TECHNICAL DATA SHEET

AQUALACK 480

CONVERTER BASE 1K / 2K

DESCRIPTION

AQUALACK 480 Converter is a high quality water based pigmenting base top coat with good chemical resistance, minimal grain raise and good wetting of the wood. AQUALACK 480 has an optional catalyst to increase performance.

HAPs free

PRODUCT DATA

Color	N/A	**VOC less exempts**	50 g/L	0.45 lb/gal0
Solids % by Vol	41% ± 2%	**VOC actual**	50 g/L	0.45 lb/gal
Solids %by Wt	49% ± 2%	**Photochemical reactive**	No	
Density	1.25 ± 0.02	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F #4 Ford	50-65 ± 2	**Shelf life**	12 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	5, 15,30,50,100/Available in other gloss level	**Theo-coverage @1 mil dry**	660-670 Sq.Ft/gal	13-14 m^2/L

PREPARATION/APPLICATION

Working Temp >18°C/65°F surface, coating and air

Catalyzation Optional for optimal chemical resistance 5 % by volume using CW 7800 or CW 7900 catalyst.

Pot life 2 hours (when catalysed with CW 7800 catalyst)

Reducer Product can be applied without reduction. If reduction is needed to optimize application, reduce 5-10% by volume with distilled water, or HRX L (medium reducer), or HRX SL (slow reducer) and HRX Retarder can be used to slow

Suggested Primer HYDROPRIME X, HYDROSAND 493

Application

- Prime- Apply a full coat of a recommended primer at 4.0 – 6.0 wet mils.
- Allow to dry. Sand with 240, 320 paper, or sponges as required. Topcoat within 8 hours of sanding
- Topcoat – apply AQUALACK 480 at 4.0 - 6.0 mils wet
- For more depth or build, sand and apply an additional coat.

Surface Preparation Wood surface must be clean, dry, and finish sanded with 180 grit sandpaper Substrate should be clean and free of grease and oil to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.

Use Directions For interior use only. Catalyze, adjust viscosity and stir thoroughly before application to avoid variations application. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.

App equip. Conventional, Airless and Air Assist Equipment.

Tinting Can be tinted up to 20% maximum with colorants AQUATINT

Cleanup Clean tools/equipment immediately after use with HRX Kleaner or warm water.

DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	**Dust free time**	20 minutes	**Dry to sand**	60 minutes
		Dry to touch	25 minutes	**Dry to recoat**	1 hour
		Dry to Handle	45 minutes	**Dry to stack**	48 hours
Force dry	45 °C/110°F	30 minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Dilution %	Thickness Film (Mils)
Conventional spray	40-60	-	2-2.5 / 0,078-0.098	5-10	4-6
Airless Spray	20-30	1100-1600	9-11 / 0,35-0.43	5-10	4-6

The use of pre-atomizers and pre-heaters, to bring the temperature to 30 – 40 °C, ensures a correct application regardless the room temperature. The drying process should be carried out in environments with adequate air ventilation (the recycle of air in the drying room should be carried out every 15-20 minutes).

Note: All measurements and application equipment settings are based on application at a temperature of 77°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Must be agitated before and during using.
- Use stainless steel spray equipment. Tank, piping, and containers should be lined steel or plastic
- Do not expose to freezing temperatures. The liquid coating will not handle any freeze/thaw cycles.
- Apply over recommended LORCHEM primer. Please contact your LORCHEM representative for system recommendations.
- The application on Nitrocellulose basecoat is not recommended.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may show cracking tendencies.
- Very low temperature application (less than 12°C) may cause poor mechanical and chemical film properties.

CAUTIONS

TESTING

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

CONTACT

PH: +1(450)424-4000
F: +1(450) 424-9134
http://www.lorchemintl.com

LORCHEM INTERNATIONAL
150,Rue Aimé-Vincent Vaudreuil, Dorion,
QC J7V5V5