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TECHNICAL DATA SHEET

OLI-AQUA PRO M 18.10 | 1K multi-coat varnish

Water-based 1K multi-coat varnish for furniture, chairs and shopfitting and interior design.

Gloss level	Range	2.5 L	10 L	30 L
18.10-2 Matt approx. 10 gloss units at 60°	A04141	X		X
18.10-3 Silk matt approx. 20 gloss units at 60°	A04140		⊗	X

Area of application

- Wood and wood-based materials indoors
- Solid wood and veneers
- Home and office furniture, chairs
- Interior fittings: e.g. interior doors, panelling and mouldings
- Shopfitting and exhibition stand construction
- Industrial furniture manufacturing

Properties

- Primer and topcoat; 1K system based on acrylate, thixotropic (standard version)
- Excellent coverage, even application and very good stability
- High transparency and lightfastness
- Fast drying and cross-linking strength
- Can be sanded quickly to a fine finish
- Good resistance to creaming and to plasticisers found in standard PVC seals
- Spray application: cup gun, airless, Airmix; suitable for automatic sprayers
- Forced heat or IR drying possible

Tests / Certifications

- Complies with EU Decopaint
- Flame-retardant: Class B-s1,d0 in accordance with DIN EN 13501-1 in the tested system.
- DIN EN 71-3: Tested migration limits complied with
- DIN 53160, Parts 1 and 2: Saliva and sweat resistant
- Chemical resistance: DIN 68861-1, 1C; 1B for selected test media
- IOS-MAT-0066 R4: Residential and office furniture; MÖBELFAKTA: Category 2

Composition

Aqueous binder system based on an acrylate dispersion.

Wood preparation

- The surface must be dry, clean and free from oil, wax, grease and silicone. Sand the wood with P150-180 and remove the sanding dust thoroughly.
 - The wood moisture content should be between 8-12 per cent.
 - Pre-treat resin-rich and substance-rich woods such as pine, limba, teak or wengé prior to coating with a sealer suitable for the respective substrate and the subsequent coating system. Consult OLI Application Technology for the appropriate system recommendation.
 - Pre-treat raw MDF edges and milled areas with a suitable sealer to reduce moisture absorption and swelling. Take into account the board quality and intended area of use.
- Check compatibility, adhesion and colour tone by carrying out a test application on the original wood, particularly on dark or dark-stained surfaces.

Application conditions	Optimal application conditions: +20 °C and 50 per cent relative humidity. Application temperature: at least +15 °C.		
Material preparation	Stir the material thoroughly. Seal opened containers tightly after each use to prevent the material from drying out and a skin forming.		
Thinning	For application with a cup gun, airless or Airmix spray gun, use undiluted and without adding hardener.		
Application	The following information applies to the standard thixotropic formulation.		
		Cup	Airless/Airmix
	Spray pressure (bar)	2.0 – 3.0	90 – 120
	Nozzle size (mm)	1.8 – 2.0	0.23 – 0.28
	Thinner addition (%)	none	none
	Working viscosity	Ready to use	Ready for application
	Application rate per coat (g/m²)	100 – 120	100–120
	Coverage per application (m²/L)	8–10	8–10
	Flow time (as supplied): 120–140 seconds at +20 °C in accordance with DIN 53211, 4 mm cup.		
	Measurement to be carried out after thorough stirring or shaking.		
Processing instructions	All fittings in contact with the material must be made of stainless steel. The material is also suitable for automatic spraying machines. Forced heat or IR drying is possible. Coordinate the process conditions with OLI Application Technology. A low-viscosity special grade (NV, approx. 70 seconds flow time at +20 °C according to DIN 53211, 4 mm cup) is available on request. The above processing details refer to the standard grade.		
Recommended application sequence	Primer		
	Apply OLI-AQUA PRO M 18.10 at approx. 100–120 g/m².		
	Intermediate sanding		
Drying	After approx. 2 hours’ drying, sand with P240 and remove all dust thoroughly.		
	Top coat		
	Reapply OLI-AQUA PRO M 18.10 at a rate of approx. 100–120 g/m².		
	Dust-dry: after approx. 1 hour		
	Recoatable / sandable: after approx. 2 hours		
	Stackable: after at least 16 hours at +20 °C and 50 per cent relative humidity		
	Fully resistant to mechanical and chemical stress: after approx. 2 days once completely dry		
	The minimum drying time until stackable applies provided the specified application conditions are observed; in practice, allow for overnight drying.		
	Drying times depend on temperature, humidity, air circulation and the amount applied.		
	Low temperatures, poor air circulation, high application rates and high humidity delay drying.		
Tools / Cleaning	Clean tools with tap water immediately after use.		
Storage / Shelf life	The product has a shelf life of at least 24 months when stored in the unopened original container in a cool, dry place protected from frost. Store and transport at temperatures between +5 °C and +30 °C. Seal opened containers tightly after use to prevent a skin from forming.		
Safety	Refer to the current safety data sheet at www.oli-lacke.de for labelling and safety instructions.		

Our verbal and written recommendations regarding application are provided for guidance only and are not binding. They are based on our experience and the current state of practical knowledge. They do not relieve the applicator of the responsibility to test our products themselves, at their own risk, to ensure they are suitable for the intended purpose. All previous editions are hereby superseded. Date: 20 October 2026 – sst