



INTERCOACH 5200

DESCRIPTION	Low VOC, water borne 2-pack PU-acrylic primer, designed to meet the OEM requirements		
SPECIFICATIONS	/		
PRETREATMENT	<div>1. Clean dry with Scotch Brite Red Type A very fine.</div> <div>2. Remove dust by using air pressure or clean cloth.</div> <div>3. Degrease with isopropyl alcohol or other approved solvent.</div>		
MIXING RATIO	<div>By weight:</div> <div>INTERCOACH 5200 100 g</div> <div>INTERCOACH 5801 12 g</div> <div>Water fill spray viscosity +/-15g</div>	<div>By volume:</div> <div>INTERCOACH 5200 6 parts</div> <div>INTERCOACH 5801 1 part</div> <div>Water fill spray viscosity +/-0.7 part</div>	
	<div>While stirring thoroughly add hardener first, followed by water to obtain spray viscosity. Always verify spray viscosity.</div> <div>DO NOT ADD WATER DIRECTLY TO INTERCOACH 5801.</div>		
APPLICATION	<div>Any usual spray equipment.</div> <div>Pneumatic equipment with nozzle orifice 1.8-2.0 mm.</div> <div>Airless with a nozzle orifice 0.013 inch.</div> <div>Spray viscosity (22°C):</div> <div><div>-45 seconds DIN Cup 4</div><div>-22 seconds ZAHN Cup 3</div><div>-31 seconds ISO Cup 6</div></div>		
OPTIMAL WORKING CONDITIONS	<div>Temperature</div> <div>Relative humidity</div>	<div>15-35°C (60-95°F)</div> <div>10-80%</div>	
CLEANING EQUIPMEN	Clean equipment immediately after use with water.		
PRECAUTIONS	<div>Use masks and respiratory devices.</div> <div>See SDS for further detailed information.</div>		
DRYING TIMES	<div>Set to touch:</div> <div>Tack free:</div>	<div>8 minutes</div> <div>12 minutes</div>	
(T=25°C/R.H.55%)			

(Dry time recorder

Dry hard: 25 minutes
Dry through: 2 hours
Full cure: 7 days
Flash off time between coats: 20-30 minutes.
Flash off time before oven cure: minimum 40 minutes (50µm dry).
Oven cure (50°-60°C): minimum 2 hours.

COLOURS

-Off white (colours vary batch to batch)
-Pastel and medium-dark colours are also available.

DENSITY

INTERCOACH 5200:	1.50-1.55 kg/L	12.5-13.0 lb. /gal.
INTERCOACH 5801:	1.10 kg/L	9.2 lb. /gal
Base + hardener:	1.45-1.49 kg/L	12.1-12.4 lb. /gal
Base + hardener + water:	1.40-1.43 kg/L	11.7-12.0 lb. /gal

VOC (ASTM D3960)

90-110 g/L less water	0.75-0.92 lb. /gal less water
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**SOLIDS CONTENT
(ASTM D5201)**

Base + hardener:	73% by weight	62% by volume
Base + hardener + water:	64% by weight	51% by volume

THEORETICAL

Base + hardener:	12.4 m ² /L @ 50 microns
	8.3-8.6 m ² /kg @ 50 microns

SPREADING RATE

Base + hardener + water:	10.2 m ² /L @ 50 microns
	7.1-7.3 m ² /kg @ 50 microns

POT LIFE

4 hours depending on ambient temperature. Do not apply after potlife is expired. Do not add leftovers to fresh base coat.

PACKAGING

1 kit = 4 kg	INTERCOACH 5200	+
0.48 kg l	INTERCOACH 5801	

STORAGE STABILITY

In closed containers and at T=5-25°C (41-77°F): 1 year.

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