



Renner Italia S.p.A.  
Via Ronchi inferiore, 34  
40061 MINERBIO (BO)

# YL---M653

Thixo waterborne basecoat for interior

### Main properties

<ul style="list-style-type: none"> <li>Quick dry</li> <li>Excellent transparency</li> </ul>	<ul style="list-style-type: none"> <li>High build</li> <li>Automatic machine sanding</li> </ul>
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### Versions:

YL M653	Clear				
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<b>Recommended use</b>	<ul style="list-style-type: none"> <li>Industrial application</li> <li>Windows frames</li> </ul>	<ul style="list-style-type: none"> <li>Turned parts</li> <li>doors</li> </ul>	<ul style="list-style-type: none"> <li>Fitted furniture</li> </ul>
<b>Application methods</b>	Spray (conventional, airless, airmix). Electrostatic guns may be used provided they are suitable for waterborne products		
<b>Blending instructions</b>	Ready to use. May be further thinned with tap water if necessary Note: at low temperature (below 15°C) the product's viscosity increases dramatically and it is needed add the thinner. We recommend to thin with a 2:1 blend of tap water and <b>AYM444</b> to improve application and drying time.		
<b>Catalysis:</b>	Can be catalized at 2 – 4% with waterbased hardeners <b>YCM401</b> or <b>YCM402</b>		

### Chemical-physical properties (23 °C)

Solids content (%)	40 ± 1
Specific gravity (g/cm <sup>3</sup> )	1,030 ± 0,030
Viscosity DIN 8 (s)	-
Viscosity Brookfield (mPas)	10000 ± 2000
pH	8 - 8,5

### Application properties

Vertical application ( wet µm)	180 max
Recommended N° of coats	1 - 2
Recommended quantity per coat (g/m <sup>2</sup> )	min:100 max: 180
Interval between coats	1 h
Spreading rate (m <sup>2</sup> /litre)	6 -10

### General remarks on the application system

<b>Drying at 20°C e RU% between 45 and 65: 140 g/m<sup>2</sup></b>	
Dust free	45 minutes
Handling	60 minutes
Stackable	4 h
Sanding time	4 h
Overcoating	8 h

<b>Forced drying: 140 g/m<sup>2</sup></b>		
	Temperature	Time
Flash Off	25 °C	5 min
Laminar air	30 °C	30 min
Cooling	20 °C	5 min
Stackable	40 min	
Sanding time	40 min	
Over-coating	2 hours	

**Substrate preparation** Clean well the surface, removing all traces of oil, wax and resins. The wood must be well dry (10-14% humidity content). To minimize fibre raising the bare wood must be well sanded with 150 – 180 grit paper.

**Application instructions:** To obtain the best results, it is recommendable not to thin with water but to choose the best application conditions that allow the maximum atomization. For example, for spray application:

	Nozzle	Air pressure	Coating pressure
Conventional gun	2 - 2,2	3 - 4	--
Airmix	11	0 – 2	80 – 110
Airless	11	--	120 – 150

The use of pre atomizers and pre heaters (with temperatures between 30 and 40 °C) ensure better application constancy whatever it is the ambient room. The application of a second coat or drying carried out at low temperatures and/or when the relative humidity is high require longer drying time. Drying should be carried out in areas with good air ventilation (the whole volume of air of the drying room should be renewed every 15-20 minutes).

**Over-coating:** YL---M653/---- can be over-coated both with waterborne top coat, or with solvent based top coat whatever polyurethane or nitrocellulose.

For further information regarding the use of waterborne products, please refer to the Main Guide

### General remarks

- Mix well before use.
- If properly stored at temperatures between 5 and 35°C, shelf life is 12 months
- On application the temperature of the product, the substrate, the coating and the working environment should never fall below 15°C. Coatings applied at lower temperatures will show chemical and mechanical properties lower than standard performances that can be normally achieved.
- Coating left over (washing waters, waters from spray booths, used coatings) must be disposed of according to local regulations. Never dispose residues directly into drains.
- Application tools must be cleaned with water after use. When dry films must be removed, **AY---M460**, special detergent should be used, letting it work overnight and then cleansing with water

What to do in order to.....	Add	% of use	
		%	Grams for 25 litres
Slow down drying	<b>AY---M444</b>	0,5 - 1	125 - 250
Increase thixotropy or viscosity	<b>AY---M453</b>	0,5 - 1	125 - 250
Eliminate craters/cissings	<b>AY---M457</b>	0,2 - 1	50 - 250
To improve adhesion and elasticity	<b>YC M401</b>	2 - 4	500 - 1000
Improve sandability and stackability	<b>YC---M407</b>	0,2 - 0,5	50 -125