

TECHNICAL DATA SHEET

AU 472/XX
**HYDROPLUS 2-PACK WATERBORNE BASECOAT FOR MDF
 WHITE**

Colors:	13 white		
Area of use:	flat parts, frames, baseboards , doors		
Method of use:	airmix, airless, conventional spray gun		
Mixing procedure:		by weight (kg)	by volume (lt)
	Part A	AU 472/13	100
	Hardener	AH1550	4
		Water	0-5

Technical characteristics

Solids content (%):	61 ± 1
Specific gravity (kg/l):	1.380 ± 0.030
Viscosity (DIN 6 at 20°C):	45" ± 5"

General characteristics

Pot life at 20°C:	3 hours	
Recommended application weight (g/m ²):	from 150 to 250 per coat	
Number of coats:	max. 3	
Drying time (180 g/m ² at 20°C and 65% relative humidity):	dust free	20'
	touch dry	25'
	overcoat	1 hour
	able	4
	sandable	hours
	stackable	8
		15 hours

AU 472/13 is a 2-pack basecoat applicable by spray directly on MDF or Masonite substrates. It has a high pigment content and a high solids content, thus ensuring an excellent filling power and an even color even at 150-200 g/m² application weights.

AU 472/13 has to be hardened with AF1550 at 4%: by doing so, the product acquires a high elasticity and a higher build than 1-pack products. However, it can also be used without hardener. If so, it is necessary to consider that its properties as a barrier decrease and its sensitivity to low temperatures increases. When used without hardener, it is necessary to keep the substrate and its temperature above 20°C or, preferably, to work in a tunnel.

In industrial applications, where drying is forced and at temperatures above 30°C, AU 472/13 either with or without hardener, is stackable after a very short time.

For sanding, we recommend stearate abrasive papers for best results.

We advise against an excessive removal of the basecoat since this would result into a raising of the MDF grain fibers by the waterborne topcoat.

After sanding, AU 472/13 can be overcoated with all Hydroplus waterborne products. To prepare coloured bases, it is possible to add to AU 472/13 up to a total 4% of XA4011/XX pigmented pastes for waterborne products.

Application

By spray (electrostatic, airless, airmix or conventional) both horizontally and vertically.

Following are some guidelines:

1. Conventional spray: 1.9-2.2 mm nozzle, pressure: 3-4 bar
2. Airmix: 11-13 mm nozzle, pressure of coating: 80-100 bar; air pressure: 1-2 bar
3. Airless: 11-13 mm nozzle, pressure of coating: 150-200 bar

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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).

Application on timber

AU 472/13 can be applied on timbers only if hardened at least at 4%. In such a condition, the basecoat acquires barrier-properties that allow staining on those timbers containing colourful substances, such as: oak, acacia, ash.

If applied on bare wood, the first coat can let the colourfull substances surface. However, the following coats won't colour wood any more, thanks to the barrier action played by the first coat. In order to guarantee the barrier-power it is important to verify that the first coat has a thickness of at least 150-180 µm and that sanding, if necessary, is only a superficial one. For these reasons, therefore, AU 472/13 cannot be used to achieve an "open-pore" effect.

Warning

Due to weather variations, viscosity may vary from that shown on this data sheet.

For AU 472/13, 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.