

546-8003 Plastiseal LVOC Pre-Cat Clear Sealer

Product codes: 546-8003 Plastiseal	Viscosity	Zahn #2 signature cup 17-18 sec at 25°C
	Flash Point:	-20°C
	Density (kg/l):	0.91 ± 2% at 25°C
	Solid (% by weight):	22 ± 2%
	Solid (% by volume):	15 ± 2%
	Shelf Life (months):	6

Product Description:

Plastiseal LVOC is a one-component Pre-Catalyzed Reactive Amino Coating (RAC) sealer that provides excellent sealing properties and a smooth finish. This Low VOC containing product is designed for application that requires a rapid dry and an easy sanding material.

Uses:

Plastiseal LVOC is intended for use on interior wood applications

Environmental Data (as supplied):

VOC less exempt lb/gal:	<5.9
VOC lb/gal:	<5.0
VOC less exempt g/l:	
VOC g/l:	
VOC lb/lb Solid:	<3.2
VHAPs lb/lb Solid:	<0.45

Note:

See individual compliance sheets for specific data

Application Data

Suggested Uses:	Spray
Mixing Ratio:	N/A
Suggested Uses:	N/A
Application Viscosity:	17-18 sec Zahn #2 at 25°C
Reducer:	Lacquer thinner 803-1339/121-001 or 121-8020 if required
Retarder:	800-5328 EEP
Clean-up Solvent:	Lacquer Thinner
Recommended Wet Film:	3 to 5 mils wet
Coverage:	6 m ² /l (65 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 must be sanded with a 120, 150 or 180 grit paper and free of dust and all contaminants prior to staining or coating. Sealer must be sanded with a 280/320 paper and the next coat applied within 8 hours of being sanded. This sealer must not be applied over metal, old finish or nitrocellulose lacquer. Stain systems used under acid catalyzed systems should be acid stable.

General Information:

Agitate material before use. Apply 3 to 5 mils wet on sanded surface. Further coats can be applied after complete drying of the first coat. A thorough sanding of each coat with paper # 240/320 is essential for proper adhesion. Eliminate all contact with metallic surfaces. Maximum film build of the topcoat should not exceed 2 mils dry. Maximum film build of the system should not exceed 4 mils dry.

To obtain complete cure, Plastiseal LVOC should be applied at temperature above 18°C and relative humidity below 65%. When drying, this product is not to be exposed to ammonia vapors. Finished surfaces must not be cleaned with ammonia containing products. Always use plastic or stainless equipment to eliminate discoloration due to oxidation.

Topcoats to use with 546-8003: 431-22XX, 431-30XX, 431-90XX, 431-98XX, 421-55XX, 421-67XX, 421-72XX and 482-3XX. 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 – 20 minutes	Flash off before entering oven
Dry to Sand:	30 - 45 minutes	3 hours
Dry to Stack:	20 – 30 minutes	45 - 50 min

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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