

# TECHNICAL DATA SHEET

supersedes previous issue dated 15/05/00

**GA 850/XX**
**WATERBORNE EXTRUDER GRADE BASECOAT**

Colours available:	00 clear 13 white	08 red bolo 22 black
Area of use:	Picture frames, profiles	
Method of use:	Extruder	
Mixing procedure:	Ready to use. If necessary add 0.5 - 1% of XA 4080 (cross-linking agent).	

### Technical characteristics

Solids content (%):	00 clear	38 ± 1
	08 red	52 ± 1
	bolo 13	63 ± 2
	white 22	50 ± 2
	black 00	
Viscosity (cPs):	clear	1.030 ± 0.030
	08 red bolo	1.200 ± 0.030
	13 white 22	1.240 ± 0.030
	black 10,000	1.240 ± 0.030
		± 500

### General characteristics

Recommended application weight (g/m <sup>2</sup> ):	from 40 to 80 per coat	minutes 16-24 hours
Drying time	overcoatable	
(60 g/m <sup>2</sup> at 20°C, 65% relative humidity):	: sandable:	
	minimum 2 -	
	maximum 5	
	15	

### Number of coats:

GA 850/XX is an extruder grade basecoat with good characteristics of wettability, transparency, speed of drying and sandability.

### Shelf-life (months):

Being GA 850/XX a thermoplastic product, the addition of 0.5% of crosslinker XA 4080 is usually recommended to improve heat and chemical resistance (specially to alcohol and acetone). As a consequence such operations as scotch brite sanding or antique staining can be carried out without problems.

XA 4080 is effective for 16 hours after addition. If some product already added with XA 4080 is left over at the end of the working day, it can be used the next day by adding again cross-linking agent and mixing with fresh product (to which XA 4080 has to be added, too). At least 3 coats of product are required in order to ensure good pore filling. Do not however apply more than 5 coats.

Particular attention must be paid when sanding with scotch-brite, to avoid creating a high pressure, and raise the temperature of the film. The addition of 0.5-1% of crosslinker XA 4080 makes sanding with scotch-brite easier, but to the detriment of overcoating and hot stamping performance.

When jointed wood frames are used, make sure that gluing has been performed with waterresistant glues (class D3). Unsuitable products could result in lifting and/or swelling.

### Special instructions

Keep from freezing: store the product at temperatures higher than 5°C.

Application and drying must occur at a temperature higher than 15°C. During application also the product and the substrate must be maintained at a temperature higher than 15°C.

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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 the suppliers' technical departments to check whether the equipment and components used 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.