Chemcraft
A Great Finish is Only the Beginning

AkzoNobel

228-24XX Waterborne 1K White Topcoat

Product codes:	228-2405 Flat 228-2410 Matte 228-2420 Low Gloss 228-2435 Satin 228-2450 Semi-Gloss 228-2490 High Gloss	**Viscosity**	1100-1300 Centipoises at 77°F (25°C)
		Flash Point:	>200°F
		Density (lb/gal):	9.83
		Solid (% by weight):	46.49
		Solid (% by volume):	36.68
		Shelf Life (months):	12

Product Description:
Waterborne 1K White Topcoat is an acrylic selfcrosslinking product that is utilized in various markets. It meets AWI system #7 and specific KCMA requirements. Waterborne 1K White Topcoat has unique thixotropy for vertical and horizontal application. It has excellent hiding properties. Waterborne MaestroHue complete color sytem available utilizing 897 colorants at a maximum 7%.

Uses:
Waterborne 1K White Topcoat is designed for cabinets, architectural millwork, furniture and refinish markets.

Environmental Data (as supplied):

VOC less exempt lb/gal:	1.85
VOC lb/gal:	0.749
VOC lb/lb Solid:	0.26
VHAPs lb/lb Solid:	0.00

Note:
N/A

Application Data

Suggested uses:	For cabinets, Architectural millwork, furniture, refinish markets
Mixing Ratio:	N/A
Pot life:	N/A
Application Viscosity:	55-60 seconds Zahn signature #4
Reducer:	Water up to 10% by volume depending on spray equipment
Retarder:	803-1462 1 to 3% by volume as needed
Clean-up Solvent:	Water
Recommended Wet Film:	4-6 wet mils
Coverage:	589 Sqft/gal?

Note:
Depending on spray equipment the Waterborne 1K White Topcoat may need some reduction, the addition up to 10% water is recommended for cup gun, gravity cup or HVLP. For Air Assisted Airless Waterborne 1K White Topcoat can be used as is.

Directions for use:

Surface Preparation:
Substrate must be sanded using 120, 150 or 180 grit paper prior to prime. Primer should be sanded with 280/320 grit paper prior to being coated, The Primer should be coated within eight hours of sanding.
Appropriate primers are the Chemcraft 550-3500, 550-3501, 550-1600, 550-1602, 550-1760, and 550-1761. Always recoat within eight hours of sanding.

General Information:
N/A
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 minutes	15 minutes
Dry to Sand:	60 minutes	30 minutes
Dry to Stack:	24 hours	60 minutes

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.

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Updated: 2025-04-19 01:00:22