TECHNICAL DATA SHEET

supersedes previous issue dated 19/02/07

AT48**/XX — 2-PACK WATERBORNE WHITE TOPCOAT FOR INTERIORS

Versions:	10, 20, 30, 40 and 90 gloss The gloss level is referred to the coating film obtained with the A + B blend, i.e. AT48**/XX + hardener AH1550		
Colours:	13 white		
Area of use:	doors, furniture parts		
Method of use:	airmix, airless, conventional, electrostatic spray gun, provided that equipment is suitable for use with waterborne products		
Thinning:		by weight (kg)	by volume (l)
Part A:	AT48**/13	100	100
Part B (hardener):	AH1550	8	8
Thinner:	water	5	5

Technical characteristics

Solids content (%):	40 ± 2
Specific gravity (kg/l):	1.180 ± 0.030
Viscosity (DIN 8 at 20°C):	10, 20, 30, 40 gloss: 12”
Viscosity (DIN 4 at 20°C):	90 gloss: 100”

General characteristics

Pot life at 20°C:	8 hours
Recommended application weight (g/m²):	from 100 to 150
Number of coats:	1
Drying time (120 g/m² at 20°C):	touch dry 2 hours through dry 8 hours stackable 24 hours
Spreading rate (125 g/m²):	10 m²/l
Shelf-life (months):	15

AT48**/XX is a 2-pack acrylic-polyurethane waterborne topcoat to be applied over waterborne clear or pigmented basecoats in coating systems for interior furniture or furniture parts.
Thanks to its special formulation, AT48**/XX ensures following characteristics:

- easy mixing with the hardener
- very high yellowing resistance and light fastness
- excellent surface hardness
- good vertical hold
- excellent flow
- very smoot surface
- excellent chemical resistance even against alcohol

Alternative hardeners

AH1545: pre-thin with 5% of tap water and harden at 10%. AH1545 has a high reactivity, a pot-life of approximately 3 hours and high chemical resistance.

AH1550: pre-thin with 5% tap water and harden at 10%. AH1550 has a pot-life of approximately 8 hours (thus enabling a much longer handling of the product after catalysis - see AH1550 technical data sheet) and gives to the final blend a higher gloss level: 3-5 gloss more than that achieve with other hardeners.

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Use

AT48**/XX in 10, 20, 30 and 40 gloss versions is suitable for use as white converter for the colour-matching system. It can be mixed with up to 4% of XA4099/XX or XA2006/XX waterborne pastes to achieve pastel shades.

Substrate preparation

With one or more coats of Hydroplus waterborne or polyester basecoat, suitably dried and sanded.

Application

By spray (airless, airmix or conventional) both horizontally and vertically.
We advise against using very thick layers of topcoat in a single application since uneven drying of the film can give rise to cracking, especially in areas of build up (grooves in shaped panels). Following are some guidelines:

1. Conventional spray: 1.9 mm nozzle, pressure: 3-4 bar
2. Airmix: 11 mm nozzle, pressure of coating: 80-100 bar; air pressure: 1-2 bar
3. Airless: 11 mm nozzle, pressure of coating: 150-200 bar
4. The use of a pre-atomizer and/or of a pre-heater (30-35°C) has given excellent results in terms of flow and quality consistency.

If application devices are not in perfect conditions (defective gaskets, too high pressure, etc.) they may cause major defects in the coatings film (e.g. air bubbles).
We recommend the use of 2-head pumps in order to reduce waste and to improve the quality of the coating applied in terms of resistance to stacking and to chemicals.

Drying

2-pack waterborne products must be dried in rooms with temperatures no lower than 15°C and relative humidity no greater than 70%. Outside this range drying is slower and/or the film is formed with poorer hardness and chemical resistance. For good drying it is advisable to use a forced flow of dry air initially at room temperature and subsequently at 35°C.

Warning

When used without hardener or with hardeners different from AH1550, gloss level is likely to be 3-5 gloss lower.

Do not store the product at temperatures lower than 5°C or higher than 35°C..

Coating residues 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. In particular, check: electrostatic guns, pumps, seals, silicones, glues, booth treatment water products and packaging materials.

Once the can has been opened, the waterborne protective wood stay may rot because of the attack of bacteria, moulds and fungi commonly present in the air. This phenomenon is easily detectable because of the bad smell, increase of viscosity, mould on the surface and change of color. This problem may take place also in case of products left for a long time in vessels for dipping or flow-coating application, mainly during summertime. The use of drinking water, a frequent cleaning of the plant (possibly with disinfectant solutions) and the periodic addition of XA4051 bactericide (0.1-0.2%) increase preservation of the products used. As a disinfectant use a 2% solution in water of XA4051. As to application method relating to XA4051, please refer to its technical data sheet.

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Advices provided in our technical data sheets are the result of our application experice. However, the many substrates, their pre- or post-treatments (glueing, sanding, tinting, storage conditions, etc.) as well as the application conditions may all lead to many different situations. As a result, it is always necessary to check product suitability in relation to the specific conditions it will be used.

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