
 <h2 style="margin: 0;">VALCHROMAT</h2> <h3 style="margin: 0;">WB PROCESS - TRANSPARENT INTERIOR</h3> <h3 style="margin: 0;">2K BIO BASE COAT + 2K TOPCOAT</h3>	
SUPPORT PREPARATION	Confirm that Valchromat panels are clean, free of grease and other contaminants. Sand only on the milled and cut areas with sandpaper up to grain #180.
WB 2K BIO BASECOAT	<p>First basecoat layer. One coat of approximately 130 gr/m² (+/- 10 gr) of:</p> <p>100 Parts of FA41BIO + 5 Parts of CA500BIO (Hardener)</p> <p>Pot-life after mixing: 2 Hours. To lower the viscosity, use distilled water (up to a maximum of 5%!) To raise the viscosity, use AD77 (up to a maximum of 1%!) Make a good stirring to ensure good hardener incorporation!</p>
DRYING	4 to 6 hours at room temperature around 23°C and maximum relative humidity 65%. We recommend allowing it to dry overnight, maintaining an air renewal and a temperature above 20°C.
SANDING	Sand with #320 grit sandpaper. Repaint no later than 24 hours after sanding.
WB 2K BIO BASECOAT	<p>Second basecoat layer. One coat of approximately 130 gr/m² (+/- 10 gr) of:</p> <p>100 Parts of FA41BIO + 5 Parts of CA500BIO (Hardener)</p> <p>Pot-life after mixing: 2 Hours. To lower the viscosity, use distilled water (up to a maximum of 5%!) To raise the viscosity, use AD77 (up to a maximum of 1%!) Make a good stirring to ensure good hardener incorporation!</p>
DRYING	12 to 24 hours at room temperature around 23°C and maximum relative humidity 65%. We recommend allowing it to dry overnight, maintaining an air renewal and a temperature above 20°C.
SANDING	Sand with #320 grit sandpaper. Repaint no later than 24 hours after sanding.
WB 2K TOPCOAT	<p>One coat of approximately 120 gr/m² (+/- 10 gr) of:</p> <p>100 Parts of A0830G5 + 15 Parts of CA502 (Hardener)</p> <p>Pot-life after mixing: 2 Hours. To lower the viscosity, use distilled water (up to a maximum of 5%!) To raise the viscosity, use AD77 (up to a maximum of 1%!) Make a good stirring to ensure good hardener incorporation!</p>
DRYING for manipulation	Allow to dry at least 12 hours – Over Night. Ensure good air renewal in the drying area with a maximum relative humidity of 65% and a temperature of around 23°C.
DRYING for packaging	Pack and stack at least 24 hours after application of the last coat when drying conditions ensure a temperature above 20°C throughout the curing process. Complete cure after 7 days.
CONTACT FOR PRODUCT INFORMATION AND SUPPLY	<p>INOVLACK Coatings Solutions Lda Christophe Smits inovlack@inovlack.pt</p> <div style="text-align: right;">  <p>INOVLACK COATINGS SOLUTIONS EFICIÊNCIA EM ACABAMENTOS</p> </div>



FA41BIO

Detailed Description

Technical Description

CL.WB 2K B.COAT

CLEAR WATER-BASED 2K BASE COAT


Clear water-based two component base coat for spray application, formulated with resins from renewable sources.



Main Data

Primary Sector	✓ Indoor furnitures	
Main Features	Outstanding Good	Ability to maintain the natural colouring of the wood Quickness of drying
Line of product	iridea  bio	


Regulations

Emissions 	A+ Very Low Emission
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Chemical and Physical Properties


Solid Content %	25.0 ± 2
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Substrate


Substrate	✓ Bare solid wood or veneer
Substrate preparation 	✓ Sand the bare wood with grain 150 and then with grain 180 paper. Dust carefully with compressed air.
Substrate information	All general information refers to ICA Group products



Application

Hardener	Hardener CA500BIO	% in weight 5.0	% in volume 5.0	Pot life (h) 2	How to add Mix mechanically
Hardener Notes	At temperatures above 30°C the pot life is significantly reduced.				
Product preparation notes	Ready to use. Dilute with demineralized water up to 5%, if necessary.				
Application 	Application Diaphragm spray pump Spray with cup pistol Airmix spray-paint		Application Notes Recommended nozzles: 0.007 - 0.011 inches– material pressure 80-130 bar Recommended nozzles: 1.6 - 2.0 mm. Recommended nozzles: 0.007 - 0.011 inches– material pressure 50-100 bar – atomization air 0.8-2.5 bar		
Quantity per coat (g/sqm)	Quantity per coat (g/sqm) 100-180		Max quantity (g/sqm) 200.0		
Number of coats	Up to two				
Interval between coats (23°C 50% RH) (h)	1 - 4				
Overcoatings Notes	Applying a single coat of product, it can be sanded and overapplied after 3-4 hours, for two coats wait 16-24 hours.				

Drying

Touch dry (23°C 50% RH) (h) 	1.0
Sandable (h)	4.0
Stackable Notes	Stackable after 16 - 24 hours.
Completely dry	3 - 5 days.
Drying and cross-linking information	The figures indicated serve as a guide and are for reference. The drying time depends on the substrate, coat thickness, temperature, relative atmospheric humidity and ventilation.


Specification of supplied product

Analysis	Value			Un. Measure	Method
Flow Cup Viscosity	DIN Cup 4	55.0	± 5.0	Seconds	DIN 4 Viscosity - MP04
pH		8.0	± 0.5		pH (u.pH) - MP13



Specific Gravity	1.04	± 0.05	g/ml	Density (g/ml) - MP01
Fineness	40.0		Micron μ	Fineness(μm) - MP12

N.B.

Shelf life (days)	365.0
Storage Information	For intact and correctly stored product Store at temperatures above 5°C and below 35°C
	
N.B.	Mix well before use. Sedimentation is not a sign of deterioration and it is sufficient to carefully mix the product to use it. Apply at temperatures above 15°C and maximum relative humidity of 65%. Avoid any extensive sanding that could result in reduced insulation and a change in wood color after the application of the top coat. If this cannot be avoided, apply a second product coat. On woods containing significant amounts of coloring and/or extractive substances, carry out preliminary tests to verify the insulating effectiveness. On porous, absorbent and/or dimensionally unstable substrates, such as poplar or MDF plywood, first apply a coat of solvent-based polyurethane sealer. Avoid product accumulations to avoid cracking problems over time.

Viscosity Notes

The quality control value of the viscosity refers to the product immediately after checking. Any variations of the data specified in the technical data sheet could be due to circumstances such as length and conditions of storage.

Legal notice

The working method, the application conditions, the production cycle, the use of machinery, the ambient conditions, the characteristics of the supports used, the place of use, are beyond our control and our obligations. Therefore it is essential that you test our products and the information supplied by us to make sure that they are satisfactory and suitable for the use and application methods that you intend them for and for the results you wish to achieve. This specific analysis is exclusively your responsibility and must include assessment of suitability from a technical and procedural, environmental, health and safety point of view. Any written or verbal information given by our technical and/or commercial personnel is purely to illustrate the product and help the client, and does not constitute instructions or consultancy, which remains expressly excluded. The above mentioned written or verbal information is subject to changes without prior notice and does not imply any acceptance of responsibility by our company to you and to third parties. The product is supplied in perfect conformity with the contents of this document; we therefore guarantee the consistency of the chemical-physical characteristics of the product taking into account the allowances and data contained in our technical data sheets.

The technical data sheets may be subject to modifications and revisions and therefore it is your responsibility to ensure that you have the latest data sheet by accessing our "company portal" www.icagroup.info.

Any declarations or recommendations or advice not contained in this documents are not authorized, and are not binding for our company and do not determine acceptance of responsibility on our part.

Technical Data Sheet NR 25435

TRANSPARENT BICOMPONENT WATER BASED MATT TOP COAT

Creation date: 26/03/15 Revision date: 31/3/2015, version 1

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PRODUCT: AO830G5 TRANSPARENT BICOMPONENT WATER BASED MATT TOP COAT

DESCRIPTION: transparent bicomponent water based matt top coat

USE: indoor furniture and fittings

SPECIFICATIONS OF SUPPLIED PRODUCT

Physical state: light coloured milky liquid
Solid content %: 23 ± 2

Gloss: 85° 9-12 gloss 60° 5-6 gloss
Chemical agents resistance: excellent
Light fastness: excellent

SUBSTRATE: water and solvent based polyurethane mono and bicomponent base coats, polyester base coats, UV base coats, all suitably sanded. On metal supports after carrying out preliminary tests for adhesion.

APPLICATION: by manual or automatic spray with pneumatic and airmix systems.

HARDENER: CA502 at 15%. Incorporation must be done mechanically with a mixer with a toothed spindle for at least 60".

DRYING:
Touch dry: 2 hours at 23°C and 60% R.H.
Completely dry: 7 days
Stackable: after 24 hours at 23°C and 60% R.H.

DILUTION: 5-15% with water
QUANTITY TO APPLY: 60-130 g/m²
POT LIFE at 20°C: CA502 15% 2 hours

STORAGE INFORMATION: store at temperatures between 5°C and 35°C

SHELF LIFE AT 20°C: 12 months in correctly stored unopened tin

NB:
Apply and dry in temperatures above 20°C and max. 65% R.H.

SPECIFICATIONS OF SUPPLIED PRODUCT

CHARACTERISTICS	UNITS	VALUE	METHOD
Specific gravity at 20°C:	g/ml	1.03 ± 0.05	MP01
Viscosity:	sec	80 ± 10 C.F.5	MP04
Fineness:	µm	20 max.	MP12
pH value:	/	8.0 ± 0.5	MP13

The quality control value of the viscosity refers to the product immediately after checking. Any variations of the data specified in the technical data sheet could be due to circumstances such as length and conditions of storage.

Always verify the suitability of the product for the job to be done before application. We can not accept responsibility for the outcome.

The information contained in this technical data sheet, as well as any verbal information, is given to the best of our knowledge. We do not accept responsibility for obsolete or incorrect information. The information is to be considered obsolete when a new technical data sheet is issued. Please feel free to contact us to request the latest edition.

AO830G5/1

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