

AQUASTONE 2K

TWO COMPONENT WATERBASED TOPCOAT



DESCRIPTION

AQUASTONE 2K is a high-quality topcoat designed for use on interior wood products. This waterborne topcoat has good build characteristics and good film hardness. This topcoat has the perfect balance of fast dry times and excellent flow and leveling.



PRODUCT DATA

Color	Clear	VOC less exempt	19.44 g/L	0.15 lb/gal
Solids % by Vol	25% ± 2%	VOC actual	66.99 g/L	0.55 lb/gal
Solids %by Wt	32% ± 2%	Photochemical reactive	No	
Density	1.04 ± 0.02	Flash Point (PM/CC)	N/A	
Viscosity 23°C/73°C(CSP)	20000-30000	Shelf life	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	5, 15,30,50,100/Available in other gloss level	Theo-coverage @1 mil dry	400 Sq.Ft/gal	8 m ² /L

PREPARATION/APPLICATION

Working Temp	>18°C/65°F surface, coating, and air
Catalyzation	10 % by volume using CW7800 catalyst - 10 parts AQUASTONE 2K to 1part CW7800 catalyst.
Pot life	3 hours (23°C)
Reducer	If reduction is needed to optimize application, reduce 10-20% by volume with distilled water or HRX L (medium) or HRX SL (slow reducer) and HRX Retarder can be used
Sealer	AQUAFOND 424
Application	<ul style="list-style-type: none"> SEAL- Apply a full coat of a recommended sealer at 3-5 mils. Allow to dry, sand with 240, 320 paper as required. Topcoat within 8 hours of sanding Topcoat – apply AQUASTONE 2K at 3.0 - 5.0 mils wet
Surface Preparation	Wood surface must be clean, dry, and finish sanded with 180 grit sandpaper Substrate should be clean and free of grease and oil to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.
Use Directions	For interior use only. Catalyze, adjust viscosity and stir thoroughly before application to avoid variations application. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.
App equip.	Conventional & HVLP Siphon Feed, Pressure Pot Systems and Airless/Air Assist Equipment.
Tinting	Can be tinted up to 15% maximum with colorants AQUATINT
Cleanup	Clean tools/equipment immediately after use with HRX Kleaner or warm water.
Standards	This product meets KCMA standards when used with recommended LORCHEM products.

DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	Dust free time	30 minutes	Dry to sand	2-4 hours
		Dry to touch	45 minutes	Dry to overcoat	2-4 hours
		Dry to Handle	1 hour	Dry to stack	8-12 hours
Force dry	45 °C/110°F	30 minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Dilution %	Thickness Film (Mils)
Conventional spray	40-60	-	2-2.5/0,078-0.098	10-20	3-5
Airless Spray	-	120-150	9/0,35	-	3-5

The use of pre-atomizers and pre-heaters, to bring the temperature to 30 – 40 °C, ensures a correct application regardless the room temperature. The drying process should be carried out in environments with adequate air ventilation (the recycle of air in the drying room should be carried out every 15-20 minutes).

Note: All measurements and application equipment settings are based on application at a temperature of 77°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Must be agitated before and during using.
- Use stainless steel spray equipment Tank, piping, and containers should be lined steel or plastic
- Do not expose to freezing temperatures. The liquid coating will not handle any freeze/thaw cycles.
- Apply under recommended LORCHEM topcoat. Please contact your LORCHEM representative for system recommendations.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may show cracking tendencies.
- Very low temperature application (less than 12°C) may cause poor mechanical and chemical film properties.

CAUTIONS

TESTING

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

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