

Technical Data Sheet

ESN420-9027

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 veener 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:	10 ±1	[weight %] theoretical
Specific gravity:	1003-1023	[kg/m ³]
pH:	7-9,5	
Frost sensitive:	Yes	
Storing incl transportation:	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 water	Application viscosity	Application amount [g/m ²]	Notes
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] Hg lamps (280-320 nm)	Rec min Peak. [mW/cm ²] Hg	Min UV dose [mJ/cm ²] Ga lamps (390-450 nm)	Rec min Peak. [mW/cm ²] 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 application amounts and 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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