

# TECHNICAL DATA SHEET

**AU0472/13**
**1K / 2K WATERBORNE WHITE BASECOAT / PRIMER**
**AU0472**

Colors	White		
Area of use:	Flat parts, frames, baseboards, doors		
Method of use:	Airmix, airless, conventional spray gun ix, airless, conventional, electrostatic spray gun, if equipment is suitable for use with waterborne products		
Mixing procedure:		<b>By Weight (kg)</b>	<b>By Volume</b>
	Part A	<b>AU0472</b>	100
	Part B (hardener)	<b>*AH1550/00</b>	4
	Thinner	<b>Water</b>	0-5
	Retarder	<b>WR7025</b>	3-5

## Technical characteristics

Solids content (%): As packaged	Weight Solids 32 ± 2 / Volume Solids 28 ± 2	
Specific gravity (kg/l): As packaged	1.380 ± 0.030	
Viscosity (DIN 6 at 20°C):	45" ± 5"	
Pot-life (at 68°F):	12 hours	
Recommended wet film thickness:	4.0 - 7.0 mils	
Max # of Coats:	3	
Spread Rate:	449 sq. ft./gal @ 1.0 mil DFT, No loss	
Drying time (at 68°F):	Dust Free	20 minutes
	Touch Dry	25 minutes
	Overcoat	1 hour
	To Sand	4 hours
	Stackable	8 hours
VOC (Theoretical as packaged, maximum):	1.90 lb./gal, 155 g/L (less exempt solvents)	
Shelf-life:	15 months, unopened. After long periods of storage, always check homogeneity and stir well before use to eliminate and possible sediment.	
Tinting	4% <b>by volume</b> 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%.

**AU0472/13 2K Waterborne White Basecoat / Sealer** is a 2-pack basecoat applicable by spray directly on MDF or Masonite substrates. It has a high pigment content and a high solids content, thus ensuring an excellent filling power and even color consistency even at high wet film thickness weights.

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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.

## \*Drying and catalysis

AU0472/13 should be hardened with **AH1550/00 at 4%**: by doing so, the product acquires a high elasticity and a higher build than 1-pack products. **However, it can also be used without hardener.** If so, it is necessary to consider that its properties as a barrier decrease and its sensitivity to low temperatures increases.

In industrial applications, where drying is forced and at temperatures above 30°C / 86°F, AU0472/13 either with or without hardener, is stackable after a very short time.

When used without hardener, it is necessary to keep the substrate and its temperature above 20°C / 68°F or, preferably, to work in a temperature-controlled tunnel.

## Sanding of the basecoat

For sanding, we recommend stearate abrasive papers for best results. We advise against an excessive removal of the basecoat since this would result into a raising of the MDF grain fibers by the waterborne topcoat.

After sanding, AU0472/13 can be overcoated with all Hydroplus waterborne products.

## Tinting:

To prepare colored bases, it is possible to add to AU0472/13 up to a total 4% of **XA2006/XX** pigmented pastes for waterborne products.

## Application

By spray (electrostatic, airless, airmix or conventional) both horizontally and vertically. Following are some guidelines:

1. Conventional spray: 1.9-2.2 mm nozzle, pressure: 3-4 bar
2. Airmix: 11-13 mm nozzle, pressure of coating: 80-100 bar; air pressure: 1-2 bar
3. Airless: 11-13 mm nozzle, pressure of coating: 150-200 bar
4. The use of a pre-atomizer and/or of a pre-heater (30°C - 35°C / 86°F - 95°F) 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 defects in the coatings film (e.g. air bubbles).

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## Application on timber

AU0472/13 can be applied on timbers only if hardened at least at 4%. In such a condition, the basecoat acquires barrier-properties that allow staining on those timbers containing colorful substances, such as: oak, acacia, ash. If applied on bare wood, the first coat can let the colorful substances surface. However, the following coats won't color wood anymore, thanks to the barrier action played by the first coat. In order to guarantee the barrier-power it is important to verify that the first coat has a thickness of at least 150–180 µm and that sanding, if necessary, is only a superficial one. For these reasons, therefore, AU0472/13 cannot be used to achieve an "open-pore" effect.

## Viscosity Climb Warning

Due to weather variations, viscosity may vary from that shown on this data sheet. For AU0472/13, viscosity variations within 20% must be regarded as normal.

## General Considerations

- During application, the temperature of the product, the substrate and the environment must be no lower than 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 the drain. In view of the wide variety of materials used for manufacturing wooden products, when switching from a solvent-based to a waterborne painting 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, seals, silicones, glues, booth treatment water products, packaging materials, putties, sandpaper, etc

## 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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