

TECHNICAL DATA SHEET

Supercedes previous issue dated 10/06/99

AU 465
HYDROPLUS: CLEAR WATERBORNE BASECOAT FOR INTERIORS

Area of use:	Flat parts, turned parts, picture frames, skirting board, matchboards, doors.
Method of use:	Spray: conventional, airmix, airless and electrostatic spray guns (provided equipment suitable for waterborne products is used).
Thinning:	Ready to use. If necessary, thin with 5% max. drinking water.

Technical characteristics

Solids content (%):	35 ± 1
Specific gravity (kg/l):	1.030 ± 0.030
Viscosity (DIN 4 at 20°C):	110" ± 5"

General characteristics

Application weight (g/m ²):	from 80 to 140 per coat
Spreading capacity (kg/m ²):	from 8 to 16
Number of coats:	maximum 3
Shelf-life (months):	15

AU 465 is a one-pack waterborne basecoat suitable for interior applications ensuring good sandability and build. With its excellent transparency and capacity for wetting the wood fibres, AU 465 enables to achieve wood colour similar to that obtained with polyurethane basecoats.

In order to obtain the best performance in terms of pore wetting and vertical hold, AU 465 shall be applied with systems ensuring the best product atomisation. Following are some general remarks relating to spray application:

Spray system	Nozzle diameter (µm)	Air pressure (bar)	Coating pressure (bar)
conventional	1.8-2	3-4	
airmix	9-11	0-2	80-110
airless	9-11		80-150

The use of pre-atomisers and pre-heaters with coating temperature between 30 and 40°C have proven to be very effective to ensure application consistency during the year.

AU 465 is suitable both for open and closed pore systems, which can be obtained by applying from one to three 60-120 g/m² coats of product.

In normal drying conditions with a good air exchange (20°C and relative humidity of 65%), the first coat of product can be overcoated after just 2 hours and sanded after 4-5 hours. Application of the second coat or drying conditions with low temperatures and/or high relative humidity result in longer drying times.

Drying conditions in which air is completely exchanged in 15-20 minutes are particularly recommended.

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Sanding of AU 465

AU 465's special formulation, based on acrylic resins with low thermoplasticity, allows the first coat to be sanded, either mechanically or manually, just 4 hours after application, provided that drying is complete.

For best results, use stearate sandpaper, which provide excellent de-dusting and much higher efficiency than conventional sandpaper. For automatic sanding, calibrate the machine very accurately and use low belt rotation speeds and low pressure on the roller/pad. Consult your abrasives supplier for information on specific papers for waterborne products.

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AU 465**HYDROPLUS: CLEAR WATERBORNE BASECOAT FOR INTERIORS****Application of topcoat**

AU 465 waterborne basecoat can be overcoated without problems using any of the HYDROPLUS waterborne products for interior applications.

General instructions

- Storage temperature shall not fall below 5°C. Can be damaged by the cold.
- 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".