

# Technical Data Sheet

## AT48\*\*/XX 2-PACK WATERBORNE TOPCOAT FOR INTERIORS

Supersedes previous issue dated 08/06/09

DATE 06/22/15

Colours and versions:	AT48**/13 White 10, 20, 30, 40 and 90 gloss AT48**/00 Clear 10, 20, 30, 40, 60, 85 gloss The gloss level is referred to the coating film obtained with the A + B blend, i.e. AT48**/XX + hardener AH1550/00		
Area of use:	doors, furniture components		
Method of use:	airmix, airless, conventional, electrostatic spray gun, provided that equipment is suitable for use with waterborne products		
Mixing procedure:		by weight (kg)	by volume (l)
Part A:	AT48**/13	100	100
Thinner:	water	5	5
Part B (hardener):	AH1550/00	8	8
Part A:	AT48 **/00	100	100
Thinner:	water	5	5
Part B (hardener):	AH1550/00	10	10

### Technical characteristics

Solids content (%):	AT48**/13	40 ± 2
	AT48**/00	36 ± 2
Specific gravity (kg/l):	AT48**/13	1.180 ± 0.030
	AT48**/00	1.030 ± 0.030
Viscosity (DIN 6 at 20°C):	AT48**/XX	31" ± 4
Viscosity (DIN 4 at 20°C):	90 gloss:	100" ± 5

### General characteristics

Pot life at 20°C:	8 hours
Recommended application weight (g/m²):	from 100 to 150
Number of coats:	1
Drying time (120 g/m² at 20°C):	touch dry 2 hours through dry 8 hours stackable 24 hours
Spreading rate (125 g/m²) only for white version:	10 m²/l
Shelf-life (months):	15

**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.

AT48\*\*/XX is a 2-pack acrylic-polyurethane waterborne topcoat to be applied over waterborne clear or pigmented basecoats in coating systems for interior furniture or furniture components.

Thanks to its special formulation, AT48\*\*/XX ensures following characteristics:

- easy mixing with the hardener
- very high yellowing resistance and light fastness
- excellent surface hardness
- good vertical hold
- excellent flow
- very smooth surface
- excellent chemical resistance even against alcohol

#### Alternative hardeners

- **AH1545/00:** pre-thin with 5% of tap water and hardened at 8% for AT48\*\*/13 and at 10% for AT48\*\*/00. AH1545/00 has a high reactivity, a pot-life of approximately 3 hours and high chemical resistance.
- **AH1550/00:** pre-thin with 5% tap water and hardened at 8% for AT48\*\*/13 and at 10% for AT48\*\*/00. AH1550/00 has a pot-life of approximately 8 hours (thus enabling a much longer processing of the product after catalysis – see AH1550/00 technical data sheet) and gives to the final blend a higher gloss level: 3-5 gloss more than that achieved with other hardeners.

#### Use

AT48\*\*/XX except 90 gloss version, is suitable for use as converter for the colour-matching system. It can be mixed with up to 4% of XA2006/XX waterborne pastes to achieve pastel shades starting from AT48\*\*/13 and up to 8% to achieve full tone colors starting from AT48\*\*/00.

#### Substrate preparation

With one or more coats of Hydroplus waterborne or polyester basecoat, suitably dried and sanded.

#### Application

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

We advise against using very thick layers of topcoat in a single application since uneven drying of the film can give rise to cracking, especially in areas of build up (grooves in shaped panels).

Following are some guidelines:

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

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We recommend the use of 2-head pumps in order to reduce waste and to improve the quality of the coating applied in terms of resistance to stacking and to chemicals.

### Drying

2-pack waterborne products must be dried in rooms with temperatures no lower than 15°C and relative humidity no greater than 70%. Outside this range drying is slower and/or the film is formed with poorer hardness and chemical resistance. For good drying it is advisable to use a forced flow of dry air initially at room temperature and subsequently at 35°C.

### Warning

- When used without hardener or with hardeners different from AH1550/00, gloss level is likely to be 3-5 gloss lower.
- Do not store the product at temperatures below 5°C or above 35°C..
- Coating residues 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. In particular, check: electrostatic guns, pumps, seals, silicones, glues, booth treatment water products and packaging materials.
- Once the can has been opened, the waterborne protective wood stay may rot because of the attack of bacteria, moulds and fungi commonly present in the air. This phenomenon is easily detectable because of the bad smell, increase of viscosity, mould on the surface and change of color. This problem may take place also in case of products left for a long time in vessels for dipping or flow-coating application, mainly during summertime. The use of drinking water, a frequent cleaning of the plant (possibly with disinfectant solutions) and the periodic addition of XA4051/00 bactericide (0.1-0.2%) increase preservation of the products used. As a disinfectant use a 2% solution in water of XA4051/00. As to application method relating to XA4051/00, please refer to its technical data sheet.
- Advices provided in our technical data sheets are the result of our application experience. However, the many substrates, their pre- or post-treatments (glueing, sanding, tinting, storage conditions, etc.) as well as the application conditions may all lead to many different situations. As a result, it is always necessary to check product suitability in relation to the specific conditions it will be used.

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