



## INTERCOACH 5100

### DESCRIPTION

Waterborne one component acrylic spatula filler for surface repair of Railways interior panels. INTERCOACH 5100 shows excellent performance on honeycomb panels, polycarbonate, PES, composites and most commonly used synthetic materials, as well as on metals. INTERCOACH 5100 is specially formulated to fill up general surface porosity and/ or light scratches. In some cases, a primer must be applied first to assure a good adhesion of the filler.

### SPECIFICATIONS

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### 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).

Prior to the application of the INTERCOACH 5100 a thin layer of INTERCOACH 5075 PC or 750 M may be sprayed to improve the adhesion and to obtain an easier spreading of the filler.

### APPLICATION

Apply with clean, plastic or metal spatula in consecutive layers with sanding in between. The layer thickness per coat should not exceed 0.2-0.3 mm. Dry sand after minimum 15 - 30 minutes depending on layer thickness and drying conditions.

### 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 gloves to protect hands.  
See SDS for further detailed information.

**DRYING TIMES  
(T=25°C/R.H.55%)**

Flash off time between coats or before oven cure: 10 minutes.  
Can be sanded after 10 minutes oven cure at 60-70°C (140-160°F).

**COLOURS**

White other colours on request.

**DENSITY**

1.60-1.62 kg/L

13.4-13.6 lb. /gal.

**VOC (ASTM D3960)**

60-70 g/L less water

0.50-0.60 lb. /gal less water

**SOLIDS CONTENT  
(ASTM D5201)**

74% by weight

58% by volume

**THEORETICAL  
SPREADING RATE**

11.6 m<sup>2</sup>/L @ 50 microns

7.2 m<sup>2</sup>/kg @ 50 microns

**PACKAGING**

200 g tubes

1 kg

**STORAGE STABILITY**

In closed containers and at T=5-25°C (41-77°F):

- 6 months (1kg)

- 12 months (200g tubes)

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