

Topcoat HS 420





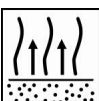


Single Stage Topcoats

08/11/2019

L1.03.03 UK & Ireland

DESCRIPTION

Two component, high solid, mixing machine-based polyester/acrylic topcoat. Available in a wide variety of direct gloss/solid colors. Specifically designed for refinishing of passenger cars. Full range of supporting ancillary items enable the product to be used successfully, with a VOC content of 420 grams/liter

Mixing ratio		5 2 1	Topcoat HS 420 HS Hardener 420 Thinner 420
Mixing stick		N	
Equipment		Spray gun set up: 1.2-1.4mm	Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.6-0.7 bar at the air cap
Application		½ + 1 coat	
Flash-off		Between coats 1-3 minutes at 20°C	Before curing 1-3 minutes at 20°C
Drying			20°C 60°C 11 hours 30 min
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator	

Read complete technical data sheet for detailed product information

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PRODUCT AND ADDITIVES

Product Topcoat HS 420

Hardener HS Hardener 420

Thinner Thinner 420

Chemical Basis	Topcoat HS 420 HS Hardener 420	Acrylic and Polyester resins Polyisocyanate resins
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METHOD OF USE

Substrates Sound original finishes, including thermoplastic acrylic
Polyester laminates
1K Plastic Primer (RTS)
1K Multi Plastic Primer (RTS)
2K Universal Plastic Primer
1K Etch Primer (RTS)
1K Primer Filler RTS
2K HS Primer Filler
2K Graphite Filler
2K Filler 540 (RTS)
2K High Build Filler
2K Epoxy Primer

Substrate preparation Thoroughly clean the surface with Lesonal Degreaser.
Sand with P500 grit dry.
Degrease with Lesonal Degreaser.

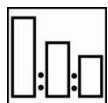
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Mixing ratio



- 5 Topcoat HS 420
- 2 HS Hardener 420
- 1 Thinner 420

Mixing stick N

Spraying viscosity 17-21 sec DIN Cup 4 at 20°C

Potlife 2 hours at 20°C

Spray gun set up



Spray gun:
HVLP Gravity
LVLP/HR Gravity

Fluid opening:
1.2-1.4 mm
1.2-1.4 mm

Spraying pressure:
0.7 bar (at air cap)
1.7-2.2 bar (at air inlet)

Refer to user manual spray gun used

APPLICATION TECHNIQUE

Application



Apply an even, light flowing coat. Flash off time for 1-3 minutes at 20°C.
Next apply a wet flowing coat.

Layer thickness 45 – 65 microns

Equipment cleaning Use Multi Thinners or nitro cellulose thinner

Drying



	20°C	60°C
Dust free	1 hr	10 min
Dry to handle	11 hrs	30 min
Infrared short wave	Half power 5 min	Full power 6-9 min

Material usage Ready for use mixture at 1 µm layer thickness : 385 m²/liter

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Product storage	Avoid extreme temperature fluctuation and high humidity levels
Shelf life	All toners 4 years at 20°C 01 Gloss Reducer 2 years
VOC	2004/42/IIB(d)(420)420 The EU limit value for this product (product category : IIB.d) in ready to use form is max. 420 g/l VOC. The VOC content of this product in ready to use form is max. 420 g/litre.
Ancillaries	Gloss Reducer 01 : TDS L1.08.06 Topspeed : TDS L1.08.04

Akzo Nobel Coatings LTD

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FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE: The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfil the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give, or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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