

WW36
WATER-BORNE UV-PAINT SYSTEMS FOR DIFFERENT KINDS OF WOOD FURNITURE

Akvi Primer	006 5021
Luminol 40 N	960 7140
Luminol 25 N	960 7162

The water-borne UV-paint system WW36 is suitable for painting of doors, furniture and other wooden surfaces indoors. The system is especially suitable for painting of doors.

Akvi Primer is a fast drying water-borne acrylic primer. The paint has good filling properties and it is very easy to sand.

Luminol 40 N is semi-gloss and Luminol 25 N semi-matt water-borne UV-paint with very good scratch and chemical resistance. It is especially suitable for fast production lines where high quality furniture is produced.

TYPICAL PAINT SYSTEM

	Product	Application method	Application
1x priming	Akvi Primer	Spraying	100–120 g/m ²
1x top coat	Luminol 40 N	Spraying	100–120 g/m ²

PRODUCT PROPERTIES

Solid Content	42 volume-%	(006 5021)
	40 volume-%	(960 7140)
Specific gravity	1.4 kg/l	(006 5021)
	1.2 kg/l	(960 7140)
Gloss (ISO 2813/60°)	Semi-gloss	(960 7140)
	Semi-matt	(960 7162)
Application methods	Airless, air assisted airless and conventional spraying	
Drying times/50°C	Dry to sand	Dry to stack
	Akvi Primer	3–10 min
	Luminol 40 N	Flash-off 1 min / +23°C + 4 min / +50°C before UV-curing.
Required UV-energy	500 mJ/cm ² + 500 mJ/cm ² . For proper curing use both Gallium and Mercury lamps.	
Thinner	Water.	
Cleaning of equipment	Water.	
Colours	960 7162 (white), 9607140 (NCS S 0502-Y), other colors by request	

SURFACE PREPARATION

Dirt, dust and other unfamiliar material must be removed from the surface. Wooden material should be sanded before application with paper grain size 150–240. All sanding dust must be removed before application.

APPLICATION CONDITIONS

During application and drying the temperature of the air, paint and surface should be at least +18°C. The relative humidity should not exceed 70%. Good ventilation is needed during drying process.

APPLICATION

Stir Akvi Primer well before application and thin with water if necessary.

Apply an even coat of Akvi Primer (wet film thickness about 100–120 g/m²) and let it dry. Sand the surface with 240–320 grit sanding paper and remove sanding dust carefully.

Stir Luminol 40 N well before application and thin with water or if necessary. Apply an even coat (wet film thickness about 100–120 g/m²) and let it dry about 5 min in +50°C + uv-curing. The paint is ready to stack directly after uv-curing and cooling.

Application with airless, conventional spray or curtain coating machine. The right spray nozzle size is 0,011–0,013" and the spraying distance from object about 20–25 cm.

MAINTENANCE PAINTING

Wash down the surface with Maalipesu detergent and rinse carefully with water. Remove old loose paint with scraper. Sand down surface and remove the sanding dust. Stir Helmi or Empire well before use. Apply evenly 1-2 coats of paint. Sand down lightly between each coat.

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In case you intend to use the product for any other purpose than that recommended in this document without first getting our written confirmation on the suitability for the intended use, such use takes place at your own risk.