

TECHNICAL DATA SHEET

**PRODUCT: 5100399**

**DESCRIPTION:** HCS BASE PU TRANSLUCENT GLOSSY

**SUGGESTED USE:** GENERAL PURPOSE

**APPLICATION DEVICES:** MANUAL OR AUTOMATIC SPRAY GUN

**STORAGE:** KEEP CANS LIGHTLY SEALED, IN A WELL VENTILATED PLACE, WITH TEMPERATURE CONTROLLED BETWEEN 10 AND 30 °C

**SHELF LIFE:** 12 MONTHS FROM PRODUCTION DATE, IF STORED AS ABOVE, IN ITS ORIGINAL PACKING

**PHYSICAL CHARACTERISTICS**

VISCOSITY @ 20°C	sec. cup DIN 4	45 ± 10%
SPECIFIC GRAVITY @ 20°C	Kg/l	1.013 ± 1%
SOLIDS CONTENT	%	54 ± 1

**READY TO USE BLEND**

	<b>PARTS BY WEIGHT</b>	<b>PARTS BY VOLUME</b>
5100399	80	80
61015XX	20	20
91017	25	25
31599	100	100

**POT LIFE** 2 - 3 hours @ 20°C with 25% 910.17

**APPLICATION VISCOSITY FOR SPRAYING** 13 to 18 sec. cup DIN 4

**ALTERNATIVE HARDENERS AFFECTED PROPERTIES**

31594 Faster curing but worse lighth fastness

**ALTERNATIVE HARDENERS AFFECT THE SHEEN: SHEEN MUST BE CHECKED BEFORE STARTING PRODUCTION AND, IN CASE OF DOUBT, CONTACT OUR TECHNICAL SERVICE.**

**ALTERNATIVE THINNERS PURPOSE**

91073 For hot conditions

**SUBSTRATE**

ALL ITEMS COATED WITH PU OR UPE SURFACERS, DULY SANDED

**APPLICATION**

SUGGESTED COATING WEIGHT	160 - 180 gr/m <sup>2</sup>
SUGGESTED N° OF COATS	2 coats max
TIME BETWEEN 2 COATS	2 hours @ RT, without sanding in between

**DRYING SCHEDULE AT ROOM TEMPERATURE**

COATING WEIGHT 160 gr/m<sup>2</sup>

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Pag. 1/2

38

This information is correct to the best of our knowledge. However, as the coating process depends on many variables and the actual application takes place without our supervision, we cannot assume any responsibility for the final result.

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DUST FREE	40 - 50 min
TOUCH DRY	6 - 8 hours
STACKABLE	48 hours

**FORCED DRYING SCHEDULE**

COATING WEIGHT	160 gr/m <sup>2</sup>
FLASH OFF	30 min. @ ROOM TEMPERATURE
HOT AIR	120 min. @ 35 to 45 °C
HOT AIR	120 min. @ 50 to 60 °C
COLD AIR	30 min. @ ROOM TEMPERATURE

**GENERAL INFORMATION**

THE PRODUCT IS A CLEAR GLOSSY CONVERTER INTENDED TO BE USED IN COMBINATION WITH THE PIGMENTED PASTES OF THE SERIES 61015XX (XX STANDS FOR THE VARIOUS COLOUR CODES).

MIXING 80 PARTS OF 510.03.99 WITH 20 PARTS OF 61015XX WILL GIVE A HIGH QUALITY PIGMENTED GLOSSY TOPCOAT SUITABLE FOR CLOSED GRAIN FINISHING WITH EXCELLENT LEVELING, BUILD, HIDING AND VERY LOW YELLOWING.

WHEN LOW HIDING PASTES ARE USED IT'S POSSIBLE TO APPLY A SECOND COAT AFTER 2 HOURS WITHOUT SANDING OR AFTER 12 HOURS WITH LIGHT SANDING.

IT'S POSSIBLE TO OVERCOAT GLOSSY PIGMENTED PRODUCT WITH ONE COAT OF 510.03.99 CATALYZED AT 100% WITH 315.99. THIS OPERATION WILL GIVE A SMALL COLOUR CHANGE ALSO UPON AGEING: PLEASE VERIFY IF THIS IS ACCEPTABLE.

SANDING AND BUFFING OPERATIONS ARE POSSIBLE 48 HOURS AFTER THE APPLICATION.

FOR HEALTH & SAFETY INFORMATION, PLEASE REFER TO RELEVANT MSDS.

<b>Revision</b> 2 dated 27 Dec 2010
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5100399