

TECHNICAL DATA SHEET

supersedes previous issue dated 07/06/04

AF54**
HYDROPLUS: WATERBORNE CLEAR SELF-SEALER FOR INTERIORS

Gloss level:	5, 20, 50 and 70 gloss
Area of use:	Flat parts, turned parts, frames, baseboards, wall panelling, doors, chairs
Method of use:	By spray: conventional, airmix, airless, electrostatic (provided that any equipment used is suitable for waterborne products)
Mixing procedure:	Ready to use. If necessary, thin with tap water up to 5%.

Technical characteristics

Solids content (%):	24 ± 2
Specific gravity (kg/l):	1.030 ± 0.030
Viscosity (DIN 4 at 20°C):	40" ± 5"

General characteristics

Number of coats:	2
Recommended application weight (g/m ²):	min. 60, max. 120 per coat
Drying time (100 g/m ² at 20°C):	Dust free 20' Touch dry 60' Sandable: 4 hours Stackable: 24 hours
Shelf-life (months):	15

AF54** is a 1-pack waterborne self-sealer for interiors, thinnable with water and ensuring good hardness, transparency and blocking resistance.

It is particularly suitable for two-coat open pore systems.

AF54** can be tinted with small percentages of AC 600/XX or AC 1810/XX waterborne stains .

Substrate preparation

To obtain the best final result, a preliminary sanding of the substrate is always recommended (medium to fine grit) in order to remove macroscopic woodworking imperfections and to increase timber porousness. This will ensure an excellent adhesion of the coating film.

Application of AF54** as a basecoat

AF54** is a self-sealer ensuring excellent results in systems where a good pore marking is required. Thanks to this feature, it is particularly appreciated in countryfied furniture.

Sanding of the basecoat or of the first coat of AF54**

In case a higher build is required and a specific high solids basecoat has been applied, AF54** can be applied as a topcoat on the waterborne basecoats for interiors from the HYDROPLUS range.

We always recommend to sand the first coat of basecoat with 220-240 grit sandpapers. For best results, use stearate sandpaper, which provide excellent de-dusting and much higher efficiency than conventional sandpaper. Ask your abrasives supplier for information on specific papers for waterborne products.

Before applying the last coat, it is very important to make sure that the basecoat is thoroughly clean and free from grease, wax or resins.

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Chemical resistance and crosslinker

To increase further on chemical resistance and surface hardness of the last coat of AF54**, 1% of XA 4080 crosslinker can be added under stirring conditions. This is particularly recommended for AF5470 so that to improve its surface hardness and scratch resistance.

Drying

Drying of waterborne products must take place at temperatures not below 15°C and at a relative humidity preferably not exceeding 85%. Out of these limits, there is a slowing down of the drying and/or formation of a less hard and resistant film. It is always advisable for drying to be forced, with de-humidified air initially at room temperature then at 20-30°C.

Stacking

AF 54** has an excellent drying speed, but in case of forced drying, and considering the wide variety of ovens and tunnels existing on the market, a preliminary stacking check is always recommended.

The natural thermoplasticity of the resins used in waterbased coatings, makes them more delicate when stacked. Moreover, depending on how the coated items have dried, different results may be achieved. A strong ventilation with moderately hot air, a low humidity rate, a correct spreading rate and the use of XA 4080 crosslinker in the topcoat may significantly reduce time and risks linked to stacking.

The following recommendations always apply:

- stack the coated items at least 24 hours after coating
- always used a proper packaging material between the panels
- when possible, stack vertically

For further information, please refer to "GENERAL GUIDELINES ON USE OF WATERBORNE COATINGS FOR INTERIORS".

General instructions

- Store the product in rooms where the temperature does not fall below 5°C. • During application, keep the product, the substrate and the room at a temperature of at least 15°C.
- The use of coating devices not in perfect order (defective gaskets, too high pressures) or of pumps with low capacity may cause major defects in the coating film (air bubbles). • Coating residues (washing water, booth water, used coating) must be disposed of in accordance with current legislation. Do not pour residues down drains.
- In view of the wide variety of materials used for manufacturing wooden products, when switching from a solvent -based to a waterborne coating system it is always advisable to contact your suppliers' technical departments to check whether your equipment and components are appropriate or whether more suitable types exist. In particular, check: electrostatic guns, pumps, seals, silicones, glues, booth treatment water products, packaging materials, fillers, sandpaper, etc.
 - Once the can has been opened, the coating may rot because of the attack of bacteria commonly present in the air. This phenomenon is easily detectable because of the bad smell and by an increase of viscosity of the product stored in the can. Avoid recovering the used coating in fresh product cans and also to leave them open, particularly during summertime.

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The addition of 0.1÷0.5% of XA4051 increases the product's preservation (but only as a preventive action).