

# AQUAFOND 424

## WATERBASE MONO-BICOMPONENT SEALER



### DESCRIPTION

AQUAFOND 424 Waterborne Sealer is a clear fast drying waterborne acrylic sealer with quick build and excellent sanding characteristics designed for use on interior wood products. This sealer works very well on closed grain or semi-closed grain wood species such as maple or alder. This sealer displays excellent transparency making it a great sealer for use under LORCHEM water-based topcoats.



### PRODUCT DATA

<b>Color</b>	Clear	<b>VOC less exempts</b>	28.33 g/L	0.24 lb/gal
<b>Solids % by Vol</b>	30%± 2%	<b>VOC actual</b>	51.69 g/L	0.43 lb/gal
<b>Solids %by Wt</b>	38% ± 2%	<b>Photochemical reactive</b>	No	
<b>Density</b>	1.04 ± 0.02	<b>Flash Point (PM/CC)</b>	N/A	
<b>Viscosity 23°C/73°FORD #5</b>	50-60	<b>Shelf life</b>	12 months (at 15-25°C/59-77°F)	
<b>Gloss( On Black glass @60°)</b>	Flat	<b>Theo-coverage @1 mil dry</b>	480-490 Sq.Ft/gal	9 m <sup>2</sup> /L

### PREPARATION/APPLICATION

<b>Working Temp</b>	>18°C/65°F surface, coating and air
<b>Catalyzation</b>	Optional for optimal chemical resistance 5 % by volume using CW7500 catalyst.
<b>Pot life</b>	N/A
<b>Reducer</b>	Product is normally applied without reduction. If reduction is needed to optimize application, reduce 5% by volume with warm water.
<b>Application</b>	<ul style="list-style-type: none"> <li>Stain- Stain or color wood if desired and allow to dry. Consult your local representative for appropriate stain offering</li> <li>Seal- Apply AQUAFOND 424 at 4.0 – 6.0 wet mils. Air dry thoroughly. Sand with 240 grit sandpaper and remove all sanding dust. Topcoat within 8 hours of sanding.</li> <li>Topcoat – apply a recommended LORCHEM waterbaseD topcoat.at 4.0 - 6.0 mils wet. Apply an additional topcoat for greater build. Refer to corresponding data sheet for details</li> </ul> <p><b>Note:</b> Oak or other species of wood rich in tannic acid can discolor. Users are urged to test the system under shop conditions.</p>
<b>Surface Preparation</b>	Wood surface must be dry and finish sanded with 180 grit sandpaper Substrate should be clean and free of grease and oil to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.
<b>Use Directions</b>	For interior use only. Catalyze, adjust viscosity and stir thoroughly before application to avoid variations application. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.
<b>App equip.</b>	Conventional & HVLP Siphon Feed, Pressure Pot Systems and Airless/Air Assist Equipment.
<b>Tinting</b>	Can be tinted up to 10% maximum with AquaTint colorants 100.
<b>Cleanup</b>	Clean tools/equipment immediately after use with water.

### DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	<b>Dust free time</b>	15 minutes	<b>Dry to sand</b>	30 minutes
		<b>Dry to touch</b>		<b>Dry to recoat</b>	2 hours
		<b>Dry to Handle</b>	30 minutes	<b>Dry to stack</b>	8-10 hours
Force dry	45 °C/110°F	30 minutes			

**Note:** Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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**APPLICATION RECOMMENDATIONS**

**APPLICATION EQUIPMENT SETTINGS**

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Dilution %	Thickness Film (Mils)
Conventional spray	40-60	-	2-2.5/0,078-0.098	10-20	3-5
Airmix Spray	15-30	1100-1600	9-11/0,35-0.43	-	3-5
Airless	-	1700-2200	9-11/0,35-0.43	-	3-5

The use of pre-atomizers and pre-heaters, to bring the temperature to 30 – 40 °C, ensures a correct application regardless the room temperature. The drying process should be carried out in environments with adequate air ventilation (the recycle of air in the drying room should be carried out every 15-20 minutes).

**Note:** All measurements and application equipment settings are based on application at a temperature of 77°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer’s recommendations for equipment set-up.

**SPECIFICATIONS**

- ◆ For interior use only.
- ◆ Must be agitated before and during using. Avoid vigorous agitation which may cause foaming.
- ◆ Use stainless steel spray equipment. Tank, piping, and containers should be lined steel or plastic.
- ◆ Very low temperature application ( less than 12°C) may cause poor mechanical and chemical film properties.
- ◆ Total film thickness must not exceed 4.0 mils dry film because heavier films may show cracking tendencies.
- ◆ Application on open grain woods such as oak may require an additional coat of the sealer with sanding between coats. T.
- ◆ Natural Finished Woods (unstained) will change color on aging and exposure to light. This is a natural phenomenon. Clear finishes will not prevent the wood from changing color.
- ◆ Apply under recommended LORCHEM topcoat. Please contact your LORCHEM representative for system recommendations.
- ◆ Do not expose to freezing temperatures. The liquid coating will not handle any freeze/thaw cycles.

**CAUTIONS**

**TESTING**

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

**THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY**

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

**PDS**

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

**CONTACT**

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