

WW36
WATER-BORNE UV-PAINT SYSTEMS FOR DIFFERENT KINDS OF WOOD FURNITURE
**AKVI PRIMER
LUMINOL 25 N**

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 25 N is 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
Primer	1-2x Akvi Primer	Spraying	100 - 150 g/m ²
Top coat	1x Luminol 25 N	Spraying	100 - 120 g/m ²

PRODUCT PROPERTIES

Solid Content 42 volume-% Akvi Primer
35 volume-% Luminol 25 N

Specific gravity 1.4 kg/l Akvi Primer
1.3 kg/l Luminol 25 N

Gloss (ISO 2813/60°) Semi-matt Luminol 25 N

Application methods Airless, air assisted airless and conventional spraying

Drying times/50°C

	Dry to sand	Dry to stack
Akvi Primer	3 - 10 min	3 - 10 min
Luminol 25	Flash-off 1 min / 23 °C + 5 min / 50 °C before UV-curing.	

Required UV-energy 500 mJ/cm² + 500 mJ/cm². For proper curing use both Gallium and Mercury lamps.

Thinner Water.

Cleaning of equipment Water.

Colours White, NCS S 0502-Y

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 100-150 g/m² and let it dry. Sand the surface with 240-320 grit sanding paper and remove sanding dust carefully.

If needed apply second coat of Akvi Primer same way as first coat and sand the surface and remove sanding dust.

Stir the Luminol 25 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 - 0,015" 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.