



ICF - ISOCYANATE FREE TOPCOAT

PRODUCT DESCRIPTION

Commercial Performance Coatings Isocyanate Free is an Isocyanate Free two component topcoat, with excellent gloss retention and resistance to weathering.

Commercial Performance Coatings Isocyanate Free Topcoat is available in a range of colours from the AS2700 and RAL Classic colour ranges as well as a range of gloss levels.

PRODUCTS

CPC Isocyanate Free Topcoat Mixed Colour		ICF Mixed Colour
Hardener		ICH20 Pack B Normal
Reducers	<i>Normal conditions</i> <i>Hot conditions</i>	ICR20 Isocyanate Free Reducer Normal ICR30 Isocyanate Free Reducer Slow
Cleaners		971-9119 PROTEC® Metal Conditioner AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



CPC Isocyanate Free Topcoat can be applied over the following primers:

- EPS Etch Pro, VIN Vinyl Etch, PAR Paraloc
- EPO Epotec Primer Surfacer, BAR Barrierprime, SLX Self Levelling Epoxy Primer
- *NOTE: A sympathetic tintable primer is recommended for colours such as Yellows, Reds and Oranges.

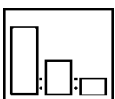


Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

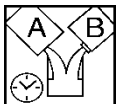
For other primer options please consult the PPG LIC Technical Team.

MIXING RATIO BY VOLUME



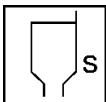
PRODUCT	PARTS
ICF Mixed Colour	4
Hardener	1
Reducer	30 - 40% (gloss colours) 50 - 60% (matt colours)

POT LIFE



Catalysed material is useable for up to 8 hours at 25°C

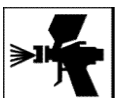
SPRAY VISCOSITY



CONVENTIONAL, HVLP 20 - 25 seconds (DIN 4) at 25°C

AIRLESS, AIR ASSISTED AIRLESS 25 - 30 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.4 mm - 1.6 mm
- SUCTION 1.6 mm - 1.8 mm

SPRAY PRESSURE

- CONVENTIONAL 2.0 - 2.5 bar (200 - 300 kPa, 30 - 36 psi)
- HVLP / RP 2 - 3 bar



AIRLESS, AIR ASSISTED AIRLESS

SETUP

- TIP 0.007 - 0.011
- PUMP RATIO 32:1

SPRAY PRESSURE

- AIRLESS 100 - 140 bar
- AIR ASSISTED AIRLESS 70 - 100 bar

APPLICATION & FLASH OFF



CONVENTIONAL, HVLP 2 - 3 wet, even coats

AIRLESS, AIR ASSISTED AIRLESS 2 wet, even coats

Allow 5-10 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80%, or if the surface temperature is within 3°C of the dew point.

DRYING TIMES



AIR DRY (25°C)

- TOUCH DRY: 30 minutes
- HARD DRY: 8 hours

BAKE (65°C)

40 minutes

Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied. Full cure will be achieved after 7 days.

RECOAT



Recoat after a minimum of 12 hours. Recommendations are based on 25°C ambient temperature.

If recoating after 24 hours, the coating must be lightly abraded and degreased prior to painting.

Aged films must be free of chalk and dirt (abraded and degreased) before recoating.

TOTAL DRY FILM BUILD

40 - 60 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS	45%, depending on colour
COVERAGE	9.0 metres squared per litre (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	Very Good
ABRASION	Good
SOLVENT	Good to splash and spillage for common solvents
CHEMICAL	Good to splash and spillage for mild chemicals
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	Not recommended

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

**PPG Industries Australia Pty Ltd, 14 McNaughton Rd
Clayton, V.I.C. 3168 Australia**

EMERGENCY RESPONSE NUMBER, Australia: 1800 883 254

**PPG Industries New Zealand Pty Ltd, 5 Vestey Dr, Mt Wellington
Auckland, New Zealand**

EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096

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