

Product range

Clear

HAC 4	HYDROCOAT CHAIR BASE-COAT TIX HQ
HAC 7	HYDROCOAT CHAIR BASE-COAT FC
HAC 8	HYDROCOAT CHAIR BASE-COAT TIX
HEC 7x Series	HYDROCOAT MONO-COMPONENT TOP-COAT OP 50-30-20-10
HEC 550	HYDROCOAT CHAIR MATT TIX OP 6
HEC 551	HYDROCOAT CHAIR MATT TIX OP 50
HEC 552	HYDROCOAT CHAIR MATT TIX OP 30
HEC 553	HYDROCOAT CHAIR MATT TIX OP 20
HEC 554	HYDROCOAT CHAIR MATT TIX OP 15
HEC 555	HYDROCOAT CHAIR MATT TIX OP 10
HEC 556	HYDROCOAT CHAIR MATT TIX OP 5

Pigmented

HAT 3	HYDROCOAT WHITE BASE-COAT
HKR 114	HYDROCOAT WHITE CONVERTER OP20

Ready-for-use
mono-component
product range,
easy to apply.



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Hydrocoat Chair

WATER-BASED PRODUCTS FOR CHAIRS

Product characteristics

HAC 4 Hydrocoat Chair Base-Coat TIX HQ	High quality, mono-component, water-based base-coat, for electrostatic spray application (manual, robot, reciprocators and disks) Utmost clearness and electrostatic transfer, excellent soakability and coating, high filling, good sandability and verticality, maximum resistance to removal, overlappable with polyurethane products even after 4-hour drying at room temperature (20-25°C)
HAC 7 Hydrocoat Chair Base-Coat FC	Mono-component, water-based base-coat for flow coating and immersion application Easy to use, excellent wrapping, good dryability, good filling and excellent sanding, overlappable with polyurethane top-coats
HAC 8 Hydrocoat Chair Base-Coat TIX	Mono-component, water-based base-coat for electrostatic spray application (manual, robot, reciprocators and disks) Excellent filling and sanding, high thixotropy and dryability, good transparency and resistance to removal, overlappable with polyurethane products
HEC 7x Series Hydrocoat	Water-based mono-component top-coat, high verticality, excellent smoothness and good leveling power Suitable for spray gun coating systems, for flat and vertical furniture panels, small shutters and furnishing accessories
HEC 55 Series Hydrocoat Chair Matt TIX OP xx	Mono-component, water-based top-coats for electrostatic spray application (manual, robot, reciprocators and disks) Excellent verticality and clearness Good filling, softness and soakability Good chemical-physical resistance, excellent resistance to yellowing The following opacity degrees are available: 5 and 65 gloss
HAT 3	White water-based base-coat with excellent filling power, hiding power and sandability spray application for horizontal and vertical surfaces, for interior and exterior parts of furniture, kitchen doors and furniture complements Good removal resistance Optional complementary product optional max 5% of HNB1
HKR 114 Hydrocoat	White water-based Kromosystem converter for interiors Coating cycles by spray application for flat and vertical surfaces Suitable for external sections of furniture in general Easy to use, excellent softness and filling power



AN IVM CHEMICALS' BRAND

ivm Chemicals
coatings & polymers technologies

Hydrocoat Chair

Milesi products were born in 1947 in Italy, from Milesi spa, a company specialized in the production of coatings, stains and primers for wood.

In 1970, Milesi spa became part of IVM, the most important multinational Group in Europe, and among the first groups in the world in this sector. It has Subsidiaries in Italy, France, Spain, Germany, Greece and Poland, distributing in over 70 Countries thanks to a highly specialized Sales Network.

In 2007, **IVM Chemicals originated** from the merger **between Milesi and the other Italian Companies of the Group**, and at the same time it was created the **International Wood Coatings Division**, exclusively dedicated to the distribution of Milesi products all over the world.

The project involves the building of a highly productive plant, thanks to the possibility offered by the processing of quantities never managed before by a single plant.

IVM Chemicals plant is **the largest and most modern manufacturing establishment in the world**, designed to guarantee high process standardization, the constant possibility to intervene with tests and quality controls, the optimization of loading operations and a complete control of raw materials and finished products.

Milesi products have been studied and developed by over **200 researchers** who, **in the European Research and Development labs of the Group**, work every day in constant telematic contact for the future of wood coatings, with the most technologically advanced instruments.



Water-based products for chairs

IVM Chemicals Research and Development Laboratories, which are constantly committed finding new solutions to protect and enhance wood, have created **Milesi HYDROCOAT CHAIR**, innovative water-based product line for chairs, cribs and wood-turned items.

It is a ready-for-use mono-component product range, easy to apply, without pot-life limitations typical of bi-component products. This allows a drastic reduction in consumptions, up to 30%.

Milesi HYDROCOAT CHAIR line includes base and top-coats in different opacity, which guarantee:

- **excellent resistance to abrasions and scratches**
- **high resistance to light**
- **excellent chemical-physical resistance.**

The use of **HYDROCOAT CHAIR** products allows aesthetic performances similar to the ones obtained with solvent-based products:

- **soft-touch surfaces**
- **perfect pore filling**
- **extremely clear film, ensuring the grain to be highlighted and enhanced.**

HYDROCOAT CHAIR products are suitable for all electrostatic coating plants normally used to apply water-based products (such as robots, reciprocators, disks or manual machinery).

Coating cycles

1 - Low environmental impact clear cycle

Operation	Product	Type of application	Quantity gr/smq	N° of coats of paint	Drying*
Dye	CHT/CFT Series	Flow coating - immersion	60 - 70	1	4 hours
Base-Coat	HAC 4 <i>or</i> HAC 8	Electrostatic spray (manual - robot - reciprocators - disks) Electrostatic spray (manual - robot - reciprocators - disks)	110 - 130 110 - 130	1 - 2 1 - 2	12 hours 12 hours
Top-Coat	HEC 55x Series	Electrostatic spray (manual - robot - reciprocators - disks)	100 - 120	1	12 hours

2 - Mixed water/solvent-based clear cycle

Operation	Product	Type of application	Quantity gr/smq	N° of coats of paint	Drying*
Dye	CHT/CFT Series	Flow coating - immersion	60 - 70	1	4 hours
Base-Coat	HAC 4 <i>or</i> HAC 8	Electrostatic spray (manual - robot - reciprocators - disks) Electrostatic spray (manual - robot - reciprocators - disks)	110 - 130 110 - 130	1 - 2 1 - 2	12 hours 12 hours
Top-Coat	LGA 53x Series	Electrostatic spray (manual - robot - reciprocators - disks)	100 - 120	1	4 hours

3 - Mixed water/solvent-based clear cycle – maximum commercial competitiveness

Operation	Product	Type of application	Quantity gr/smq	N° of coats of paint	Drying*
Dye	CHT/CFT Series	Flow coating - immersion	60 - 70	1	4 hours
Base-Coat	HAC 7	Flow coating - immersion	70 - 80	1	12 hours
Top-Coat	LGA 53x Series	Electrostatic spray (manual - robot)	120 - 140	1	4 hours

4 - Water-based clear cycle – maximum commercial competitiveness

Operation	Product	Type of application	Quantity gr/smq	N° of coats of paint	Drying*
Dye	CHT/CFT Series	Flow coating - immersion	60 - 70	1	4 hours
Base-Coat	HAC 7 (opzionale)	Flow coating - immersion	70 - 80	1	12 hours
Top-Coat	HEC 7x Series	Electrostatic spray (manual - robot)	80 - 120	1	12 hours

5 - White Pigmented cycle – low environmental impact

Operation	Product	Type of application	Quantity gr/smq	N° of coats of paint	Drying*
Base-Coat	HAT 3	Electrostatic spray (manual - robot)	90 - 150	1	4 hours
Top-Coat	HKR 114	Electrostatic spray (manual - robot)	140 - 150	1	12 hours

6 - White Pigmented cycle, mixed water/solvent-based

Operation	Product	Type of application	Quantity gr/smq	N° of coats of paint	Drying*
Base-Coat	HAT 3	Electrostatic spray (manual - robot)	110 - 130	1 - 2	12 hours
Top-Coat	LKR 112 series	Electrostatic spray (manual - robot - reciprocators - disks)	100 - 120	1	4 hours

*Room temperature

Coating

The choice of a dye is fundamental for the perfect carrying out of a coating cycle. In the passage from solvent-based to water-based base-coats, dye changing is inevitable because the brightening and bleeding characteristics of the two are completely different, in particular when using water-based base-coats applied by flow coating. It is therefore advisable to verify this aspect and use coating products series CFT-Kromofix and CHT-Kromopastel: our technical-commercial services are available to assess the most suitable solution for every need.

Plants

For what concerns HAC7 it is possible to use the same flow-coating plant used for dyes, but it is necessary to accurately wash it with water (XZC7) before product change. For water-based base and top-coat electrostatic spray applications (manual - robot - reciprocators - disks), the normal existing plants for solvent-based products are usually not suitable. It is therefore necessary to contact the plant technicians to assess the feasibility of plant modifications or buy suitable machinery.

Use

In the event of product dilution, it is advisable to use de-mineralized water to avoid inconveniences derived from excessive water hardness (high salts concentrations).

The water-based line for chairs **HYDROCOAT CHAIR**, like all water-based products, must be used in appropriate working environment, that is to say at a temperature of more than 15°C, with a relative humidity never exceeding 70%, and a good ventilation in the drying rooms.

We recommend wood humidity to be between 8 and 12%.
Stocked products must be kept at temperatures of more than 5°C.

