


Solido (ICLA 211.18.50) S-T220H-50







Product data	
Packaging size	20 l 5l
Viscosity at delivery DIN 4 mm (sec.)	60 ± 10
Solid content in % base material	44.8 ± 1
Solids in % incl. standard hardener	38.1 ± 1
Specific weight in kg/l at 20°C	1.01 ± 1%
Shelf life – Original container unopened	at least 2 years

Gloss levels		
Product number	Gloss level	DIN 67530 Angle of 60°
S-T220H-50	gloss	50 ± 2

Preparation of substrates		
	Open-pore coatings	Priming with a suitable sealer of the Solido series.
	Closed-pore coating	Close the pores by repeated application of a sealer of the Solido series.
	Exotic wood / woods rich in extractives Wood or MDF in wet rooms	Priming with Solido S-IS130

Processing	
	Stir thoroughly!
	Mix and apply the product as described under "Hardener Thinner Additives".

Hardener - Thinner - Additives		
	Hardening	50% of HPU 6206 (310.42)
	Alternative hardeners	50% HPU 6205 (310.70) better non-yellowing properties 50% of HPU 6204 (315.90) higher solids content
	Dilution	TPU 9302-M (910.17) medium drying TPU 9303-S (910.73) slow drying
	Pot life 20°C, 65% rel. humidity	up to three hours

Application		
Spray pressure (bar)	1.5 - 2.0	110-130
Nozzle size (mm)	1.6-2.0	0.23-0.28
Thinner to be added (%)	30	30
Processing viscosity DIN 4mm (sec.)	14 - 16	14 - 16
Coverage per application (g/m²)	100-120	100-120
Coverage (m²/l)	6-7	6-7

Drying time @ 20°C	
Dust dry	at least 20 minutes
Touch dry	at least 45 minutes
Ready for transport	at least 6 hours

Forced drying	
Rest period at room temperature	20 minutes
Hot air drying at 40°C	30 minutes
Hot air drying at 60°C	30 minutes
Cooling at room temperature	20 minutes

Products from AkzoNobel Wood Coatings are exclusively produced for professional and industrial users, who have a basic knowledge of the handling and application of chemical/technical products for surface design. The processing instructions for reaching the qualities given in the leaflets should be regarded as non-binding recommendations and do not constitute any warranty. These recommendations are based on our experiences, including test series, and should facilitate and promote the work of our clients. Any potential deviation from ideal working conditions is within the responsibility of our clients and may affect the (end) result of the application. The purchaser is not relieved from his duties to inspect the product and its suitability for the surface to be processed, preferably through trial processing. If in any doubt as to the handling or processing of the purchased product, our material experts as well as our application and laboratory technicians will help you to the best of their ability. AkzoNobel, of course, guarantees an impeccable quality of its products in its product specifications, yet the use thereof lies entirely within the responsibility of the purchaser. As long as we have not guaranteed – in writing – the specific characteristics and suitability of a product for a contractually agreed purpose, any advice or information given regarding the application or handling, even if the advice or information is given to the best of our knowledge, will not be binding nor will it constitute a warranty. AkzoNobel's liability for the use of its products by its customers is limited in its General Sales and Delivery Conditions, to which the purchaser is hereby referred. The applicable version of the Technical Data Sheet for this product can be downloaded from our websites. Previous versions of the Technical Data Sheets are rendered void with the issue of a new one. Date of issue: 2020-08-05 / 12

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Special notes
Do not process and dry PU lacquers below 15° C.
PU lacquers can be applied within one working day without any intermediate sanding. After that period of time, intermediate sanding must be made just before further processing, in order to ensure proper adhesion.
PU hardeners are affected by moisture. Always store the hardener in tightly closed original batches.
When using PU hardeners, always follow the safety instructions on the label.
PU hardeners can be stored in the closed original container at a cool and dry place for a maximum of one year.
The product is not lightfast. That is why the lacquer film will turn yellow in the course of time. The intensity of yellowing depends on the coat thickness and on the intensity of the ultraviolet radiation of the sunlight. If absolutely non yellowing coatings are desired, please use our products from the Quantum series.
All specified parameters refer to an application with the standard hardener. When using an alternative hardener, some parameters, e.g., curing speed, application properties, degree of gloss and surface quality, may change.

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