

Acrylic Topcoat X

Technical Data Sheet: 450-5X
X series

1. Introduction

ALEXSEAL Acrylic Topcoat X is a two-component topcoat combining the latest acrylic and polyester technology. Designed for the yachting industry, the ALEXSEAL Acrylic Topcoat X offers a very high gloss and exceptional depth of image.

The product is easy to apply and shows a very good leveling. After a short curing period, ALEXSEAL Acrylic Topcoat X can easily be sanded and polished. It offers excellent color stability values and additional resistance to UV rays, salt water, abrasion and fuel.

2. Range of application

ALEXSEAL Acrylic Topcoat X is easy to buff / polish after curing. It can be used on external areas, which are not subject to permanent water immersion.

3. Color

ALEXSEAL Acrylic Topcoat X is available in standard factory packaged colors and, upon request, in custom colors. Refer to the color card or product overview for part numbers.

4. Coverage

Volume Solids catalyzed without reduction: clear 47 %, whites 60 %, colors 57 %.

Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	@ DFT in μm (mils)
Theoretical / Brushing and Rolling	8.6	34	350	70 (3)
Practical				
Conventional Air Spray Equipment	5.2	20	210	70 (3)
HVLP Air Spray Equipment	6.5	25	263	70 (3)

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust, grease, oil, and other contamination. To achieve optimum performance and adhesion ALEXSEAL Finish Primer 442 is recommended. Final sanding of ALEXSEAL Finish Primer 442 should be smooth sanded with 320 grit sand paper.

ALEXSEAL Topcoat should be applied within 4 days, 2 days if outside after sanding to ensure adhesion. For inside applications talk about extended times with your sales rep.

6. Trade names & Packaging

X....	ALEXSEAL Acrylic Topcoat X (Base Color)	1 QT & 1 Gal
C5120	ALEXSEAL Acrylic Topcoat X Converter Spray	1 Pt & ½ Gal
C5012	ALEXSEAL Topcoat Converter Brush	1 Pt & ½ Gal
R5030	ALEXSEAL Topcoat Reducer Slow (spray)	1 QT & 1 Gal
R5050	ALEXSEAL Topcoat Reducer Medium (spray) – for cold conditions or small objects only	1 QT & 1 Gal
A5035	ALEXSEAL Topcoat Accelerator	4 Ounces

7. Mix Ratio Spray

2 parts by volume	T....	ALEXSEAL Acrylic Topcoat X (Base Color)
1 part by volume	C5120	ALEXSEAL Acrylic Topcoat X Converter Spray
40 to 60 % by volume	R....	ALEXSEAL Topcoat Reducer (choose from list above)
Example: 2 : 1 : 1.5 = 50% reduction		

The amount of reducer required may vary depending on the application conditions.

Mixed material must be filtered before application with 25μm paint filter.

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8. Application

Viscosity Zahn #2 Signature Cup: ≈ 18 - 22 sec, DIN 4 cup 4mm: ≈ 14 - 18 sec,

ISO 3mm ≈ 55-65 sec

Nozzle Size Gravity Gun 1.0 to 1.4 mm (0.039 to 0.055) - Conventional & HVLP

Nozzle Size Siphon Cup 1.6 mm (0.063) - Conventional & HVLP

Fluid Nozzle Size Pressure Pot 1.0 to 1.3 mm (0.039 to 0.051) - Conventional & HVLP

Atomizing Pressure 3.0 to 5.0 bar (42 to 60 PSI) - Conventional & HVLP

Pot Pressure 0.7 to 1.5 bar (10 to 20 PSI) - Conventional & HVLP

Airmix Equipment 0.18 to 0.28 mm (0.007 to 0.011)

Inlet pressure 3.0 to 5.0 bar (42 to 70 PSI)

Application by Spraying:

Spray apply 2 coats to a wet film thickness (WFT) of 50 - 75 microns (2 - 3 mils) per coat. Allow 20 - 60 minutes tack up between coats. This will achieve a dry film thickness (DFT) of 40 - 60 microns (1.5 - 2 mils) for a 2 coat application. Maximum recommended film thickness during a spray application is 3 coats totalling 300 microns (12 mils) WFT, or 100 microns (4 mils) DFT.

Accelerator:

ALEXSEAL Topcoat Accelerator is used to reduce the drying time of ALEXSEAL Acrylic Topcoat X. Per each mixed (catalyzed and reduced) 2 quarts (2 liters) of ALEXSEAL Acrylic Topcoat X, a maximum of 3 caps or 30 ml (1 ounce) of ALEXSEAL Topcoat Accelerator may be added. Additional quantities of accelerator reduce pot life, and are not recommended.

Polishing:

Alexseal Acrylic Topcoat X may be polished. In some cases, it may be necessary to restore the finish / gloss of the surface after a certain time.

Make sure the polishing is done by an experienced person and follow the following process:

- Sand the area first with 1500 and then with 3000 3M Trizact grit wet. Optional to reduce sanding marks: Sand with 6000 3M Trizact grit wet afterwards.
- Polish with 3M Perfect-it Fast Cut XL Coarse Compound (51052 green lid) or 3M Perfect-it Fast Cut PLUS Compound Coarse (50417 green lid) with 3M Perfect-it Green Foam Pad (50499/50962/50874) (or similar).
- Cleaning with 3M High Performance Microfibre Cloth Green (02010) (or similar).
- Then use 3M Perfect-it Finish Control Spray (55535) with Scotch-Brite High Performance Microfibre Cloth White (02010) (or similar).
- Polish with 3M Perfect-it Extra Fine PLUS Polish (80349 yellow lid) with 3M Perfect-it Yellow Foam Pad (50879/50875/50536) (or similar).
- Cleaning with 3M Perfect-it High Performance Ultra Soft Yellow Cloth (50400) (or similar).
- Optional for dark colors use 3M Perfect-it III Anti-Hologram Compound (50383) with 3M Perfect-it Blue Foam Pad (50880/50708/50457) (or similar).
- Cleaning with 3M Perfect-it III Anti-Hologram cloth (50486) (or similar).

Protect the buffed area with A5010 Alexseal Premium Polymer Sealer (or similar) every 4-6 weeks.

For more detailed information please have a look at our polishing poster

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10. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life - approx.	6 hrs	4 hrs	3 hrs	2 hrs	N/A
Pot Life - with ALEXSEAL Accelerator	3 hrs	3 hrs	2 hrs	2 hrs	N/A
Dust Free	90 min	60 min	45 min	30 min	N/A
Polishable - without accelerator	36 hrs	30 hrs	24 hrs	18 hrs	N/A
Tape Dry - without ALEXSEAL Accelerator	30 hrs	24 hrs	18 hrs	12 hrs	N/A
Tape Dry - with ALEXSEAL Accelerator	18 hrs	12 hrs	9 hrs	6 hrs	N/A
Fully Cured - without accelerator	21 days	18 days	14 days	10 days	N/A
Spray Recoat after tack up with additional coats of ALEXSEAL Acrylic Topcoat X	90 min	60 min	45 min	30 min	16 hrs
Brush/Roll Recoat after tack up with additional coats of ALEXSEAL Acrylic Topcoat X	12 hrs	8 hrs	6 hrs	6 hrs	24 hrs
Overcoat with another product. Preparation including sanding is required after max. time	24 hrs	24 hrs	18 hrs	12 hrs	24 hrs

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will affect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.

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