

TECHNICAL DATA SHEET

AT99/A0**
1K / 2K WATERBORNE CONVERTER TOPCOAT NEUTRAL / CLEAR
AT9905/AO Neutral (5 sheen)
AT9915/AO Neutral (15 sheen)
AT9930/AO Neutral (30 sheen)

Versions	5, 15, 30
Area of use:	Flat parts, turned parts, picture frames, furniture, skirting board, matchboards.
Method of use:	Spray (conventional, airmix, airless and electrostatic, provided equipment suitable for waterborne products is used).
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 – *See cross-linking guidance below.

Technical characteristics

Solids content (%): As packaged	Weight Solids 29 ± 2 / Volume Solids 25 ± 2
Specific gravity (kg/l): As packaged	1.020 ± 0.030
Viscosity: (Brookfield - RV4, 20 rpm, 20°C/68°F)	4400 ± 1300 cPs
Pot Life:	24 hours with Optional Cross-Linker
Spread Rate:	353 sq. ft./gal @ 1.0 mil DFT, No loss
Recommended wet film thickness:	4.0 - 5.0 mils
Drying time (at 68°F):	Dust Free: 30 minutes Dry to Touch: >1 hour Stackable: 24 hours
VOC (Theoretical as packaged, maximum):	0.49 lb./gal, 58 g/L (less exempt solvents)
VHAPS (Theoretical as packaged, maximum):	0.09 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:	11.5% 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%.

AT99/A0 1K / 2K Waterborne Converter Topcoat Neutral / Clear** is a one-pack waterborne topcoat suitable for coating wooden products for indoor use which ensures excellent hardness and good chemical resistance. In application it is extremely fluid and has excellent wetting.

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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

Prime: Prime with one or more coats of Hydroplus® waterborne basecoat systems properly 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 Cross-linker Mixing Instructions

AT99**/A0 can be used as it is. However, to further improve chemical resistance, add slowly while stirring 0.5-1% cross-linker XA4080/00, premixed 1:1 with water and used immediately.

The use of **XA4080/00** is particularly recommended for flat parts subjected to hardware or contact with chemicals. Such performances are further improved by **double-crosslinking** with:

XA4080/00	0.5% - 1.0% (previously mixed 1:1 with water)
XA4095/00	3.0%

The above shall be added one after the other following the above order, slowly and under stirring.

*Use as a Convertor Base

AT99**/13 is suitable for use as convertor for color-matching systems. It can be mixed with up to **11.5%** of XA2006/XX WB Paste by volume to achieve full tone colors.

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 for drying to be forced, with air previously de-humidified and warm (20°C - 30°C / 68°F – 86°F)

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Stacking

The natural thermos-plasticity of the resins used in waterborne coatings makes them more delicate when stacked. Moreover, depending on how the coated items have dried, different results may be achieved. Incorporating strong ventilation with moderately hot air, a low humidity rate, a correct spreading rate and the use of XA4080/00 and XA4095 crosslinkers 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 used a proper packaging material between the panels
- When possible, stack vertically

General Considerations:

- On some wood species, even those species commonly used for pigmented topcoat application, the basecoat may dissolve natural oils/tannins in the wood and cause tanning yellowing. This color is liable to float to the surface even after the application of more than one coats of waterborne topcoat. White basecoat must therefore be used only on MDF (but check the quality of the MDF first) or as a colored basecoat for pigmented topcoats in colors other than white.
- Store the product in rooms where the temperature does not fall below 5°C / 41°F.
- During application, keep the product, the substrate, and the room at a temperature of at least 15°C / 59°F.
- Coating residues (washing water, booth water, used coating) must be disposed of in accordance with current legislation. Do not pour residues down drains.
- Due to wide variety of materials used for manufacturing wooden products, when switching from a 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 appropriate or whether more suitable types exist. Check: electrostatic guns, pumps,

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

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