



INTERCOACH 5000

DESCRIPTION

Thermoformable waterborne UV-resistant acrylic topcoat designed for application on a wide variety of substrates in railways interiors. It does not affect impact resistance of plastics (no stress-crazing).

PRETREATMENT

1. Clean dry with Scotch Brite Red Type A very fine.
2. Remove dust by using air pressure or clean cloth.
3. Degrease with isopropanol or other approved solvent.
4. Check result with water-break test (water drop has to spread out).

APPLICATION

Any usual spray equipment.
Pneumatic equipment with nozzle orifice 1.6-2.0 mm.
Airless with a nozzle orifice 0.013 inch.
Spray viscosity (20°C):
40 seconds DIN Cup 4
20 seconds ZAHN Cup 3
27 seconds ISO Cup 6

OPTIMAL WORKING CONDITIONS

Temperature	15-35°C (60-95°F)
Relative humidity	10-80%

CLEANING EQUIPMENT

Clean equipment immediately after use with water.

PRECAUTIONS

Use masks and respiratory devices.
See SDS for further detailed information.

DRYING TIMES (T=25°C/R.H.55%) (ASTM D5895)

Set to touch:	5 minutes
Tack free:	9 minutes
Dry hard:	11 minutes
Dry through:	14 minutes
Full cure:	3 days

Flash off time between coats or before oven cure: 15-30 minutes.

COLOURS	Most colours are available.	
DENSITY(*)	1.05-1.20 kg/L	8.8 – 10.0 lb. /gal.
VOC (ASTM D3960)	240-270 g/L less water	2.00 – 2.26 lb. /gal less water
SOLIDS CONTENT (ASTM D5201)	38-43 % by weight 33 -35 % by volume	
THEORETICAL SPREADING RATE	6.6 – 7.0 m ² /L @ 50 microns	
PACKAGING	1 kg 5 kg 1 Gallon	
STORAGE STABILITY	In closed containers and at T=5-25°C (41-77°F); 2 year.	

(*) depending on colour.

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