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PRODUCT DATA SHEET

PRODUCT: **TOPSHIELD 2K**
High-performances heat curing one component coating

CODE: **COMP. A C3760X TOPSHIELD 2K**
COMP. B CC760E - TOPSHIELD ACTIVATOR

PRODUCT DESCRIPTION:

Topshield is a high-performances coating suitable for use in harsh environments. Topshield can offer withstanding scratch resistance thanks to the high content in ceramic components, as well as antifriction properties thanks to the presence of PTFE. The product is resistant to acid and basic aqueous solutions, lubricating oils and hydrocarbons even for long contact times. Topshield is extremely easy to use, has an excellent coverage and a pleasant semimatt finish. The product can be applied even on heat-sensitive substrates (such as Ergal or other precipitation hardened aluminium alloys) by simply reducing the curing temperature to 155°C for 60 minutes.

SURFACE PREPARATION:

Topshield can adhere to all metallic substrates, on chemical conversion coatings (phosphate conversions) and on anodized aluminium. To bring the performance level to the top it is suggested to accurately sandblast the surface at low incision profile ($Ra < 5\mu m$) by using 80-100 mesh corundum. The product must be applied strictly on dry surfaces, clean, perfectly free of oil, grease, dust, moisture or other contaminants.

APPLICATION METHODS:

Spraying by conventional air spray gun

APPLICATION INSTRUCTIONS:

	CONVENTIONAL SPRAY LOW PRESSURE PUMP	AIRLESS AIRMIX	
Nozzle diameter (mm)	1,5÷2,0	Pressure ratio	--
Product pressure (Atm)	1,0÷1,7	Nozzle diameter (inch)	--
Air pressure	2,5÷3,5	Product pressure (Atm)	--



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TECHNICAL DATA:

Mechanism of hardening	Heat curing
Specific weight (kg / l) *	1,2 (±8%)
Volume solids (%) *	43 (±1%)
Medium dry film thickness (microns)	30
Correspondence wet film thickness (microns)	70
Yield to the average or recommended thickness (m ² / kg) *	12
Yield to the average or recommended thickness (m ² / lt) *	14
Consumption at the average or recommended thickness (lt / m ²) *	0,1
Hard dry at 155 ° C (minutes)	60
Hard dry at 180 ° C (minutes)	30
Recommended application temperature (° C)	40
Max. nominal continuous service temperature (° C)	+5 ÷ +35
Mixing ratio by weight (Comp.A: Comp.B)	(4:1) 25%
Mixing ratio by volume (Comp.A: Comp.B)	(3:1) 33%
Thinner	6000760
Maximum dilution (% volume)	15%
Aspect of the film	Semi-matt
Color	On request
Storage in suitable conditions (months)	12
Storage after activation (months)	3

N.B.

* Data referred to colour black. The solid content values, specific weight and yield were calculated with theoretical method. Thickness and performance are only indicative, in fact vary greatly depending condition of substrate, dilution, absorption, porosity, surface irregularities and application method. Data referred to the mixture of component A + 25% by weight of Comp.B



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ADDITIONAL INFORMATION:

The product must be pre-activated. Before mixing the two components it is recommended to homogenize the component possibly with agitator and shake vigorously, possibly without opening, the packaging of component b. After mixing and addition of appropriate thinner, agitation should be continued until it became homogeneous. In order to use the correct mix ratio, necessary to obtain the best results, we recommend to mix only entire packs. In case you want to use only a portion of the pack, you should equip with adequate precision scale for mixing by weight and appropriate sized containers for mixing by volume. After the activation, the product is stable for three months. Before applying the heat treatment it is mandatory to let the coating dry in air at ambient temperature for 20 minutes. If this procedure is not performed, alterations in the aesthetic of the coating can occur.

IMPORTANT NOTE

All information contained in this form are the result of laboratory tests carried out under controlled conditions and well-defined and / or correspond to our most advanced and current technical and practical knowledge. this does not exempt the customer, given the variability of environmental conditions and personal systems of application, from carrying out their own investigations and to make their own eligibility checks. Mondial Color assumes no responsibility for any damage caused by improper use of the product. The values of specific weight, solids by volume and yields were calculated by theoretical methods. This sheet supersedes the previous editions.
