

Technical Data Sheet



Edition dated: 05.02.08

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Data sheet Nr. 5393/FE

AVKOTE FE

Product description	A high quality top coat for furniture and wood to be applied on top of Avkote Primer.		
Binding Agent	2-K polyurethane resin		
Areas of Application	High-quality top-coat for furniture, wood & MDF		
Form of Supply	Colours	RAL and BS colour cards Other Colours available on request	
	Gloss Level	Silk (30 - 45 gloss levels at 60 °)	
Hardener	Avkote Hardener 279		
Packing	Coating	1, 3 and 5 Litre disposable containers	
	Hardener	1 Litre disposable containers	

Technical Data


The data is valid for Avkote FE white 80. The values can change for other colours.							
	Coating		Hardener		Mixture		
Specific Gravity (23 °C)	1.2	g/cm ³	1.0	g/cm ³	1.17	g/cm ³	
Solids content	52	± 2 Weight-%	46	± 2 Weight-%	Appr 51	Weight-%	
Organic Solvent Content.	48	± 2 Weight-%	54	± 2 Weight-%	Appr 49	Weight-%	
VOC Content (CH / EU)	57	%	570	g/lt	56	%	560 g/lt
			57	%	569	g/lt	
Shelf life at 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	



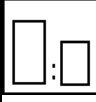









Safety Data	Coating		Hardener	
Flash point	27 °C		0 °C	
Transport ADR/RID	Class: 3	VP: III	Class: 3	VP: III
Poison classification (EU)				
VVS disposal code (EU/CH)	08, 08 01, 08 01 11		08, 08 01, 08 01 11	

Application Recommendations

Substrate	No. of Coats	Product	Dry Film thickness	Data sheet
Chipboard and MDF panels or Wood Veneered Surfaces or	1 x Sealer	Seal edges and milled / cut-out sections with Avkote 3910 Primer or AVKOTE SFP	30 - 50 µm	5409
	1-2 x Primer	Avkote 1090 Spray filler OR AVKOTE SFP Sand between coats	30 - 50 µm	1090
	1 x Top Coat	Avkote FE	30 - 50 µm	5393/FE
	1-2 x Sealer	Avkote sanding primer 3910 or AVKOTE SFP Sand between coats	30 - 50 µm	5409
	1 x Top Coat	Avkote FE	30 - 50 µm	5393/FE
Wood MDF	1 x Top Coat	Avkote FE	30 - 50 µm	5393/FE
Foil Faced Chipboard	1 x Top Coat	Avkote FE	30 - 50 µm	5393/FE
Old coats of paint (solvent-resistant)	1 x Top Coat	Avkote FE	30 - 50 µm	5393/FE
For further application proposals please ask our technical department.				

Preparation

	Substrate	Every substrate must be thoroughly cleaned, grease and oil-free, and dry before paint application commences.
	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
	Old coatings	Sand off, clean, prime as necessary

Processing						
	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 Nos. 539300FE and 279H00.				
	Stir	Before use ensure contents are stirred together well with hardener if applicable.				
	Mixing Ratio	10 : 1 by volume with Avkote 279 hardener Add up to 4:1 Avkote 279 hardener to increase gloss level				
	Pot life at 20 °C	approx. 24 hr. according to tone				
	Thinners	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 %	1.4 - 1.8 mm	2-2.5 bar	2
	Suction-spray-gun	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	2-2.5 bar	2
	Airless-(Airmix)-Spray	22 - 25" secs	25 %	11/40	3 – 4 bar Atomising air 1.5 - 2	1 - 2
	HVLP paint gun	18 - 22 secs	25 - 30 %	1.4 - 1.8 mm	3 - 4 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:	2	Minutes	
		Touch – Dry	after:	10	Minutes	Primary Coat
		Dried (Can be sanded)	after:	1	Hour	
		Suitable for re-coating	after:	2	Hours	Max 48hrs
		Completely Dry	after:	7	days	

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		

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 1483, 1485 or 1495 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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