Lorchem

TECHNICAL DATA SHEET

AQUA FOND 2K

Waterborne Transparent Basecoat Two component

Main product characteristics			
Typical Proprieties :	Fast drying	High transparency	Excellent hardness
Recommended use for :	tables	stairs	Doors
Applications Method:	By conventional Spray gun	Air less	Air mix
Main Purpose :	The Acquapur fond 2k clear is used for indoor coating cycles for hardwoods and softwoods. It is suitable for doors, furniture and etc.		

Gloss levels available			
N/A			

Chemical – Physical characteristics (20 °C)		Application Properties	
Solid Content (%)	37 ± 1	Vertical Hold (µm wet)	140
Specific Gravity (g/cm^3)	1,04 ± 0,02	Recommended N° of coats	1-2
Viscosity ASTM 4 RPM 50	2000 - 2500	Recommended quantity per coat (gr/m^2)	min: 100 max: 120
Pot life	3 hours	Metric yield (m^2/kg)	8 - 10

General information				
Dry at 20°C and UR% between 45 - 65: 100 g/m^2		**Dry in tunnel: 100 g/m^2**		
Dust free	25 minutes	Dust free	25 minutes	Dust free
Handling	30 minutes	Handling	30 minutes	Handling
Overcoat wet on wet	1 - 3 hours	Overcoat wet on wet	1 - 3 hours	Overcoat wet on wet
Overcoat with topcoat	8 - 10 hours	Overcoat with topcoat	8 - 10 hours	Overcoat with topcoat
Sand ability	4 hours	Sand ability	4 hours	

Substrate Preparation

Raw woods: Clean the substrate well, removing all traces of wax, grease and resin. Maximum wood moisture should be between 10 and 14%.Surfaces must be sanded with 150 -180 grit sanding paper, to avoid fibre swelling.

Application Instructions

To obtain the best results it is necessary to use the right equipment in order to better atomize the varnish.
Here follows some suggestions for spraying applications:

Use	Dilution %	Nozzle	Press. Air / bar	Press. Vanish / bar
Conventional spray gun	10 - 20	1,8 - 2	3 - 4	--
Air mix	--	09 -11	1 - 2	80 -110
Air less	--	09 -11	--	120 - 150

The use of pre-atomizers 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 and remarks

- Mix the product before use.
- The shelf life is 12 months if the products are stored in an environment with temperature between 5 - 35°C.
- The product application on substrate must be done in an environment with no less than 12°C. Coatings applied at lower temperatures will show chemical and mechanical properties lower than standard performances that can be normally achieved.
- Coating left overs (washing waters, waters from spray booths, used coatings) must be disposed according to local regulations. Never dispose residues directly into drains.
- Application tools must be cleaned with water after use. When dry films must be removed, the special detergent **HYDROCLEANER** should be used, letting it work overnight and then cleaning with water.

All our technical data sheets are compiled according to our best studies and are not binding. The user assumes all risks of use. A perfect result depends on a number of factors; the nature of the substrate, the technical and physical possibilities and the user's application technique.

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Lorchem Industrial Wood Coatings
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