

# Technical Data Sheet



Edition dated: 07.03.06

Replaces Edition dated: 27.05.03

Data sheet Nr. 5494/1484

## AVKOTE 1484 CD Lacquer

<b>Product description</b>	Catalytic drying two-component clear lacquer
<b>Binding Agent</b>	Polyurethane / acrylic resin combination
<b>Areas of Application</b>	A high quality 2K lacquer specially designed for use in with Catalytic Dryers on production lines.
<b>Form of Supply</b> Colours	Clear
Gloss Level	Satin Gloss (When dried in a Catalytic Dryer) Matt (When left to air dry)
<b>Hardener</b>	Avkote Hardener 279
<b>Packing</b> Coating	1, 3 and 5 Litre disposable containers
Hardener	1 Litre disposable containers

### Technical Data

The data is valid for Avkote 1484 CD Lacquer. The values can change for other colours.


	Coating		Hardener		Mixture							
<b>Specific Gravity (23 °C)</b>	0.96	g/cm <sup>3</sup>	0.99	g/cm <sup>3</sup>	0.97	g/cm <sup>3</sup>						
<b>Solids content</b>	33	± 2 Weight-%	46	± 2 Weight-%	37	± 2 Weight-%						
<b>Organic Solvent Content.</b>	67	± 2 Weight-%	54	± 2 Weight-%	63	± 2 Weight-%						
<b>VOC Content (CH / EU)</b>	64.5	%	645	g/l	53.4	%	534	g/l	60.8	%	608	g/l
<b>Shelf life at 20 °C</b>	12 Months		6 Months in well shut containers									
<b>Theoretical Coverage</b>	125 g/m <sup>2</sup> →8		m <sup>2</sup> /kg for 40		µm dry layer thickness							

<b>Safety Data</b>	<b>Coating</b>	<b>Hardener</b>
<b>Flash point</b>	-5 °C	0 °C
<b>Transport ADR/RID</b>	Class: 3 VP: II	Class: 3 VP: III
<b>Poison classification (EU)</b>		
<b>VVS disposal code (EU/CH)</b>	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 or Avkote HR	30-50 µm 30-50 µm	5393/LE 5360
	1 x Lacquer	Avkote 1484 CD Lacquer	30-50 µm	5494/1484
Textured GRP	1 x Base	Avkote LE or Avkote HR	30-50 µm 30-50 µm	5393/LE 5360
	1 x Stain	Aquakote 220 Brown or 225 Black Stain	5 - 10 µm	8650
	1 x Lacquer	Avkote 1484 CD Lacquer	30 - 50 µm	5494/1484
Avkote 1484 Lacquer must be left to flash to a satin finish before being put into a catalytic dryer otherwise it will dry glossy. This takes approximately 3 minutes at 20°C.				
For further application proposals please ask our technical department.				

### Preparation

	<b>Substrate</b>	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

	<b>Preventative measures</b>	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. 148400 and 279H00.				
	<b>Stir</b>	Before use ensure contents are stirred together well with hardener if applicable.				
	<b>Mixing Ratio</b>	4 : 1 by volume with Avkote 279 hardener				
	<b>Pot life at 20 °C</b>	8 Hours				
	<b>Thinners</b>	Dilute with thinners 95 (slow) or 13000 (fast) to application viscosity according to the table shown below.				
	<b>brush</b>	Not recommended				
	<b>Roll</b>	Not recommended				
		<b>Viscosity DIN-4</b>	<b>Thinners</b>	<b>Nozzle</b>	<b>Pressure</b>	<b>Spray coats</b>
	<b>Gravity Feed Spray-gun</b>	16-20" DIN-4	10%	1.4 - 1.8 mm	3 - 4 bar	2

	<b>Suction-spray-gun</b>	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2
	<b>Airless-(Airmix)-Spray</b>	22 - 25" secs	25 %	11/40	3 – 4 bar Atomising air 1.5 - 2	1 - 2
	<b>HVLP paint gun</b>	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 bar	2
	<b>Evaporation time</b>	Prior to drying at temperatures over 40 °C allow an evaporation time of 15 minutes.				
	<b>Drying time</b>	For 40 µm dry coating at 65 % of relative humidity				
	<b>Catalytic Dryer</b>	Tack-Dry	after:	2	Minutes	
		Touch – Dry	after:	3	Minutes	
		Dried (Can be sanded)	after:	10	Minutes	
		Suitable for re-coating	after:	20	Minutes	
		Completely Dry	after:	1	Hour	

**Important references**

<b>Specific restrictions</b>	Relative humidity max. 80 %		
<b>Minimum application- and drying temperature</b>	15	°C	Do not apply at temperatures below the dew point
<b>Coating removal</b>	With paint stripper		
<b>Recoating</b>	Lightly sand and spray with Avkote 1484 CD Lacquer		
<b>Equipment cleaning</b>	Clean immediately after use with Gun Wash Thinners or U Cleaner.		

This data sheet is for your reference and information only. The above data are correct to the best of our knowledge. We offer no guarantees for use and exclude any liability. This applies in particular to consequential damage. We are not liable for any advice given by our employees. Our employees give non-binding information only. Site supervision, compliance with handling regulations and adherence to recognized engineering rules are the responsibility of the manufacturer, even if our employee was on site during handling. Modifications due to technical developments may be made. The latest version of this information is applicable. In special cases, please request separate technical specifications.