

Technical Data Sheet

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THE SPECIALIST PAINT SUPPLIERS


Data Sheet No. 5393

AVKOTE LE



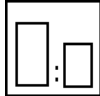
Description	
Product Description:	Especially fast drying, silk gloss 2 pack with very good weathering characteristics and good resistance to chemicals and mechanical abrasion. The paint film meets the DIN 68861 standard, 1 B, is non flammable to Austrian standard B3800, Part 1, B 2, & DIN 4102-1 Class B1. Saliva and sweat-resistant to DIN 53160, formaldehyde-free and resistant to PVC plasticisers and hand-cream.
Raw Material Basis:	2-K polyurethane resin
Areas of application:	High quality top-coat for wood, PVC and metal surfaces
Forms of Supply	Colours: RAL, BS and NCS colour card Other tones upon request Gloss: Satin (30-45 gloss levels at 60°) Hardener: AVKOTE 279 Hardener
Packing	Coating: 1, 3 and 6 litre containers Hardener: 1 litre containers

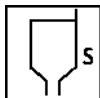


Technical Data	Coating	Hardener	Mixing ratio 10:1 by volume
The data is valid for AVKOTE LE white 80. The values can change for other colours.			
Density (23°C)	1.15 G/cm ³	1.0 g/cm ³	1.12 g/cm ³
Solid Content	52 ± 2 % by weight	46 ± 2 % by weight	Appr 51 % by weight
Content of organic solvent	48 ± 2 % by weight	54 ± 2 % by weight	Appr 49 % by weight
VOC content (CH/EU)	50% 576 g/lit	56% 560 g/lit	51% 574 g/lit
Shelf Life 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 (without spray loss)		






Safety Data	Coating	Hardener
Flash point	20 °C	27 °C
Transport ADR/RID	Class: 3 VP: II	Class: 3 VP: III
Poison classification (CH)	4 BAG T No: 619004	Free BAG T No: 614300
VVS disposal code (CH)	1620	1620

Preparation		
	Substrate	Every substrate must be thoroughly cleaned and be, clean, dry, grease and oil-free.
	Aluminium	Clean, fine sand or use pad(Scotch-brite coarse) and clean OR chemical pre-treatment (Chromate)
	Aluminium Profile	Clean, sand well or fine sand-blast and clean OR chemical pre-treatment (Chromate)
	AVKOTE Spray Filler 1090	Clean, sand as required, clean.
	AVKOTE Sealer Primer 207	Clean, Sand as required, clean.
	Foil Faced Chipboard	Clean, sand as required, 360 grit
	PVC (PVC Profiles) Old Coatings	Take note of our ,Instructions for the painting of PVC window profiles with AVKOTE LE. MB 2511 Sand off, clean, prime as necessary

Application recommendations				
Substrate	Product	Data Sheet	Dry Thickness	
Aluminium and galvanised substrate	1 x AVKOTE Primer Surfacer	5162	30 – 50 µm	
	1 x AVKOTE LE		30 – 50 µm	
Steel	1 x AVKOTE Primer 2250	5150	40 – 60 µm	
	1 x AVKOTE LE		30 – 50 µm	
Chipboard and MDF panels or Wood Veneered Surfaces	Seal edges and milled or cut-out sections with AVKOTE 207 Sealer Primer			
	1-2 x AVKOTE Filler Primer 1090	5201		
	Sand between coats			
	1 x AVKOTE LE			
or	1-2 x AVKOTE Sealer Primer 207	5409		
	Sand between coats			
	1 x AVKOTE LE			
Foil Faced Chipboard	1 x AVKOTE LE			
PVC (PVC-Profiles)	1 x AVKOTE LE			
Old coats of paint (solvent resistant)	1 x AVKOTE LE		30 – 50 µm	
Remark:	Remark: For pastel coloured coating of surfaces subject to heavy use, such as structural elements, working surfaces etc. It is recommended to clear-coat with AVKOTE Varnish 1230 Hardener 279 to improve resistance of marking			
	For further application proposals please ask our application technology department.			

Application		
	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 No. 539300 and 279H00.
	Stir	Before use, coating and hardener + thinners are to be well stirred together
	Mixing Ratio Pot life at 20°C	10: 1 by volume with AVKOTE 279 Hardener Approx: 24 hours according to tone

	Thinners	Dilute with thinners V-95 (slow), or V-13000 (Fast) to application viscosity according to the table shown below.
	Brush Painting	Not recommended
	Rolling	Not recommended

	Viscosity	Thinner	Nozzle	Pressure	Spray Coats
	18-22 secs DIN-4	25-30%	Mm 1.4-1.8	3-4	2
	18-22 secs DIN-4	25-30%	Mm 1.4-1.8	3-4	2
	22-25" secs DIN-4	25%	06-09	3-4	1-2
	Evaporation time	For drying with temperatures above 40°C an airing-time of 15 minutes should be maintained			
	Drying Time	For 50 µm dry coating at 65% rel. Humidity			
	At 20°C	Tack-dry	After:	10	Minutes
		Can be handled	After:	30	Minutes
		Dried (can be sanded)	After:	1	Hour
	At 80°C	Suitable for recoating	After:	2	Hours
Dry		After:	30	Minutes	
At 100°C	Dry	After:	15	Minutes	

Important References	
Specific restrictions	Relative humidity max. 80%
Minimum application and drying temperature	10 °C Do not apply at temperatures below the dew point
Coating Removal	Sand blast and/or paint stripper
Equipment cleaning	Clean immediately after use with thinners 95, 13000 or U cleaner

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