

423-44XX Aqualac II Waterborne Clear Topcoat

Product codes:	423-4420 20°C Low Gloss	Viscosity	Zahn #2 signature cup 29-30 sec at 25°C
	423-4435 35°C Satin	Flash Point:	> 93°C (200F)
	423-4450 50°C Semi-Gloss	Density (kg/l):	1.04 ± 2% at 25°C
		Solid (% by weight):	35 ± 1%
		Solid (% by volume):	31 ± 1%
		Shelf Life (months):	6

Product Description:

This fast dry high solid acrylic is a water based lacquer that can be used as a self-sealing lacquer. This product meets KCMA specifications (Kitchen Cabinet Manufacturer Association).

Uses:

For interior uses only.

Environmental Data (as supplied):

VOC less exempt lb/gal:	<7.15
VOC lb/gal:	<7.15
VOC less exempt g/l:	
VOC g/l:	
VOC lb/lb Solid:	0.00
VHAPs lb/lb Solid:	0.00

Note:

See individual compliance sheets for specific data

Application Data

Suggested Uses:	Spray
Mixing Ratio:	N/A
Suggested Uses:	N/A
Application Viscosity:	29-30 sec Zahn #2 at 25°C
Reducer:	2% of water if needed
Retarder:	N/A
Clean-up Solvent:	Use water when in liquid state and water/acetone 800-5500 when material is semi-dried
Recommended Wet Film:	4 - 5 mils wet
Coverage:	N/A

Note:

N/A

Directions for use:

Surface Preparation:

Sealer must be sanded with grit 120, 150 or 180 and free of dust and all contaminants.

General Information:

The first coat must be applied as is or reduced at 10% maximum with water. After 60 minutes of dry time, it must be sanded using a fine sand paper (ex.: 280,320) and free of sand dust. An extra coat is then applied, not reduced, depending on the desired wear resistance and the desired look. Additional coats must be done within 8 hours after sanding. Maximum film build of the system should not exceed 4 dry mils.

To obtain complete cure, the product must be applied at a temperature above 18°C and relative humidity below 65%. Contact with metallic surfaces must be avoided. Always use containers and equipment made of plastic or stainless steel to avoid discoloration of the material due to oxidation.

Keep from freezing.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	30 - 45 minutes	Flash off required before oven
Dry to Sand:	60 - 90 minutes	24 hours
Dry to Stack:	30 - 45 minutes	6 - 8 hours

Note:

N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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