

TECHNICAL DATA SHEET

AT99/XX****HYDROPLUS WATERBORNE TOPCOAT FOR INTERIORS**

Versions and colours:	AT99**/NN	Neutral	15, 30, 50 gloss
	AT99**/BB	White	15, 30, 50 gloss
Area of use:	Flat parts, turned parts, picture frames, furniture, skirting board, matchboards.		
Method of use:	Spray (conventional, airmix, airless and electrostatic, provided equipment suitable for waterborne products is used).		
Thinning:	Ready to use. If thinning is required, use max. 5% drinking water.		

Technical characteristics

Solids content (%):	AT99**/NN:	32 ± 2
	AT99**/BB:	40 ± 2
Specific gravity (kg/l):	AT99**/NN:	1.020 ± 0.030
	AT99**/BB:	1.150 ± 0.030
Viscosity (DIN 4 at 20°C):	AT99**/XX:	140" ± 10"
	AT99**/BB:	150" ± 10"

General characteristics

Drying time(120 g/m ² at 20°C):	Dust free:	30'
	Touch dry:	70'
	Stackable:	24 hours
Application weight (g/m ²):	from 80 to 140	
Spreading capacity (m ² /kg):	from 7 to 12	
Number of coats:	1	
Shelf-life (months):	15	

AT99**/XX is a one-pack waterborne topcoat suitable for coating wooden products for indoor use which ensures excellent hardness and good chemical resistance.

The good vertical hold and hardness, coupled with an exceptional even matting and smoothness, make AT99**/XX a viable environmentally-friendly alternative to meet all requirements.

Method of use

AT99**/XX can be tinted with XA 4099/XX and XA2006/XX waterborne pastes, in a ratio of 920/80 cc for full color tones formulated with the clear base, up to a maximum of 4% for the light shades formulated with the white pigmented base, as shown on WOODCOLOR-PLUS formulation book.

Substrate preparation

With one or more coats of Hydroplus waterbased basecoat or polyester basecoat properly dried and sanded.

Chemical resistance and cross-linker

AT99**/XX can be used as it is to coat all wood surfaces for interiors. However, to further improve chemical resistance, add slowly while stirring 0.5-1% cross-linker XA 4080, premixed 1:1 with water and used immediately.

The use of XA 4080 is particularly recommended for flat parts subjected to hard wear or contact with chemicals.

AT99/XX**

HYDROPLUS WATERBORNE TOPCOAT FOR INTERIORS

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 air previously de-humidified and warm (20-30°C).

Stacking

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

N.B.:

On wood species, even those species commonly used for pigmented topcoat application, the basecoat may dissolve coloured substances in the wood and cause yellowing. This colour is liable to float to the surface even after the application of more than one coats of waterborne topcoat.

White basecoat must therefore be used only on MDF (but check the quality of the MDF first) or as a coloured basecoat for pigmented topcoats in colours other than white.

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.
- 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.

For further information on all stages of furniture coating using waterborne products, consult our technical booklet "GENERAL GUIDELINES ON THE USE OF WATERBORNE COATINGS FOR INTERIORS".