

# Technical Data Sheet



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Data sheet Nr. 5393/LE

## AVKOTE LE

<b>Product description</b>	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)
<b>Binding Agent</b>	2-K polyurethane resin
<b>Areas of Application</b>	High-quality top-coat for PVC, GRP, acrylic and metal surfaces.
<b>Form of Supply</b>	RAL, BS and NCS colour card Other Colours available on request
Colours	
Gloss Level	Silk (30 - 45 gloss levels at 60 °)
<b>Hardener</b>	Avkote Hardener 279
<b>Packing</b>	Coating Hardener
	1, 3 and 5 Litre disposable containers 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							
<b>Specific Gravity (23 °C)</b>	1.2	g/cm <sup>3</sup>	1.0	g/cm <sup>3</sup>	1.17	g/cm <sup>3</sup>						
<b>Solids content</b>	52	± 2 Weight-%	46	± 2 Weight-%	Appr 51	Weight-%						
<b>Organic Solvent Content.</b>	48	± 2 Weight-%	54	± 2 Weight-%	Appr 49	Weight-%						
<b>VOC Content (CH / EU)</b>	57	%	570	g/lit	56	%	560	g/lit	57	%	569	g/lit
<b>Shelf life at 20 °C</b>	12 Months		6 Months in well shut containers									
<b>Theoretical Coverage</b>	96	g/m <sup>2</sup>	10.4	m <sup>2</sup> /kg for	30	µm dry layer thickness						













Safety Data	Coating	Hardener
<b>Flash point</b>	27 °C	0 °C
<b>Transport ADR/RID</b>	Class: 3 VP: III	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
PVCu (PVC-Profiles) & GRP	1 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	Aquakote 220 Brown or 225 Black Stain		8650
	1 x Lacquer	Avkote 1483, 1485, 1495 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**

	<b>Substrate</b>	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	PVCu (PVC-Profiles) & GRP	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.
	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 153b Cleaner first then with Avkote 154 Cleaner. Apply Avkote LE. Leave to dry. Apply Stain with a sponge. Seal stain with Avkote Lacquer.
	Other Plastics	Please refer to our technical department.
	Aluminium and galvanised substrate	Ensure metal is clean and grease free. Apply Primer. Sand as required. Apply Avkote LE Top coat.
	Steel	
	Old coats of paint (solvent-resistant)	Sand off, clean, primer as necessary.

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. 539300LE and 279H00.				
	<b>Stir</b>	Before use ensure contents are stirred together well with hardener if applicable.				
	<b>Mixing Ratio</b>	10 : 1 by volume with Avkote 279 hardener Add up to 4:1 Avkote 279 hardener to increase gloss level.				
	<b>Pot life at 20 °C</b>	Minimum 8 hr. according to tone				
	<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>	18 - 22 secs	25 - 30 %	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 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	
		Completely Dry	after:	7	days	

**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>	Sand blast and/or paint stripper		
<b>Equipment cleaning</b>	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 Varnish to improve resistance to marking.
	Please observe our Material Safety Data Sheets for all products used as well as the instructions on the tin label.

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.