SAYERLACK®
INNOVATIVE WOOD SOLUTIONS

TECHNICAL DATA SHEET

AT48/00** | **1K / 2K WATERBORNE CLEAR TINT-BASE / TOPCOAT**

AT481000 Clear (10 sheen) **AT482000 Clear (20 sheen)** **AT484000 Clear (40 sheen)**
AT488500 Clear (90 sheen)

Versions	10, 20, 40, 90		
Area of use:	Doors, furniture components		
Method of use:	Airmix, airless, conventional, electrostatic spray gun, if equipment is suitable for use with waterborne products		
Mixing procedure:		**By Weight (kg)**	**By Volume**
Part A	**AT48**/00**	100	100
Part B (Extended Pot-Life)	***AH1550/00**	10	10
or Part B (Max. Performance)	***AH1545/00**	10	10
Thinner	**Water**	0-10	0-10
Retarder	**WR7025**	3-5	3-5

Technical characteristics

Solids content (%): As packaged	Weight Solids 36 ± 2 / Volume Solids 32 ± 2
Specific gravity (kg/l): As packaged	1.030 ± 0.030
Viscosity (Zahn #2 at 68°F)*:	45 ± 5 seconds
Pot Life:	***AH1550/00** 8 hours ***AH1545/00** 3 hours
Recommended wet film thickness:	3.0 - 5.0 mils
Spread Rate:	513 sq. ft./gal @ 1.0 mil DFT, No loss
Drying time (at 68°F):	Touch dry 2 hours Through dry 8 Hours Stackable 24 hours
VOC (Theoretical as packaged, maximum):	0.64 lb./gal, 77 g/L (less exempt solvents)
VHAPS (Theoretical as packaged, maximum):	0.20 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.
Tinting	8% **by volume** with XA2006/XX WB Paste

*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%.

AT48/00 1K/2K Waterborne Clear Tint-Base & Topcoat** is an acrylic-polyurethane waterborne topcoat that can be applied over waterborne clear or pigmented basecoats in coating systems for interior furniture or furniture components. *It can be used as is or catalyzed for improved performance advantages.

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AT48/00 ensures following characteristics:**

- Easy mixing with the hardener
- Very high yellowing resistance and light fastness
- Excellent surface hardness
- Good vertical hold
- Excellent flow
- Very smooth surface
- Excellent chemical resistance even against alcohol

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

Prime or Seal: With one or more coats of Hydroplus® waterborne basecoat, suitably dried and sanded.

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.

***Chemical resistance and Catalyst Mixing Instructions**

AH1545/00: pre-thin with 5% of tap water and hardened at **10%** for AT48**/**00**.
AH1545/00 has a high reactivity, a pot-life of approximately 3 hours and high chemical resistance.

AH1550/00: pre-thin with 5% tap water and hardened at **10%** for AT48**/**00**.
AH1550/00 has a pot-life of approximately 8 hours (thus enabling a much longer processing of the product after catalysis – see AH1550/00 technical data sheet) and gives to the final blend a higher gloss level: 3-5 gloss more than that achieved with other hardeners.

***Use as a Convertor Base**

AT48**/**00** except 90 gloss version, is suitable for use as converter for color-matching systems. It can be mixed with up to **8%** by volume to achieve full tone colors.

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Application

By spray (airless, airmix or conventional) both horizontally and vertically. We advise against using very thick layers of topcoat in a single application since uneven drying of the film can give rise to cracking, especially in areas of buildup (grooves in shaped panels).
Following are some guidelines:

1. Conventional spray: 1.9 mm nozzle, pressure: 3-4 bar
2. Airmix: 11 mm nozzle, pressure of coating: 80-100 bar; air pressure: 1-2 bar
3. Airless: 11 mm nozzle, pressure of coating: 150-200 bar
4. The use of a pre-atomizer and/or of a pre-heater (30-35°C) has given excellent results in terms of flow and quality consistency.

If application devices are not in perfect conditions (defective gaskets, too high pressure, etc.) they may cause major air bubble defects in the coatings film. We recommend the use of 2-head pumps to reduce waste and to improve the quality of the coating applied in terms of resistance to stacking and to chemicals.

Drying

2-pack waterborne products must be dried in rooms with temperatures no lower than 15°C / 59°F and relative humidity no greater than 70%. Outside this range drying is slower and/or the film is formed with poorer hardness and chemical resistance. For good drying it is advisable to use a forced flow of dry air initially at room temperature and subsequently at 35°C / 95°F.

General Considerations

- When used without hardener or with hardeners different from AH1550/00, gloss level is likely to be 3-5 gloss lower.
- Do not store the product at temperatures below 5°C / 41°F or above 35°C / 95°F
- Coating residues must be disposed of in accordance with current legislation. Do not pour residues down drains.
- In view of the wide variety of materials used for manufacturing wooden products, when switching from solvent based to a waterborne coating system it is always advisable to contact your suppliers' technical departments to check whether your equipment and components are. Check: electrostatic guns, pumps, seals, silicones, glues, booth treatment water products and packaging materials.
- Once the can has been opened, the waterborne protective wood stay may rot because of the attack of bacteria, mold, and fungi commonly present in the air. This phenomenon is easily detectable because of the bad smell, increase of viscosity, mold on the surface, and change of color. This problem may take place also in case of products left for a long time in vessels for dipping or flow-coating application, mainly during summertime. The use of drinking water, a frequent cleaning of the plant (possibly with disinfectant solutions)
- Advice provided in our technical data sheets are the result of our application experience. However, the many substrates, their pre- or post-treatments (gluing, sanding, tinting, storage conditions, etc.) as well as the application conditions may all lead to many different situations. As a result, it is always necessary to check product suitability in relation to the specific conditions it will be used.

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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. 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