

Technical Data Sheet



Edition dated: 05.02.08

Replaces Edition dated: 05.10.06

Data sheet Nr. 5393/LE

AVKOTE LE

Product description	Especially fast drying, Satin 2K coating with very good weathering characteristics and good resistance to chemicals and mechanical abrasion. Test standard compliance: DIN 68861 Part 1B (Chemical Resistance) DIN 4102 B1 (Non-Flammable)
Binding Agent	2-K polyurethane resin
Areas of Application	High-quality top-coat for PVC, GRP and acrylic surfaces. Please take note of our important recommendations on page 4.
Form of Supply	Colours Most colour ranges available on UK's market. Bespoke colour matching available on request. Gloss Level Silk (30 - 45 gloss level at 60 °)
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 LE white 80. The values can change for other colours.


	Coating		Hardener		Mixture							
Specific Gravity (23 °C)	1.2	g/cm ³	1.0	g/cm ³	1.17	g/cm ³						
Solids content	52	± 2 Weight-%	46	± 2 Weight-%	Appr 51	Weight-%						
Organic Solvent Content.	48	± 2 Weight-%	54	± 2 Weight-%	Appr 49	Weight-%						
VOC Content (CH / EU)	57	%	570	g/lt	56	%	560	g/lt	57	%	569	g/lt
Shelf life at 20 °C	12 Months		6 Months in well shut containers									
Theoretical Coverage	96 g/m ² 10.4 m ² /kg for		30 µm dry layer thickness									












Safety Data	Coating	Hardener
Flash point	27 °C	0 °C
Transport ADR/RID	Class: 3 VP: III	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
PVCu (PVC-Profiles) & GRP	2 x Top Coat	AVKOTE LE	30-50 µm	5393/LE
Polypropylene & Polyethylene	1 x Adhesion Promoter	AVKOTE PP 502	5 - 10 µm	502000
	1 x Top Coat	AVKOTE LE	30-50 µm	5393/LE
Textured GRP	1 x Base	AVKOTE LE	30-50 µm	5393/LE
	1 x Stain	AQUACOTE 220 Brown, 225 Black or Irish Oak Stain		8650
	1 x Lacquer	AVKOTE 1484, 1485, 1487 or 1495 Clear Coat Lacquer	30-50 µm	5494
Other Plastics	Please refer to our Technical Department.			
Old coats of paint (solvent-resistant)	1 x Top Coat	AVKOTE LE	30 - 50 µm	5393/LE
For further application proposals please ask our Technical Department.				

Preparation

	Substrate	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	PVCu (PVC-Profiles)	Take note of our 'Instructions for painting PVC Profile with Avkote LE'. Clean with AVKOTE 153b Cleaner first then with AVKOTE 154 Cleaner. Apply AVKOTE LE.
	GRP	Clean with AVKOTE 154 Cleaner. Apply AVKOTE LE.
	Polypropylene & Polyethylene	Clean with AVKOTE 153b Cleaner first then with AVKOTE 154 Cleaner. Apply AVKOTE PP 502. Leave to dry. Apply AVKOTE LE.
	Textured GRP	Clean with AVKOTE 154 Cleaner. Apply Avkote LE. Leave to dry. Apply Stain with a sponge. Seal stain with AVKOTE Clear Coat Lacquer.
	Other Plastics	Please refer to our Technical Department.
	Old coats of paint (solvent-resistant)	Sand off, clean, primer as necessary.

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. 539300LE and 279H00.				
	Stir	Before use ensure contents are stirred together well with hardener if applicable.				
	Mixing Ratio	10 :1 by volume with AVKOTE 279 hardener Add up to 4:1 (max.) AVKOTE 279 hardener to increase gloss level.				
	Pot life at 20 °C	Minimum 8 hr. according to tone				
	Thinners	Ready to spray. Product supplied thinned. Option for mixing scheme clients only. Dilute with thinners 95 (standard) or 13000 (fast) to application viscosity according to the table shown below.				
	brush	Not recommended				
	Roll	Not recommended				
		Viscosity DIN-4	Thinners	Nozzle	Pressure for HVLP spray guns	Spray coats
	Gravity Feed HVLP Spray-gun	18 - 22 secs	25 - 30 %	1.4mm	2-2.5 bar	2
	Suction-spray-gun HVLP	18 - 22 secs	25 - 30 %	1.4mm	2-2.5 bar	2
	Airless-(Airmix)-Spray	22 - 25" secs	25 %	11/40	3 – 4 bar Atomising air 1.5 - 2	1 - 2
Spray Gun	None 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 50 µm dry coating at 65 % of relative humidity				
	At 20 °C	Tack-Dry	after:	2	Minutes	
		Touch – Dry	after:	10	Minutes	
		Dried (Can be sanded)	after:	1	Hour	
		Suitable for re-coating	after:	2	Hours	
					Max 48 hours	
		Completely Dry	after:	7	days	

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	Not recommended		
Equipment cleaning	Clean immediately after use with Gun Wash Thinners.		

Important Recommendations

	For buildings situated near the sea or in a heavily polluted area or city a clear coat must be applied to protect against the influence of salt air and pollution.
	For pastel coloured coating of surfaces subject to heavy use, such as structural elements, working surfaces etc., it is recommended to clear coat with an AVKOTE 1484, 1485, 1487 or 1495 Lacquer to improve resistance to marking.
	External Applications - We recommend that metallic and pearlescent colours have a clear coat applied over the top to provide extra protection to the colour for longevity.
	Please observe our Material Safety Data Sheets for all products used as well as the instructions on the tin label.
	When using dark colours in exposed locations with a high degree of heat or sunlight we advise the use of AVKOTE HR instead of AVKOTE LE. AVKOTE HR Paint includes a special IR component which helps to minimize any temperature build up from the sun. The black pigment in the colours is replaced with Heat Reflective black which only heats to a maximum of 76°C. This will prevent any warping or distortion of the substrate. Data sheet available upon request.

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.