

## 228-27XX Waterborne 1K Neutral Topcoat

<b>Product codes:</b>	228-2705 Flat	<b>Viscosity</b>	1100-1300 Centipoises at 77°F (25°C)
	228-2710 Matte	<b>Flash Point:</b>	>200°F
	228-2720 Low Gloss	<b>Density (lb/gal):</b>	8.55
	228-2735 Satin	<b>Solid (% by weight):</b>	34.73
	228-2750 Semi-Gloss	<b>Solid (% by volume):</b>	31.3
	228-2790 High Gloss	<b>Shelf Life (months):</b>	12

### Product Description:

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

### Uses:

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

<b>Environmental Data (as supplied):</b>	<b>VOC less exempt lb/gal:</b>	1.71
	<b>VOC lb/gal:</b>	0.69
	<b>VOC lb/lb Solid:</b>	0.23
	<b>VHAPs lb/lb Solid:</b>	0.00

### Note:

N/A

<b>Application Data</b>	<b>Suggested uses:</b>	For cabinets, architectural millwork, furniture, refinish markets
	<b>Mixing Ratio:</b>	N/A
	<b>Pot life:</b>	N/A
	<b>Application Viscosity:</b>	55-60 seconds Zahn signature #4
	<b>Reducer:</b>	Water up to 10% by volume depending on spray equipment
	<b>Retarder:</b>	803-1462 1 to 3% by volume as needed
	<b>Clean-up Solvent:</b>	Water
	<b>Recommended Wet Film:</b>	4-6 wet mils
	<b>Coverage:</b>	503 Sqft/gal

### Note:

Depending on spray equipment the Waterborne 1K Neutral Topcoat may need some reduction - up to 10% with water. Recommended for cup gun, gravity cup or HVLP. For Air Assisted Airless Waterborne 1K Clear 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.

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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