

Product Code:

439-1610	Matte
439-1625	Low Gloss
439-1630	Satin
439-1650	Semi-Gloss
436-1690	Gloss

VISCOSITY:	Z #2 50-57 sec at 77° F
FLASH POINT:	N/A
DENSITY (lb/gal):	8.70
SOLID (% by weight):	35.5%
SOLID (% by volume):	32%
SHELF LIFE (months):	6

Product Description: 439-16XX is a waterborne UV coating developed to provide a beautiful appearance and is especially suited for surfaces that require extreme durability. 439-16XX uses light fast resins that provide long-lasting protection. This waterborne material offers an environmental alternative to conventional UV and 2-pack coatings based on solvents.

Recognition: Meets Required Performance for the Kitchen Cabinet Manufacturers Association ANS/KCMA A161.1 - 2000 9.0 Finish Tests.

Recommended: American Woodworking Institute (AWI) TR-3.

Uses: 439-16XX can be used for interior applications when high quality surfaces are required. This coating is designed to provide the ultimate in performance and ease of application. 439-16XX is especially suitable for surfaces in demanding areas requiring premium properties, such as kitchens, bathrooms, as well as office furniture or tables tops. Due to its outstanding flow characteristics and stability on edges it is also well suited for substrates with complex profiles or shapes.

Environmental Data (as supplied):

VOC less exempt lb/gal:	0.72
VOC lb/gal:	0.26
VOC less exempt g/l:	<100
VOC g/l:	<35
VOC lb/lb Solid:	0.08
VHAPs lb/lb Solid:	0.02

See individual compliance sheets for specific data

Application Data:

SUGGESTED USES:	Wood Finish
MIXING RATION:	N/A
POT LIFE:	N/A
APPLICATION VISCOSITY:	Z #2/50-57 seconds
REDUCER:	5 – 10% Water if needed
RETARDER:	N/A
CLEAN-UP SOLVENT:	Wet: Water, Dry: 80:20 blend water:800-5742
RECOMMENDED WET FILM:	3-5 mils
COVERAGE:	538 sq.ft./gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.



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Directions for Use

439-16XX
W/B UV Topcoat

Surface Preparation: Substrate should be sanded using 120, 150 or 180 grit sandpaper prior to coating. Sealers should be sanded using 240 and 320 grit stearedated paper. Suitable sealers are 546-7023 Chemvinyl HS or self-seal. The sealer should be topcoat within eight hours of sanding.

General information: Mix material before use. Add water to reduce, if required, and mix thoroughly. Apply by hand spray or by automatic spray at a wet film build of 3-5 mils on sanded or sealed substrate. Application and drying conditions must be at temperatures of 16°C/61° F or above and at a humidity of less than 65%. Further coats may be applied after complete curing followed by sanding with 280/320 grit stearedated paper. Second and subsequent coats must be applied the same day as the previous coat is sanded. 439-16XX must be agitated thoroughly at all times to ensure product consistency. Contact with metal surfaces should be avoided. Total film build must not exceed 4 dry mils. 439-16XX is touch-dry after a few minutes and therefore provides a rapid dust-free finish even without UV curing. The fast curing of 439-16XX using UV lights offers the advantage of immediate stacking and packaging.

Spray using - Conventional, HVLP or Air Assist Airless (Airmix)

Recommended Reciprocating Spray Machine Setup

Gun Setup:	2 guns set on push and pull or 4 guns on pull only	Tip Size:	Kremlin 06-136 (11 thou.)
Gun Angle:	45/45	Fluid Pressure:	600-800 psi
Gun Distance:	10.5 inches (26.7 cm)	Air Pressure:	20 psi
		Line Speed:	4.9 m/min or 16.1 ft/min

Contact salesman for recommended flash and oven time

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION.

Drying Times:

	At 68°F (Minimum Required)	At 122°F (Minimum Required)
Tack Free Time:	N/A	N/A
Dry to Sand:	N/A	N/A
Dry to Stack:	N/A	N/A

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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