

SEDIPAN WACM 310

Waterborne translucent spray Midcoat



Main product characteristics

- Excellent transparency
- Excellent leveling
- Good sanding properties
- Good pore filling
- Contains UV-Absorbers
- Very good isolation properties in combination with SEDIPAN WV 012



Processing

General information



- Specific Gravity (g/cm³): 1,04± 0,02
- The product application on substrate must be done in an environment with not less than 12°C and not higher than 30°C. Coatings applied at lower temperatures will show chemical and mechanical properties worse than standard performances that can be normally achieved.
- The best leveling results will be achieved at 20°C and a relative humidity of 60%.
- All external materials (i.e. fillers, tapes, sealing compounds, cleaners) must be checked for compatibility with the coating system before use.

Area of usage



- Stable
- Semi stable

Substrate preparation



- Wood must have the right wood moisture (12-15%).
- Always clean well the surfaces, removing all traces of dust, grease, waxes and resins.
- Perform sanding on raw wood with not less than 180 grit paper.
- Don't sand the primer if you use a midcoat.

Application Table

	Application	Airless	Airless air assisted (Airmix, Aircoat, etc.)	Cup gun
	Nozzle (Ø mm)	0,28	0,28	2,0 – 2,5
	Nozzle (Ø inch)	0,011	0,011	-
	Injection pressure (bar)	80 – 100	80 – 100	3 – 4
	Atomizing pressure (bar)	-	0,5 – 1,5	-
	Thinning	Water		
	Thinner in %	0 – 20	0 – 20	5 – 10
	Application quantity (ml/m ²)	100 – 150		
	Productivity per application (ml/m ²) ¹⁾	200 – 300		
	Wet layer thickness (µm)	100 – 150		
	Dry layer thickness (µm)	30 – 50		
Thin product with 20% water to get better pore wetting on wood with deep pores.				
¹⁾ Productivity incl. added thinner and spraying loss				

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Drying Table

Drying at 20 °C and RH% between 45–65: 150 µm		Drying in tunnel: 150 µm		
Dust free	10 minutes		Temperature	Time
Handling	1 hour	Flash off	20 °C	15 minutes
Overcoat	4 – 6 hours	Laminar Air	35 °C	70 minutes
Stackable	24 hours	Cooling	20 °C	15 minutes
Sanding	4 hours	Stackable	At tunnel exit	

Cleaning



- Application tools must be cleaned with water after use.
- Coating left overs (washing waters, waters from spray booths, used coatings) must be disposed according to local regulations. Never dispose residues directly into drains.

Storage

- The shelf life is 18 months if the products are stored in an environment with temperature between 5 – 30°C.



Systems

Impregnation	Primer	Midcoat	Topcoat
SEDIPAN WACP 100	SEDIPAN WACP 110	SEDIPAN WACM 310	SEDIPAN WACT 500
SEDIPAN WACP 100	SEDIPAN WACP 200	SEDIPAN WACM 310	SEDIPAN WACT 600

The here mentioned coating systems are only an example, other systems are possible.



Additional notes

Availability

Packaging size	5 and 20l
Colours	Colourless

VOC

- EU limit value for this product (Kat. A/d): 130 g/l (2010). This product contains maximum 40 g/l VOC.

Where to find the MSDS



Please contact your local business partner.

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