

# TECHNICAL DATA SHEET

**AF54\*\*/00**
**1K / 2K CLEAR SELF-SEAL TOPCOAT (WATER-WHITE)**
**AF5405 Clear (5 sheen)**
**AF5420 Clear (20 sheen)**
**AF5490 Clear (90 sheen)**

Versions	5, 20, 90
Color:	Clear / Water-White
Area of use:	Flat parts, turned parts, frames, baseboards, wall paneling, doors
Method of use:	By spray: conventional, airmix, airless, electrostatic (provided that any equipment used is suitable for waterborne products)
Mixing procedure:	Ready to use. If necessary, thin with tap water up to 5-10%. If retarder is needed, use up to 5% WR7025 For improved performance options – <b>*See cross-linking guidance below</b>

## Technical characteristics

Solids content (%): As packaged	Weight Solids 24 ± 2 / Volume Solids 22 ± 2
Specific gravity (kg/l): As packaged	1.030 ± 0.030
Viscosity (Zahn #3 at 68°F)*:	22 – 32 ± 5 seconds
Pot Life:	*24 hours if optional cross-linker is used
Recommended wet film thickness:	3.0 -7.0 mils
Spread Rate:	353 sq. ft./gal @ 1.0 mil DFT, No loss
Drying time (at 68°F):	Dust free 20 minutes Touch dry 60 minutes Stackable 24 hours
VOC (Theoretical as packaged, maximum):	0.32 lb./gal, 38 g/L (less exempt solvents)
VHAPS (Theoretical as packaged, maximum):	0.07 lb./lb. of solids
Shelf-life:	15 months, unopened. After long periods of storage, always check homogeneity and stir well before use to eliminate and possible sediment.

\*WARNING: Actual viscosity of some pigmented and/or thixotropic products may differ from the viscosity shown on the Technical Data Sheet. Differences are to be considered acceptable if within 30%.

**AF54\*\*/00 1K-2K Clear Self-Seal Topcoat** is a self-sealer for interiors, ensuring good hardness, transparency, and smoothness to the touch. It can be applied alone or as a topcoat over **AU0420** 1K WB Basecoat Clear Sealer or **AU0392** 2K WB Clear Basecoat Sealer. It is also suitable for open pore systems and for arte povera style furniture

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## **Substrate preparation**

Wood – New Work (interior only): Must be clean, dry and finish sanded. Substrate should be free of grease, oil, dirt, fingerprints, and any contamination. Moisture content of wood should be 6-8%.

Previously finished wood (interior only): Strip old finishes completely and remove all contaminants from the surface. Make sure surface is dry. Finish as new work

**Testing:** The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

## **Sanding of the basecoat or of the first coat of AF54\*\*/00**

In case a higher build is required, and a specific high solids basecoat has been applied, AF54\*\*/00 can be applied as a topcoat on the waterborne basecoats for interiors from the HYDROPLUS range. We always recommend sanding the first coat or the basecoat with 320-400 grit sandpapers. For best results, use stearate sandpaper, which provide excellent de-dusting and much higher efficiency than conventional sandpaper. Ask your abrasives supplier for information on specific papers for waterborne products. Before applying the last coat, it is very important to make sure that the basecoat is thoroughly clean and free from grease, wax or resins.

## **\*Chemical resistance and crosslinker**

To increase chemical resistance and surface hardness further on, 1% of XA4080/00 cross-linker (see Technical Data Sheet) can be added under stirring conditions.

## **Drying**

Drying of waterborne products must take place at temperatures not below 15°C / 59°F and at a relative humidity preferably not exceeding 85%. Out of these limits, there is a slowing down of the drying and/or formation of a less hard and resistant film. It is always advisable to have forced dry air circulation, initially at room temperature and then at 20-30°C / 68°F-86°F.

## **Stacking**

AF54\*\*/00 has an excellent drying speed, but in case of forced drying, and considering the wide variety of ovens and tunnels existing on the market, a preliminary stickability test is always recommended. The natural thermoplasticity of the resins used in water-based coatings makes them more delicate when stacked. Moreover, depending on how the coated items have dried, different results may be achieved. A strong ventilation with moderately hot air, a low humidity rate, a correct spreading rate and the use of XA4080/00 cross-linker in the topcoat may significantly reduce time and risks linked to stacking.

The following recommendations always apply:

- Stack the coated items at least 24 hours after coating
- Always use a proper packaging material between the panels
- When possible, stack vertically

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## General Considerations

- Keep from freezing. Do not store at temperature below 5°C / 41°F.
- Do not apply at temperature below 15°C / 59°F.
- Stir the product well before application to disperse any possible sedimentation. This operation is essential to ensure even matting on the substrate.
- Application residues, including washing water and booth water must be disposed of according with the rules in force. Do not pour into drains.
- Because of the variety of materials used to manufacture wood furniture, when moving to a waterborne system from a solvent-based system, it is very important to check with the supplier the suitability of equipment and components used, with particular attention to electrostatic guns, pumps, seals, silicones, glues, products for booth water treatment, packing materials, sanding papers, putties, etc.
- The use of coating devices not in perfect order (defective gaskets, too high pressures) or of pumps with low capacity may cause major defects in the coating film (air bubbles).
- Once the can has been opened, the coating may rot because of the attack of bacteria commonly present in the air. This phenomenon is easily detectable because of the bad smell and by an increase of viscosity of the product stored in the can. Avoid recovering the used coating in fresh product cans and also to leave them open, particularly during summertime.

## FOR INDUSTRIAL SHOP APPLICATION ONLY

**Thoroughly review product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.** To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit [www.paintdocs.com](http://www.paintdocs.com). Please direct any questions or comments to your local M.L. Campbell® Distribution Partner, M.L. Campbell® Sales Manager or contact our technical service line at 1-800-364-1359

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