

Technical Data Sheet

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Data Sheet No. 2470


Aquakote 247 Spray Filler



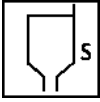

Description	
Product description	Water-borne, white spray filler. The product is characterised by its high filling capacity, fast-drying and good sandability.
Raw material base	Polyurethane polymers
Area of application	Furniture and interiors, interior doors, kitchens. For priming MDF boards, blockboards, plywood and fibreboard. The filler can be coated with water-borne and solvent-based enamel paints
Form of supply	White
Colours	
Gloss level	Matt
Packaging	1 , 3 or 5 litre tins



Technical Data	
The data apply for:	They can vary for other shades.
Specific gravity (23 °C)	1.41 g/cm ³
Solids content	57 ± 3 % by weight
Organic solvents	3 ± 0.5 % by weight
VOC content (EU)	65 g / l
Shelf life at 20 °C	6 months in well-sealed original containers
Theoretical coverage	220 g/m ² → 4.4 m ² /kg for 80 µm dry coat thickness






Safety Data	
	Please refer to our safety data sheet 247000 as well as the instructions on the label.

Preparation				
Substrate	Product		Data sheet	Layer thickness Application
MDF / HDF	247	2-3 x Aquakote 247 Spray Filler Intermediate sanding, grain 220-240	2470	220 - 250 g/m ²
	2575	Aquakote CT	2575	120 g/m ²
Foil-laminated boards	247	1-2 x Aquakote 247 Spray Filler Intermediate sanding, grain 220-240	2470	170- 200 g/m ²
	2575	Aquakote CT	2575	120 g/m ²
Please contact our technical staff for further application suggestions.				

Surface preparation		
	Substrate	Every substrate must be clean, dry and free from grease and oil.
	MDF GF (priming film)	Always apply coatings on newly-sanded surfaces. First clean with V4217, then sand the film with grain 180 to 220
	MDF / HDF untreated	Sanding grain 180 – 220 On MDF boards with a density of below 700 kg/m ³ the surface must be pre-isolated or pre-treated with Avkote 3910 Primer or Avkote 242 Furniture. Strengthen the edges and cut sections with Avkote 3910 Primer or Avkote 242 Furniture. Use moisture-resistant wood-based materials for objects exposed to high humidity levels (e.g. kitchens, bathrooms etc.). Do not use on horizontal surfaces.

Application		
	Precautionary measures	We recommend wearing protective clothing even in cases where no local regulations are in force. The precautions according to local regulations with respect to hygiene and equipment must be observed.
	Stirring	Stir well before use.
	Dilution	With water
	Brush painting	No

	Rolling	No
	Trowel application	No

		Viscosity	Dilution	Nozzle	Pressure	Spray coats
	Gravity feed gun	Form of supply	0-5%	1.8-2.5 mm	1.8-2.5 bar	1-2
	Airless (airmix) spraying	Form of supply	0-5%	13	3 bar M 1.0-1.5 bar atom.	1-2
	HVLP paint gun	Form of supply	0-5%	1.8-2.5 mm	1.8-2.5 bar	1-2
	Evaporation	---				
	Drying time	For µm dry film at 23 °C and 65 % relative humidity				
		Dust-dry	after:	30	min	
		Touch-dry	after:	2	hours	
		Recoatable	after:	4	hours	
		Fully cured	after:	4	hours	

Important Information	
Special restrictions	Warning: Always carry out an adhesion test on foil-laminated boards!
Minimum application and drying temperature	+16 °C The temperature of the floor, air and material must not be below this temperature
Coat removal	Paint stripper
Equipment clean-up	Immediately after use with water.

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