component solid colours for repairing automotive finishes. Mix at 2:1

Technical Characteristics

Colours: mixing system Shelf life: 48 months at 25°C Theoretical spreading rate: 260 m²/l (avg) at 1 µm

Pre-treatment

Wet flat with P600-800 grade paper or dry flat with P400-500 grade paper.
Degrease with HAMR PREPSOLVE.
Wash off residues and dry thoroughly.
Re-clean with HAMR PREPSOLVE. The use of a tack rag is recommended.

Mixing Ratio

Stir well before use. Twice per day for 15 min on the mixing machine.

2K Solid Colours	**2**	100 (vol)	depending on colour
9788 Hardener	**1**	50 (vol)	
950 Thinner	20-30%	20 – 30 (vol)	

Mix well and strain before application.
Note: 9688/940 is for temperatures beneath 15°C
9788/950 is for temperatures between 15°C – 25°C
9888/960 is for temperatures above 25°C
970 Thinner is for temperatures above 35°C or when refinishing large surfaces.

Spray Viscosity

14 to 17 seconds DIN 4 cup at 25°C

Potlife

3-4 hours at 25°C

Sprayguns

HVLP gravity-feed spray gun	1.2–1.3 mm	1.8–2.0 bar	10–15 cm
Conventional gravity-feed spray gun	1.3–1.6 mm	3.0–4.0 bar	15–20 cm

Application

Apply topcoat over sound finishes or over grey primers.
Number of coats: 1 half wet + 1 wet coat
Flash-off: 10 mins
Film thickness: 40–50 µm

Drying

Drying	25°C	60°C
Dust free after	40 mins	5 mins
Ready for assembly after	6 hours	30 mins
Ready for polish after	24 hours	60 mins

IR Drying

IR drying after flash-off time:
Step 1–short wave: 5 mins at a 80 cm distance
Step 2–medium wave: 20 mins at a 80 cm distance

Further Treatment

Polish after specified drying times and cooling.