Chemcraft
A Great Finish is Only the Beginning

AkzoNobel

423-2400 Waterborne 1K Sealer

Product codes:	423-2400	**Viscosity**	500-600 Centipoises at 77°F (25°C)
		Flash Point:	>200°F
		Density (lb/gal):	8.59
		Solid (% by weight):	28.25
		Solid (% by volume):	25.81
		Shelf Life (months):	12

Product Description:
Waterborne 1K Sealer is an acrylic selfcrosslinking product that is utilized in various markets. Waterborne 1K Sealer has unique thixotropy for vertical and horizontal applications. Waterborne 1K Sealer has excellent clarity.

Uses:
This is a selfcrosslink Waterborne 1K Sealer designed for cabinets, architectural millwork, furniture and refinish markets.

Environmental Data (as supplied):	**VOC less exempt lb/gal:**	1.89
	VOC lb/gal:	0.64
	VOC lb/lb Solid:	0.27
	VHAPs lb/lb Solid:	0.00

Note:
N/A

Application Data	**Suggested uses:**	For cabinets, architectural millwork, refinish markets
	Mixing Ratio:	N/A
	Pot life:	Brookfield 500-600 cps at 77°F (25°C)
	Application Viscosity:	28-32 seconds Zahn signature #4
	Reducer:	Water up to 10% by volume depending on spray equipment
	Retarder:	803-1462 1 - 3% by volume as needed
	Clean-up Solvent:	Water
	Recommended Wet Film:	3-5 wet mils
	Coverage:	415 sqft/gal

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

Directions for use:

Surface Preparation:
Substrate must be sanded using 120, 150 or 180 grit paper prior to seal. Sealer should be sanded with 280/320 grit paper prior to being coated, The Sealer should be coated within eight hours of being sanded.

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:	20 minutes	12 minutes
Dry to Sand:	45 minutes	20 minutes
Dry to Stack:	24 hours	30 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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