

# ALPHAGAM

## TECHNICAL DATA SHEET

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Topcoats TDS  
**2K PU TC RAL 9006**

**2K PU TOPCOAT RAL 9006 (4:1)**  
40% GLOSS

## PRODUCT INFO

**2K PU TOPCOAT RAL 9006 HS** one-coat aluminium lacquer for high-quality coatings of semi-trailer, utility vehicles, machines, etc. The very high high-solid content (HS quality) allows durable high-gloss coatings. The special pigmentation ensures furthermore a safe application without clouding. Very good weather resistance, high resistance against chemical and mechanical stresses.

**Approx Coverage: 10 – 12 m<sup>2</sup>/l at 40 - 50 µm DFT**

## SURFACE PREPARATION

Steel surfaces to be coated must be clean and free from grease. For maximum protection, it is essential to pre-treat components prior to the application of **2K PU TOP COAT RAL 9006**. Iron phosphate and zinc phosphate of ferrous metals improve corrosion resistance.

Aluminium substrate may require a chromate conversion coating.

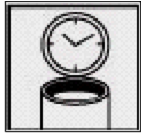


## Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
HVLP Spray Gun	2 - 2.5	1.3 - 1.4	1 - 2	0 - 30
Air / flow cup spray gun	2 - 2.5	1.3 - 1.4	1 - 2	0 - 30

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**Pot life :**

1 – 3 hr depends on the used hardener:  
1 hr with 1-UP 2K PU MS & HS Standard Hardener @ 30°C  
2 hrs with 1-UP 2K PU MS & HS Medium Hardener @ 30°C  
3 hrs with 1-UP 2K PU MS & HS Slow Hardener @ 30°C



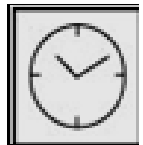
**Hardener :**

1-UP 2K PU MS Hardener  
1-UP 2K PU HS Hardener



**Thinner :**

1-UP 2K PU Standard Thinner @ 0 - 30%  
1-UP 2K PU Medium Thinner @ 0 - 30%






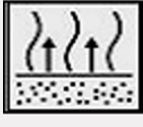

**Drying time :**

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatible
30°C	30 - 45 min	2 - 3 h	6 - 8 h	NA	NA
60°C	NA	30 min	After cooling-off	NA	NA

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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**Technical Information**

	<p><b>Colour :</b> <b>RAL 9006</b></p>						
	<p><b>Mixing Ratio :</b></p> <table border="1" data-bbox="483 776 1399 968"> <thead> <tr> <th data-bbox="483 776 1047 844">Hardener</th> <th data-bbox="1047 776 1399 844">By volume</th> </tr> </thead> <tbody> <tr> <td data-bbox="483 844 1047 906">1-UP 2K PU MS Hardener</td> <td data-bbox="1047 844 1399 906">4:1</td> </tr> <tr> <td data-bbox="483 906 1047 968">1-UP 2K PU HS Hardener</td> <td data-bbox="1047 906 1399 968">3:1</td> </tr> </tbody> </table>	Hardener	By volume	1-UP 2K PU MS Hardener	4:1	1-UP 2K PU HS Hardener	3:1
Hardener	By volume						
1-UP 2K PU MS Hardener	4:1						
1-UP 2K PU HS Hardener	3:1						
	<p><b>Spraying Viscosity :</b> <b>18 - 20 s 4mm DIN</b></p>						
	<p><b>Flash Off Time :</b> <b>10 - 15 min between each coats.</b></p>						
	<p><b>Dry Coat Thickness :</b> <b>40 - 50 µm</b></p>						

<p><b>Storage :</b></p>	<p><b>1year from the date of manufacturing at 30° C, if stored in a dark dry place in a tightly closed container.</b></p>
<p><b>VOC Regulation :</b></p>	<p>EU limiting value for the product (cat. B/e): 840 g/l This product contains max. 534 g/l VOC</p>
<p><b>Processing Conditions :</b></p>	<p>From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.</p>

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