

AUW4920

Ultraguard™ White Conversion Varnish Undercoat- 275 VOC HAPs Free



Date: August 31, 2017 (supersedes all previous revisions)



GENERAL INFORMATION

Axalta's Ultraguard™ White Conversion Varnish Undercoat is a post-catalyzed, acid cured undercoat formulated for high build and superior performance on MDF and other wood substrates used in interior finishing. When properly applied with the companion topcoat, the film properties of this system provide a tough, durable finish that passes all KCMA performance standards. This product is designed for professional application only. For Wood Substrates Only.



1. PRODUCTS

* AUW4920



2. MIXING RATIO

• 3 oz per gallon (2.5% by volume) with CXC4000. VOC max catalyzed is 275 g/l.



3. SHELF LIFE @ 77°F (25°C)

• 18 months from the manufacturing date as packaged. 6-8 hour pot life @77° F once catalyzed



4. CLEAN UP

• Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer soaked rags should be stored in water-filled, closed containers prior to disposal.



5. SURFACE PREPARATION

- Surface must be clean and dust free with a moisture content of 6-8% prior to finishing. Remove all dust, dirt, wax and wood marks. Proper sanding and preparation of the wood is critical to achieving consistent results.
- On new wood, finish sand surface with 150-180 grit sandpaper
- On previously finished wood, remove all old paint or varnish and follow new wood procedure.



6. COMPANION PRODUCTS

- Ultraguard™ White Conversion Varnishes-AUW492X series
- Ultraguard™ Conversion Varnishes -AUF472X series



7. SUBSTRATES

- Commonly used furniture and cabinetry woods
- MDF/HDF

NOTE: Not to be used on exterior applications



10. APPLICATION

• See Application Notes for instruction on MDF application and other wood substrates.



11. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

| | |
|---------------------|---------------|
| Dry to touch | 15-20 Minutes |
| Flash between coats | 30-45 Minutes |
| To Stack | 12-16 Hours |

12. FORCE DRY



| | |
|-----------|-------------------------|
| Flash | 5-8 Minutes |
| Bake | 15 Minutes @ 125°F |
| Cool Down | 10 Minutes ambient |
| Stack | 2 hours after cool down |



13. GUN SET UP



| | |
|----------------------|---------------------|
| Gravity Feed | 1.4 mm - 1.8 mm |
| Siphon Feed | 1.4 mm - 1.8 mm |
| Airless | 10 - 15 thousandths |
| Air-Assisted Airless | 11 - 15 thousandths |

AIR PRESSURES

| | |
|----------------------|-------------------------|
| Gravity Feed | 30-35 psi (2.0-2.4 bar) |
| Siphon Feed | 35-40 psi (2.4-2.8 bar) |
| Air-Assisted Airless | 5-10 psi (0.3-0.7 bar) |

See spray gun manufacturer data for more information



14. PHYSICAL DATA

| | |
|--|---------------------------|
| Viscosity | 18-21 sec. EZ Zahn 2 |
| Weight Solids % | 55.70% |
| Volume Solids % | 36.77% |
| Actual VOC | 1.77lbs/gal of Product |
| VOC Ratio (lb.voc/lb.solids) | 0.28lb VOC/lb solid |
| Regulatory VOC (less water and exempt solvents) | 194.97 g/l |
| Weight Per Gallon | 9.58 lbs/gal |
| Flash Point | 20°F Closed Cup |
| Theoretical Coverage | 589.84 ft/gal @ 1 mil dry |
| VHAP (lb.HAP/lb.solids) | 0.0lb VHAP/lb solid |
| Photochemically Reactive | No |
| Coating Category | White |

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Application Notes:

General:

Always pre-test the system on your substrate to verify suitability of the application.

While under agitation, catalyze the AUW4920 at a rate of 3 oz per gallon (2.5% by volume) with CXC4000 and let mix for 5-10 minutes or until the catalyst is thoroughly incorporated. Stir thoroughly before use and occasionally during use. Apply by spray only, using Conventional Air, HVLP, Airless, or Air Assisted Airless equipment.

On MDF: Apply the undercoat in one, smooth, even "box-coat" at 3-4 wet mils. Spray two coats on the edges. This will help to build enough film on the edges to cover any imperfections in the MDF and allow for a smoother application of the topcoat.

On Other Wood Substrates: Apply at a rate of 3-4 wet mils per coat. Sand between coats with 240-320 grit, no fill type sandpaper. Remove sanding dust before applying the next coat. This finish must be sanded between coats for proper adhesion. 1-2 coats are recommended on Wood substrates. 2 coats are recommended on MDF. Topcoat with AUW492X series Ultraguard™ White Conversion Varnishes-275 VOC. Maximum film thickness of the total coating system MUST NOT EXCEED 4 dry mils.

Drying Time:

Dry to touch: 15-20 minutes

Dry to sand and recoat: 30-45 minutes (depending on ambient conditions).

Do not apply if the material or substrate temperature is below 55°F.

This product is best applied when surface and air temperatures are between 55°-90° F (~12-32°C) and when relative humidity is below 50% during application and drying time.

Clean Up:

Refer to your local regulations for compliance requirements for cleaning solvents. Dispose of dirty solvent and cleaning rags in a safe and compliant manner. Solvent or lacquer soaked rags should be stored in water-filled, closed containers prior to disposal.

Precautions:

These products are recommended for professional application and are designed for interior use only. Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and to avoid potential need for costly refinishing. Axalta Industrial Wood Coatings products are designed to protect and enhance the natural beauty of wood, but cannot eliminate natural discoloration or deterioration of wood as it ages.

Additional notes:

Do not mix with other finishing systems or deviate from these finishing recommendations. Axalta will not be held liable for finish failures resulting from the mixing of products or deviations from finishing recommendations.

Storage:

Store in a cool, dry place. Close all containers after use. Do not store near heat or sparks. Spills should be cleaned up with non-sparking tools. [See the product MSDS for complete safety information.](#)

Warning:

Always pre-test the system on your substrate and under your line conditions to verify suitability to the application and avoid potential need for costly refinishing. All dry times listed are as tested under ideal indoor environmental conditions of 78°F (26°C) with relative humidity not exceeding 50%. These products are recommended for use under temperature conditions of 60-100°F (16-38°C) and when relative humidity is below 50% during application and drying time. Low temperatures, poor air circulation or high humidity will extend dry times. **Axalta strongly recommends against use of these products if temperatures of air, material, or surface to be coated are below 60°F (16°C) or below the dew point. Abnormal conditions of temperature or humidity may adversely affect product performance.** Please contact your authorized Axalta Industrial Wood Coatings distributor for additional product use recommendations and finishing guidance.