

AQUASILK 400TW 2K WHITE 228-34XX

Product codes:	228-3405	Viscosity	Zahn #2 Signature cup 40-45 sec at 77°F (25°C)
	228-3410		
	228-3420	Flash Point:	Zahn #3 Signature cup 18-22 sec at 77°F (25°C)
	228-3435		
	228-3450	Density (lb/gal):	Over 200°F (93.3°C)
	228-3480		10.31 lb/gal
		Solid (% by weight):	45.5
		Solid (% by volume):	32.5
		Shelf Life (months):	12

Product Description:

AQUASILK 400TW 2K White Topcoat is a white 2K polyurethane waterborne topcoat for industrial application. This product provides excellent water and chemical resistance and has high solids with great hide that allows for ease of application. Whether you are at a finishing shop or at a professional on-site job this low VOC and low odor system meets or exceeds industry standards.

Uses:

AQUASILK 400TW 2K White Polyurethane Waterborne Topcoat has been designed for the cabinet, architectural millwork, furniture and refinish markets.

Environmental Data (as supplied):	VOC less exempt lb/gal:	0.34
	VOC lb/gal:	0.11
	VOC lb/lb Solid:	0.02
	VHAPs lb/lb Solid:	0.00

Note:

N/A

Application Data	Suggested uses:	For cabinet, architectural millwork, furniture, refinish markets.
	Mixing Ratio:	8% by volume of 876-3400 Hardener
		See Application Data Notes for additional mixing information
	Pot life:	3-4 hours depending on external condition
	Application Viscosity:	Zahn #3 Signature cup 30-35 sec at 77°F (25° C)
	Reducer:	Water up to 10% by volume
	Retarder:	803-1462 1 to 3% by volume
	Clean-up Solvent:	Water
	Recommended Wet Film:	4-5 wet mils
	Coverage:	556 sqft/gal

Note:

AQUASILK 400TW 2K White base should be thoroughly mixed first then hardener must be slowly added during agitation, product must be mixed for 1-2 minutes.

Customer must wait 5 minutes for "induction time" before usage. Mix only what you can use for 2-3 hours at a time. If an excessive amount over 5 wet mils is applied, there is a chance that surface imperfection (mud cracking, etc.) may result.

Directions for use:**Surface Preparation:**

Substrate must be sanded using 120, 150 or 180 grit paper prior to priming. Primer should be sanded with 280/320 grit paper prior to being coated. The Primer should be coated within eight hours of being sanded. Appropriate primers are the Chemcraft 550-3500, 550-3501, 550-3502, 550-1600, 550-1602, 550-1760, and 550-1761.. When recoating, the previous coat of the AQUASILK 400TW 2K White Polyurethane Waterborne Topcoat must be sanded and the next coat applied within eight hours of being sanded.

General Information:

**After mixing part A and part B to the correct ratio, water can then be added to reduce viscosity prior to application as needed depending on spray equipment. A maximum of 10% water can be added to the fresh (immediately after the part B is fully dispersed into part A) catalyzed material.

Note: Adding extra water during application **is not recommended** as this will have a direct impact on the pot life. The pot life of the mixture will be reduced significantly and the mixture will gel quickly.

The mixed product contains 876-3400, an isocyanate based co-reactant. Please follow all precautions associated with handling and use of those materials. Refer to MSDS for detailed information. Product must be thoroughly stirred before adding the hardener in the recommended ratio. The viscosity of the product should be monitored after mixing with the hardener. The relative humidity in the application and drying room should not exceed 75% for maximum coating performance.

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.

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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