

Technical Data Sheet

ESN410-9026

Kombi Ton Base

Product description

Waterborn stain base for interior fitting and furniture. May be applied on most wooden substrates. Offers a more even appearance than solventborn stains. Gives more grain raising compared to solventborn stains especially at veneer joints. Does not hide glue lines. Not to be overcoated with acid catalyst lacquers. Provide for good cleaning since the product can contain binders,

Product data

| | | |
|-----------------------------|----------|---|
| Gloss: | N/A | Gardner 60° |
| Solid content: | 9±1 | [weight %] theoretical |
| Specific gravity: | 1060±10 | [kg/m ³] |
| pH: | 7-9,5 | |
| Frost sensitive: | Yes | |
| Storing: | 6 months | At 5-30 °C Storing at higher temperature reduces shelf life, do not expose to direct sunlight |
| Process Temperature: | 18-30 °C | To achieve the best result and consistency follow the application and surface temperatures given in Schedule of Application for each specific technology and production line. |

Mixing/Application

| Recommended application method | Hardener | Amount hardener [Parts by vol] | Dilutant | Application viscosity | Application amount [g/m ²] | Notes |
|--------------------------------|----------|--------------------------------|------------------------------|-----------------------|--|-------|
| | | | water | | | |
| | | | Stir well before use! | | | |
| Cleaning: | XX699 | | | | | |
| | Water | | | | | |

Drying

| Method | Drying condition | Drying time | Notes |
|---------------|------------------|-------------|--------------------|
| Air Drying | 20 °C | 2-4 h | depends on amounts |
| Forced drying | 50 °C | 10-20 min | depends on amounts |

All kind of drying requires good ventilation and circulation
Do not stack before surface temperature below 30 °C

Curing

| UV-dose | Min UV dose [mJ/cm ²] | Rec min Peak. [mW/cm ²] | Min UV dose [mJ/cm ²] | Rec min Peak. [mW/cm ²] |
|------------------|-----------------------------------|-------------------------------------|-----------------------------------|-------------------------------------|
| | Hg lamps (280-320 nm) | Hg | Ga lamps (390-450 nm) | Ga |
| Full cure | N/A | | | |
| Semi cure | N/A | | | |

Note - Required Peak/Energy is depending on several factors, such as substrate, amount of application, number of layers and type of UV oven / reflectors. Recommended Peak/Energy values will be stated in the finishing instruction/process control submitted by technician.

General information

According to Swedish legislation we provide information regarding dangerous materials. The Safety Data Sheet contains facts about the components, primarily solvents and acids which present the dangerous characteristics. The Safety Data Sheet will be sent on request. All values and recommendations above are to be considered as guidance only. Many factors beyond our control may have an influence on the coating result. Should a problem arise, please contact us and we will advise accordingly. We reserve the right to alter the above specifications.

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