

431-90XX Opticlear Pre-Cat Clear Topcoat

Product codes:	431-9010 10° Matte	Viscosity	Zahn #2 signature cup 45 sec at 25°C
	431-9020 20° Low Gloss	Flash Point:	-3°C (26°F)
	431-9035 35° Satin	Density (kg/l):	0.92
	431-9050 50° Semi-Gloss	Solid (% by weight):	30%
	431-9090 90° High Gloss	Solid (% by volume):	23%
		Shelf Life (months):	6

Product Description:

Opticlear is a one component, Pre-Catalyzed lacquer especially developed for surface treatment of furniture where a beautiful appearance with good resistance properties is desired. To augment the chemical resistance of the product, Opticlear 431-90XX may be catalyzed.

Uses:

Opticlear is fast drying and well suited for spraying as well as coating by roller and curtain coating. The material is used for an open or semi open grain finish on all types of wood for interior use.

Environmental Data (as supplied):

VOC less exempt lb/gal:	<2.29
VOC lb/gal:	<0.60
VOC less exempt g/l:	
VOC g/l:	
VOC lb/lb Solid:	<0.35
VHAPs lb/lb Solid:	<0.001

Note:

See individual compliance sheets for specific data

Application Data

Suggested Uses:	Spray
Mixing Ratio:	3% 999-017 if catalyzed
Suggested Uses:	8 hours if catalyzed
Application Viscosity:	Zahn #2 signature cup 20-25 seconds
Reducer:	121-8020 or 121-803
Retarder:	800-5328 EEP
Clean-up Solvent:	Lacquer Thinner
Recommended Wet Film:	3-5 wet mils
Coverage:	9 m ² /l (100 pi ² /l) at 1 mil dry and at 100% efficiency. Coverage will vary depending on method of application or coating thickness.

Note:

N/A

Directions for use:

Surface Preparation:

Wood substrate should be sanded with 120, 150 or 180 grit paper prior to staining or coating. Sealers should be sanded with 280/320 grit steared paper prior to topcoating. The sealer should be topcoated within eight hours of sanding. When recoating, the previous coat of Opticlear must be sanded and the next coat applied within eight hours. Stain systems under acid containing coatings should be acid stable. Opticlear can not be used on metal, old oil or cellulose lacquers.

General Information:

Agitate material before use. Always mix Opticlear while adding hardener and reducers in the recommended mixing ratios. Opticlear must be agitated thoroughly at all times to ensure product consistency and consistent gloss. Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit steared paper. Contact with metal surfaces should be avoided.

Opticlear must not be used and dried at temperatures below 18°C or relative air humidity above 65% as the hardening may otherwise become incomplete. During hardening, the lacquer must not be exposed to ammonia vapours. Ammonia cleaners should not be used for cleaning the finished surface.

Maximum film build of Opticlear should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry.

431-90XX can be used as a self-seal or with following sealers: 390-001, 390-0060, 431-1219, 401-004 (not catalyzed), 401-028 (not catalyzed), 546-5192 and 546-8003.

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:	15 minutes	Flash off before entering oven
Dry to Sand:	2 hours	3 hours
Dry to Stack:	30 minutes	1 hour

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.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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