

## AqualitColor (ICLA 103.01/01) AC-P330



Product data	
Packaging size	20 kg 5 kg
Viscosity at delivery DIN 6 mm.	40 ± 5
Shelf life - Original container unopened	at least 1 year
VOC Directive EC limit value for this product (cat. A/e): 130 g/l (2010)	The unhardened product contains max. 61 g/l VOC. The hardened product contains max. 93 g/l VOC.

Preparation of substrates		
	Raw wooden surfaces. Graduated sanding of wood. Carefully remove the sanding dust. Coarse-pore wood must be brushed out.	P120, P150, P180
	Plastic foil boards (e.g., HPL or melamine resin) must be thoroughly sanded. Priming foil boards must be clean and free from grease and silicone.	P320 / P400

Processing	
	Stir thoroughly!
	Mix and apply the product as described under "Hardener Thinner Additives".
	On priming or plastic foil boards, the product may only be applied hardened as a two-pack product. When used as two-pack product, proper hardening (see Hardener Thinner Additives) must be ensured in order to ensure a sufficient insulating effect.

Hardener - Thinner - Additives		
	Hardening optional	10% of HWA 6001 (303.01) by weight 12% HWA 6001 (303.01) by volume
	Dilution	tap water
	Pot life 20°C, 65% rel. humidity	as two-pack product 1 hour

Application		
Spray pressure (bar)	1.5-3.0	110-130
Nozzle size (mm)	2.0-2.5	0.33-0.38
Thinner to be added (%)	5 - 15	5 - 15
Processing viscosity DIN 4mm (sec.)	100-140	120-140
Coverage per application (g/m²)	120 - 160	120 - 160
Coverage (m²/l)	5 - 7	5 - 7

Drying time @ 20°C	
Dust dry	at least 30 minutes
Touch dry	at least 1 hour
Sandable	at least 4 hours
Stackable	at least 15 hours

Forced drying	
Rest period at room temperature	15 minutes
Hot air drying at 35°C	2 hours
Cooling at room temperature	15 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: 2020-07-22 / 22

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Special notes
The product is frost-sensitive. Do not store and transport under 5° C
Do not use any rusting tools.
Plastic foil boards (e.g., HPL or melamine resin) must be thoroughly sanded. Priming foil boards must be clean and free from grease and silicone. On these substrates, the product must be applied as a two-pack product.
By adding hardener, an insulating effect against water and wood ingredients is obtained. The insulating effect is only obtained if the hardener is added correctly. Please take notice of the required quantity of hardener by volume or by weight.
Always keep the containers closed in order to protect the contents against drying-out.
CO <sub>2</sub> is released during the reaction of the two components. For that reason, the hardened product must not be poured into a closed container.
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.

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**EMEA HQ**  
Akzo Nobel Hilden GmbH ● Düsseldorf Str. 96 - 100 ● 40721 Hilden ● Germany ● [www.akzonobel.com/wood](http://www.akzonobel.com/wood)

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