

# SEDIPAN WACT 650

Waterborne translucent 3in1 brush and spray coat



## Main product characteristics

- Medium film building 3in1 product (primer, midcoat, topcoat)
- Easy to brush and spray
- Easy to maintain
- Lower viscosity gives better performance in application machines



## Processing

### General information



- Specific Gravity (g/cm<sup>3</sup>): 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%.
- Stir well before use!
- Check colour shade before use!
- All external materials (i.e. fillers, tapes, sealing compounds, cleaners) must be checked for compatibility with the coating system before use.

### Area of usage



- Semi stable
- Unstable

### 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.

### Application Table

	Application	Brushing	Airless air assisted (Airmix, Aircoat, etc.)	Cup gun
	Working material	Mixed or synthetic hair	–	–
	Nozzle (Ø mm)	–	0,28	2,0 – 2,5
	Nozzle (Ø inch)	–	0,011	–
	Injection pressure (bar)	–	80 – 100	3 – 4
	Atomizing pressure (bar)	–	0,5 – 1,5	–
	Thinning	Water		
	Thinner in %	–	–	–
	Application quantity (ml/m <sup>2</sup> )	50 – 80	100 – 150	100 – 150
	Productivity per application (ml/m <sup>2</sup> ) <sup>1)</sup>	50 – 80	200 – 300	200 – 300
	Wet layer thickness (µm)		100 – 150	100 – 150
	Dry layer thickness (µm)	30 – 40 (after 3 layers)	35 – 55	35 – 55

<sup>1)</sup> Productivity incl. added thinner and spraying loss

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## Drying Table

Drying at 20 °C and RH% between 45–65: 50 ml/m <sup>2</sup>		Drying in tunnel: 50 ml/m <sup>2</sup>		
			Temperature	Time
Dust free	20 minutes			
Handling	40 minutes	Flash off	20 °C	15 minutes
Overcoat	2 hours	Laminar Air	30 °C	30 minutes
Stackable	2 hours	Cooling	20 °C	15 minutes
Sanding	2 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 WACT 650	SEDIPAN WACT 650	SEDIPAN WACT 650
	SEDIPAN WACT 650	SEDIPAN WACT 650	SEDIPAN WACT 650
	SEDIPAN WACP 200	SEDIPAN WACT 650	SEDIPAN WACT 650
For opaque a fourth layer at brush application could be needed			
The here mentioned coating systems are only an example, other systems are possible.			



## Additional notes

### Availability

Packaging size	5, 20 and 1000l
Colours	Colourless base, can be tinted to all translucent colour shades out of the collection Mediterranean Translucent Colours and all opaque colour shades (RAL, NCS, VR Colours)

### VOC

- EU limit value for this product (Kat. A/d): 130 g/l (2010). This product contains maximum 100 g/l VOC.

### Where to find the MSDS



Please contact your local business partner.

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