

# Technical Data Sheet



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Data sheet Nr. 5393/FL

## AVKOTE FL

<b>Product description</b>	An especially fast drying, Satin 2K coating with very good weathering characteristics and good resistance to chemicals and mechanical abrasion with a characteristic finish especially suited to interior furniture and kitchen applications. 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 MDF, foils, melamine and uncoated furniture panels for interior use.		
<b>Form of Supply</b>	Colours	RAL and BS colour cards Other Colours available on request	
	Gloss Level	Silk (30 - 45 gloss levels at 60 °)	
<b>Hardener</b>	Avkote Hardener 279		
<b>Packing</b>	Coating	1, 3 and 5 Litre disposable containers	
	Hardener	1 Litre disposable containers	

### Technical Data


The data is valid for Avkote FL white 80. The values can change for other colours.							
	<b>Coating</b>		<b>Hardener</b>		<b>Mixture</b>		
<b>Specific Gravity (23 °C)</b>	1.12	g/cm <sup>3</sup>	1.0	g/cm <sup>3</sup>	1.11	g/cm <sup>3</sup>	
<b>Solids content</b>	51	± 2 Weight-%	46	± 2 Weight-%	Appr 50	Weight-%	
<b>Organic Solvent Content.</b>	48	± 2 Weight-%	54	± 2 Weight-%	Appr 49	Weight-%	
<b>VOC Content (CH / EU)</b>	57	%	570	g/lt	56	%	560 g/lt
<b>Shelf life at 20 °C</b>	12 Months		6 Months in well shut containers				
<b>Theoretical Coverage</b>	88	g/m <sup>2</sup>	11.4	m <sup>2</sup> /kg for	30	µm dry layer thickness	

<b>Safety Data</b>	<b>Coating</b>	<b>Hardener</b>
<b>Flash point</b>	-1 °C	0 °C
<b>Transport ADR/RID</b>	Class: 3 VP: II	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 & Plastic Foils	1 x Top Coat	Avkote FL	30-50 µm	5393/FL
Other Plastics	Please refer to our technical department.			
Chipboard and MDF panels or Wood Veneered Surfaces  or	1 x Sealer	Seal edges and milled / cut-out sections with Avkote 207 Primer	30 - 50 µm	5409
	1-2 x Primer	Avkote 1090 Spray filler Sand between coats with grit 220-240	30 - 50 µm	1090
	1 x Top Coat	Avkote FL	30 - 50 µm	5393/FL
	1-2 x Sealer	Avkote sanding primer 207 Sand between coats	30 - 50 µm	5409
	1 x Top Coat	Avkote FL	30 - 50 µm	5393/FL
Foil Faced Chipboard	1 x Top Coat	Avkote FL	30 - 50 µm	5393/FL
Old coats of paint (solvent-resistant)	1 x Top Coat	Avkote FL	30 - 50 µm	5393/FL

**Preparation**

	<b>Substrate</b>	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	PVCu & Plastic foils	Clean with Avkote 153b Cleaner first then with Avkote 154 Cleaner. Apply Avkote FL.
	Avkote 1090 Filler	Clean, sand as required, clean
	Avkote 207 Sanding Primer	Clean, sand as required, clean
	Foil Faced Chipboard	Clean, sand as required, 360 grit
	Other Coatings	Sand off, clean, prime 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. 539300FL and 279H00.
	<b>Stir</b>	Before use ensure contents are stirred together well with hardener if applicable.
	<b>Mixing Ratio</b>	4 : 1 by volume with Avkote 279 hardener
	<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.

	brush	Not recommended				
	Roll	Not recommended				
		Viscosity DIN-4	Thinners	Nozzle	Pressure	Spray coats
	Gravity Feed Spray-gun	18 - 22 secs	25 - 30 %	1.8 mm	2.5 – 3 bar	2
	Suction-spray-gun	18 - 22 secs	25 - 30 %	1.2 mm	2.5 - 3 bar	2
	Airless-(Airmix)-Spray	22 - 25" secs	25 %	11/13	1.5 – 2.0 bar Atomising air 1.5 - 2	1 - 2
	HVLP paint gun	18 - 22 secs	25 - 30 %	1.2 mm	2.5 - 3 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:	20	Minutes	
		Touch – Dry	after:	50	Minutes	
		Dried (Can be sanded)	after:	3	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 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 Lacquer 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.

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