

# TECHNICAL DATA SHEET

supersedes previous issue (AU 454/XX) dated 20/03/02

**AU 454/XX**
**HYDROPLUS WATERBORNE WHITE PRIMER FOR MDF FOR  
 SPRAY APPLICATIONS**

Area of use:	flat parts, frames, skirting, doors
Method of use:	airmix, airless, conventional spray gun
Thinning:	ready to use. Thin with tap water if needed

### Technical characteristics

Solids content (%):	62 ± 1
Specific gravity (kg/l):	1.450 ± 0.030
Viscosity (DIN 4 at 20°C):	60" ± 5"

### General characteristics

Drying time (120 g/m <sup>2</sup> at 20°C and 65% relative humidity):	Dust free	20'
	Touch dry	25'
	Overcoatable	1 hour
	Sandable	4 hours
	Stackable	8 hours
Recommended application weight (g/m <sup>2</sup> ):	80-180 per coat	
Number of coats:	Max. 3	
Shelf-life (months):	15	

AU 454/13 can be applied by spray directly onto MDF or Masonite substrates. It has a high pigment and solids content and provides excellent substrate filling, ensuring a uniform colour even at application weights of 100-120 g/m<sup>2</sup>.

This product is designed for industrial applications using tunnel drying with forced ventilation and air temperature higher than 30°C. With this kind of drying it is stackable after a very short time. It can also be dried at ambient temperature, but as for all waterborne products, drying time is strongly influenced by ambient conditions.

This product already has a limited thermoplasticity, making both manual and automated sanding possible. On these grounds the addition of crosslinker may result in an excessive rigidity of the product which may cause crackings. After sanding, AU 454/13 can be overcoated with any Hydroplus waterborne pigmented product.

### Warning

Due to weather variations, viscosity may vary from that shown on this data sheet. For AU0454/13, viscosity variations within 20% must be regarded as normal.

### Special instructions

- During application, the temperature of the product, the substrate and the environment must be no lower than 15°C.
- Coating residues (washing water, booth water, used coating) must be disposed of in accordance with current legislation. Do not pour residues down the drain.
- In view of the wide variety of materials used for manufacturing wooden products, when switching from a solvent-based to a waterborne painting 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, putties, sandpaper, etc.