

Technical Data Sheet



Edition dated: 07.03.06

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Data sheet Nr. 5494/1483

AVKOTE 1483 Clear Gloss Lacquer

Product description	Air-drying two-component clear lacquer	
Binding Agent	Polyurethane / acrylic resin combination	
Areas of Application	Air-drying clear lacquer for high-quality coating of PVC Profiles. May also be used for interior applications.	
Form of Supply	Colours	Clear
	Gloss Level	Medium Gloss
Hardener	Avkote Hardener 279	
Packing	Coating	1, 3 and 5 Litre disposable containers
	Hardener	1 Litre disposable containers

Technical Data

The data is valid for Avkote 1483 Clear Gloss Lacquer. The values can change for other colours.


	Coating		Hardener		Mixture							
Specific Gravity (23 °C)	0.96	g/cm ³	0.99	g/cm ³	0.97	g/cm ³						
Solids content	32	± 2 Weight-%	46	± 2 Weight-%	37	± 2 Weight-%						
Organic Solvent Content.	67	± 2 Weight-%	54	± 2 Weight-%	63	± 2 Weight-%						
VOC Content (CH / EU)	64.5	%	645	g/l	53.4	%	534	g/l	60.8	%	608	g/l
Shelf life at 20 °C	12 Months		6 Months in well shut containers									
Theoretical Coverage	125 g/m ² →8		m ² /kg for 40		µm dry layer thickness							

Safety Data	Coating	Hardener
Flash point	-5 °C	0 °C
Transport ADR/RID	Class: 3 VP: II	Class: 3 VP: III
Poison classification (EU)		
VVS disposal code (EU/CH)	08, 08 01, 08 01 11	08, 08 01, 08 01 11



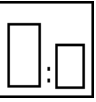
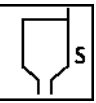






Application Recommendations

Substrate	No. of Coats	Product	Dry Film thickness	Data sheet
PVC Profiles	1 x Top Coat	Avkote LE, Avkote HR or Avkote PC	30-50 µm	5494/1483
	1 x Lacquer	AVKOTE 1483 Clear Gloss Lacquer	30-50 µm	
For further application proposals please ask our technical department.				

Preparation

	Substrate	Every substrate must be clean, dry and free of grease and oil.
	PVC Profiles	Clean with Avkote 153b Cleaner first then with Avkote 154 Cleaner.

Processing

	Preventative measures	We recommend the wearing of protective clothing even if not stipulated by law. The national and regional health and safety regulations for work hygiene and equipment are to be observed. Pay attention to our safety data sheet Nos. 148300 and 279H00.				
	Stir	Before use ensure contents are stirred together well with hardener if applicable.				
	Mixing Ratio	4 : 1 by volume with Avkote 279 hardener				
	Pot life at 20 °C	8 Hours				
	Thinners	Dilute with thinners 95 (slow) or 13000 (fast) to application viscosity according to the table shown below.				
	brush	Not recommended				
	Roll	Not recommended				
		Viscosity DIN-4	Thinners	Nozzle	Pressure	Spray coats
	Gravity Feed Spray-gun	16-20" DIN-4	10%	1.4 - 1.8 mm	3 - 4 bar	2
	Suction-spray-gun	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2
	Airless-(Airmix)-Spray	22 - 25" secs	25 %	11/40	3 – 4 bar Atomising air 1.5 - 2	1 - 2
	HVLP paint gun	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2

	Evaporation time	Prior to drying at temperatures over 40 °C allow an evaporation time of 15 minutes.																				
	Drying time	For 40 µm dry coating at 65 % of relative humidity																				
	At 20 °C	<table border="0"> <tr> <td>Tack-Dry</td> <td>after:</td> <td>10</td> <td>Minutes</td> </tr> <tr> <td>Touch – Dry</td> <td>after:</td> <td>60</td> <td>Minutes</td> </tr> <tr> <td>Dried (Can be sanded)</td> <td>after:</td> <td>2</td> <td>Hour</td> </tr> <tr> <td>Suitable for re-coating</td> <td>after:</td> <td>2</td> <td>Hours</td> </tr> <tr> <td>Completely Dry</td> <td>after:</td> <td>10</td> <td>days</td> </tr> </table>	Tack-Dry	after:	10	Minutes	Touch – Dry	after:	60	Minutes	Dried (Can be sanded)	after:	2	Hour	Suitable for re-coating	after:	2	Hours	Completely Dry	after:	10	days
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Important references

Specific restrictions	Relative humidity max. 80 %		
Minimum application- and drying temperature	15	°C	Do not apply at temperatures below the dew point
Coating removal	With paint stripper		
Equipment cleaning	Clean immediately after use with Gun Wash Thinners or U Cleaner.		

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