

Topcoat

Single-Stage Solid Topcoat

Product Description

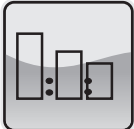





Double component solid colors for repairing automotive finishes.

Technical Characteristics

Color: 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 IC-800.
Wash off residues and dry thoroughly.
Re-clean with IC-800. The use of a tack rag is recommended.

	Mixing Ratio	<p>Stir well before use. Twice per day for 15 min on the mixing machine.</p> <table><tr><td>IC-2K Solid Colors</td><td>100 (vol)</td><td colspan="3">depending on color</td></tr><tr><td>IC-9788 Hardener</td><td>50 (vol)</td><td colspan="3"></td></tr><tr><td>IC-950 Thinner</td><td>20-30 (vol)</td><td colspan="3"></td></tr></table> <p>Mix well and strain before application.</p> <p>Note: IC-9688/IC-940 is for temperatures beneath 15°C IC-9788/IC-950 is for temperatures between 15°C – 25°C IC-9888/IC-960 is for temperatures above 25°C IC-970 Thinner is for temperatures above 35°C or when refinishing large surfaces.</p>				IC-2K Solid Colors	100 (vol)	depending on color			IC-9788 Hardener	50 (vol)				IC-950 Thinner	20-30 (vol)			
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	Spray Viscosity Potlife	<p>14 to 19 seconds DIN 4 cup at 25°C 3-4 hours at 25°C</p>																		
	Sprayguns	<p>HVLP gravity-feed spraygun</p> <p>Conventional gravity-feed spraygun</p>	<p>1.2–1.3 mm</p> <p>1.3–1.6 mm</p>	<p>1.8–2.0 bar</p> <p>3.0–4.0 bar</p>	<p>10–15 cm</p> <p>15–20 cm</p>															
	Application	<p>Apply topcoat over original stoved finishes or over IC-981 grey primers.</p> <p>Number of spraycoats: 1 half wet + 1 wet coat</p> <p>Flash-off: 10 mins</p> <p>Film thickness: 40–50 µm</p>																		
	Drying	<p>Drying</p> <p>Dust free after</p> <p>Ready for assembly after</p> <p>Ready for polish after</p>	<p>25°C</p> <p>20 mins</p> <p>6 hours</p> <p>24 hours</p>	<p>60°C</p> <p>5 mins</p> <p>30 mins</p> <p>75-110 mins</p>																
	IR Drying	<p>IR drying after flash-off time:</p> <p>Step 1–short wave: 5 mins at a 80 cm distance</p> <p>Step 2–medium wave: 20 mins at a 80 cm distance</p>																		
Further Treatment		<p>Polish after specified drying times and cooling.</p>																		

The products are suitable for professional use only. The data contained in this publication are based on our current knowledge and experience. You can obtain the latest version of technical data sheet from our website at www.wonder-global.com or directly from your supplier.