

Technical Data Sheet

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

Supersedes previous issue dated 01.29.13

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Versions and colours:	AT99**/NN	Neutral	5, 15, 30, 50 gloss
	AT99**/BB	White	5, 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:	29 ± 2
	AT99**/BB:	37 ± 2
Specific gravity (kg/l):	AT99**/NN:	1.020 ± 0.030
	AT99**/BB:	1.150 ± 0.030
Brookfield viscosity (cps):	AT99**/XX:	4400 ± 1300 cPs

General characteristics

Drying time (120 g/m² at 20°C):	Dust free:	30'
	Touch dry:	70'
	Stackable:	24 hours
Application weight (g/m²):	from 120 to 140	
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. This new formulation gives good verticality and deaeration. In bulk it looks more tixotropic than the previous version and in application it is extremely fluid and has excellent wetting even at low grams.

Method of use

AT99**/XX can be tinted with 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. However, to further improve chemical resistance, add slowly while stirring 0.5-1% cross-linker XA4080/00, premixed 1:1 with water and used immediately.

The use of XA4080/00 is particularly recommended for flat parts subjected to hard wear or contact with chemicals. Such performances are further improved by double crosslinking with:

- 0.5% - 1.0% XA4080/00 (previously mixed 1:1 with water)
- 3% XA4095/00

The above shall be added one after the other following the above order, slowly and under stirring.

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 XA4080/00 and XA4095 crosslinkers 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.

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MANAGEMENT SYSTEM
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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".

N.B.: DATA PROVIDED ON THIS TECHNICAL DATA SHEET CORRESPOND TO OUR BEST KNOWLEDGE AND EXPERIENCE. WE ASSURE CONSISTENCY ON THE CHEMICAL-PHYSICAL CHARACTERISTICS OF OUR PRODUCTS, WITHIN THE TOLERANCE LIMITS SPECIFIED ON OUR TECHNICAL DATA SHEETS. RESPONSIBILITY OF FINAL RESULT OF PRODUCT APPLICATION IS FULLY UP TO THE USERS, WHO SHALL MAKE SURE THAT THE PRODUCT CORRESPONDS TO THEIR OWN NEEDS WITH REGARD TO APPLICATION SYSTEM, TO SUBSTRATES USED AS WELL AS TO WORKING CONDITIONS.

WARNING: ACTUAL VISCOSITY OF SOME PIGMENTED AND/OR THIXOTROPIC PRODUCTS MAY DIFFER FROM THE VISCOSITY SHOWN ON THE TECHNICAL DATA SHEET. DIFFERENCES ARE TO BE REGARDED AS ACCEPTABLE IF WITHIN 30% MAXIMUM.