Chemcraft
A Great Finish is Only the Beginning

AkzoNobel

131-82XX Optiset® 550 Pre-Cat White Topcoat

Product codes:	131-8215 15° Low Gloss 131-8225 25° Low Gloss 131-8240 40° Satin 131-8260 60° Semi-Gloss	**Viscosity**	Zahn #2 signature cup 36 sec at 77°F (25°C)
		Flash Point:	-20°C (-4°F)
		Density (kg/l):	1.06
		Solid (% by weight):	47%
		Solid (% by volume):	31%
		Shelf Life (months):	6

Product Description:
Optiset 550 is a one-component, pigmented Pre-Catalyzed Reactive Amino Coating (RAC) with good resistance properties. This product meets the German “E-1” classification for the emission of formaldehyde as tested by an accredited laboratory using North American test methods. This is a fast building pigmented pre-catalyzed RAC due to its high solid content (32% volume). Optiset 550 demonstrates very good moisture, household wear, household chemical and mar resistance. The coating has light stable properties due to the type of resin used. This coating may be catalyzed to further enhance its durability. Contact your coating supplier for a recommendation. Optiset 550 has very low odor during the curing process while maintaining its rapid dry and cure properties.
Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards. Recommended: Architectural Woodwork Institute (AWI). O.P.2.

Uses:
Optiset 550 is recommended for kitchen cabinets, office and household furniture, as well as other interior wood applications.

Environmental Data (as supplied):	**VOC less exempt lb/gal:**	<4.80
	VOC lb/gal:	<4.80
	VOC less exempt g/l:	
	VOC g/l:	
	VOC lb/lb Solid:	<1.00
	VHAPs lb/lb Solid:	<0.05

Note:
See individual compliance sheets for specific data

Application Data	**Suggested Uses:**	Spray
	Mixing Ratio:	100 parts 131-82XX to 3 parts 999-017*
	Suggested Uses:	8 hours*
	Application Viscosity:	Zahn #2 signature cup 35 – 36 seconds
	Reducer:	121-803 or 121-8020
	Retarder:	800-5328 EEP
	Clean-up Solvent:	Lacquer Thinner
	Recommended Wet Film:	3 – 5 mils wet
	Coverage:	12 m^2/l (130 pi^2/l) at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Note:
*Amount of catalyst required & pot life if material is catalyzed.

Directions for use:

Surface Preparation:
Wood substrate should be sanded with 120, 150 or 180 grit paper prior to coating. Primers should be sanded with 280/320 grit stearated paper prior to topcoating. When recoating, the previous coat of Optiset 550 or primer must be sanded and the next coat applied within eight hours. Optiset 550 White cannot be used on metal, old oil or cellulose lacquers.

General Information:
Agitate material before use. Always mix Optiset 550 while adding hardener and reducers in the recommended mixing ratios. Optiset 550 must be agitated thoroughly at all times to ensure product consistency and consistent gloss.

Apply at 3-5 mils wet on sanded or primed substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. Maximum film build of Optiset 550 White should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. The second and subsequent coats must be applied the same day as the previous coat is sanded.
Contact with metal surfaces should be avoided.

Optiset 550 White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Optiset 550 White must not be used and dried at temperatures below 18°C or relative humidity above 65%. During hardening the enamel must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.
Basecoats to use with 131-82XX: 522-1624, 545-8016, 546-7257 or self-seal

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	10 – 15 minutes	Flash off before entering oven
Dry to Sand:	2 hours	3 hours
Dry to Stack:	30 - 45 minutes	60 - 90 minutes

Note:
N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

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