HEGGEL® Coat 198

Sustainable High-Gloss Polyurethane Topcoat

You Build, We Protect!

Description:

HEGGEL Coat 198 is a two-component, medium-solids, high-gloss polyurethane topcoat based on hydroxyl acrylate and aliphatic isocyanate. It is formulated as a sustainable finish for protection under critical climate and marine circumstances. The coating is designed for applications where high demands are set for colour and gloss retention.

Characteristics:

- Durable colour and gloss retention
- Topcoat in industrial epoxy and polyurethane coating systems
- Resistant to chemicals, weathering and mechanical impact
- VOC: 440 g/l

Application Areas:

HEGGEL Coat 198 is recommended as a topcoat in epoxy and polyurethane coating systems for applications requiring high levels of colour and gloss retention. It is suitable for industrial applications, including OEM systems, agricultural and construction equipment (ACE), commercial vehicles, and foundry-related environments.

Application Data:

Finish	High gloss (90 ± 5 GU at 60°) **Note:** The final gloss level is influenced by the substrate condition and applied film thickness, and may in some cases differ from the stated values.		
Colour	Standard colours (e.g. RAL, NCS), chrome- and lead-free		
Mixing Ratio	Base : Activator = 17: 3 (Parts by volume)		
Theoretical Consumption	~ 0.10 l/m^2 @ 50 microns DFT		
Practical Consumption	For large areas: ~ 0.14 l/m^2@ 50 microns DFT For small areas: ~ 0.20 l/m^2@ 50 microns DFT **Note**: Performance in practice varies with site conditions; so, the stated coverage values should be used only as guidelines for airless spraying.		
Standard Dry Film Thickness (DFT)	40-60 micron (depends on application process)		
Temperature	**10 °C**	**20 °C**	**30 °C**
Pot Life	-	2 hrs	-
Drying Time (Dust free)	90 min	45 min	30 min
Drying Time (Manageable)	6 hrs	3 hrs	2 hrs
Overcoat Interval	16 hrs	8 hrs	6 hrs

Note 1: All the provided values are approximate and should be used as guidelines for specifications.
Note 2: Drying times obtained using Activator in standard dry film thickness of 50 µm. At higher film thicknesses, longer drying times must be considered.
Note 3: No maximum overcoating interval, provided the surface is clean, dry, and free from contaminants.

Technical Data:

Title	Standard	Value
Solids Content (Mix)	-	~ 51 vol.% (depends on colour)
Density (Mix) @ 20 °C	-	~ 1.20 kg/l
Accelerated Weathering	ISO 11507 / ASTM G154	> 6000 hours (no significant degradation observed under test conditions)
Temperature Resistance	-	Dry heat: Up to 120 °C

Packaging:

20 litre pails and 200 litre drums;
HEGGEL Coat 198 Thinner: 25 litre pails or 200 litre drums.

Storage:

12 months, in sealed original containers under dry and cool conditions, ideally between 5 – 40 °C. Protect from heat and freeze!

1. Surface Preparation

Steel: Steel surfaces shall be prepared to a cleanliness level of Sa 2½ in accordance with ISO 8501-1, with a blasting profile of 40–70 µm, or alternatively cleaned using power tools to a minimum standard of ISO St3 / SSPC SP3.

For untreated steel, surface preparation shall be carried out in accordance with ISO 12944-4 §6.2.3. All grease, oil, dirt, and other contaminants must first be removed using a suitable cleaning agent such as **HEGGEL Cleaners** applied with a high-pressure spraying pistol. The surface shall then be grit blasted to Sa 2½ according to ISO 8501-1. After blasting, all dust must be removed from the entire surface using clean, dry, oil-free compressed air. The first coating layer must be applied within 6 hours after blasting. If the final coating layer is to be applied on the construction site, additional precautions must be taken to maintain surface cleanliness and coating performance.

Hot dip galvanized: The surface must be prepared in accordance with ISO 12944-4, section 6.2.3.4.1 (sweep blasting with inert grit) and NEN 5254 for duplex systems. All grease, oil, and contaminants should be removed using a suitable cleaning agent like **HEGGEL Cleaners**. The entire galvanized surface must then be lightly sweep-blasted using an inert abrasive with a grain size of 0.3–0.5 mm, at a blasting pressure of 2.0–2.5 bar and a minimum nozzle diameter of 6 mm. After blasting, the surface should exhibit a uniform, matte appearance. Depending on the zinc coating thickness, a maximum of 5–10 µm of zinc may be removed, as specified in NEN 5254. Finally, remove all dust from the surface using clean, dry, oil-free compressed air. Apply first coating layer within 2 hours.

2. Environmental Conditions

Prior to, during, and after application of the coating, ensure that the substrate temperature is at least 3 °C above the dew point and the maximum relative humidity shall be below 80%. To achieve proper film formation, the temperature should be at least 10 °C. Furthermore, any contact with moisture must be avoided during the application process. This is necessary to ensure proper drying.

3. Application Tools

Air spray: For effective application, use conventional air spray equipment. Thin the material with **HEGGEL Coat 198 Thinner** at 5–10% by volume. Maintain a flow pressure of 3–4 bar for optimal operation. Use a nozzle size of 2.0–2.5 mm. The achievable dry film thickness ranges from 40 to 60 µm.

Airless spray: Apply using standard airless spray equipment. Dilution with **HEGGEL Coat 198 Thinner** may be required at 0– 10% by volume, depending on application conditions. Operate at a pressure range of 140–160 bar and a nozzle size of 0.009– 0.013 inch is recommended. The resulting dry film thickness typically falls between 40 and 60 µm.

Air mix: Application may be carried out using Air mix spray equipment. Thin with **HEGGEL Coat 198 Thinner** at 5– 10% by volume. A working pressure of 70– 100 bar is recommended. Use a nozzle size of 0.009–0.013 inch. The recommended dry film thickness per coat is 40–60 µm.

Brush / Roller: Application by brush or roller may require thinning with **HEGGEL Coat 198 Brush Thinner** at 0- 5% by volume. Using this method, a typical dry film thickness of approximately 60 µm can be achieved.

4. Mixing

Thoroughly mix the base component and activator using a mechanical mixing device. Ensure the temperature of the mixed material is maintained at a minimum of 10°C during application.

5. Application

The coating is preferably recommended to be applied using airless or air mix spray equipment, as brush application may result in variations in film thickness and reduced flow properties.

Where thinning is required, the amount of **HEGGEL Coat 198 Thinner** should be adjusted to the equipment used, application method, and temperature of the mixed material.

Note: Clean all equipment immediately after application using **HEGGEL Coat 198 Thinner.**

6. Repairing Defects

Touch-up of damaged or untreated areas shall be carried out on site. Remove grease, oil, and dirt using a suitable cleaning agent, like **HEGGEL Cleaners**. Remove rust from mechanically damaged areas, weld seams, weld spots, and heat-affected zones using rotating steel wire brushes, sanding discs, or coarse sandpaper to a minimum cleanliness grade St 3 in accordance with ISO 8501-1.

Smooth the transition between cleaned areas and adjacent intact coatings by sanding and scraping. After sanding, remove all dust using clean, dry, oil-free compressed air. Then repair the area using the complete coating system in accordance with the coating specification. Minor surface damage may be repaired using the top coat only.

Note: Regular cleaning of the surface is recommended. The coating system should be inspected annually for defects, and any damage shall be repaired using the original coating system.

7. Safety Measures

HEGGEL Coat 198 (UN number: 1263) is in accordance with EU Directive 67/548/EEC and applicable hazardous substances regulations.

Ensure adequate ventilation during application and drying to reduce solvent vapors. This is necessary to achieve proper drying conditions and to protect applicators' health. Causes skin and eye irritation and may be harmful if inhaled. In case of eye contact, immediately rinse thoroughly with water and seek medical attention. Do not eat, drink, or smoke while handling this product. Keep away from heat, sparks, and open flames.

The material safety data sheets of the individual components, the safety instructions on the packing (label) as well as the legal requirements for handling hazardous materials must be observed.

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