

## 635-0XX Dancryl Acrylic Post-Cat Clear TC

<b>Product codes:</b>	635-015 15° Matte	<b>Viscosity</b>	Zahn #2 signature cup 40 sec at 25°C
	635-035 35° Satin	<b>Flash Point:</b>	14°C (57°F)
	635-090 90° High Gloss	<b>Density (kg/l):</b>	0.95
		<b>Solid (% by weight):</b>	39%
		<b>Solid (% by volume):</b>	34%
		<b>Shelf Life (months):</b>	12

### Product Description:

Dancryl is a two component, acrylic lacquer designed for all types of wood for interior use. It provides a smooth, hard wearing surface that is resistant to alcohol, water, grease and usual household chemicals. Dancryl is especially suited for topcoating light coloured basecoats due to its good light stability and water white appearance.

### Uses:

Dancryl is used on interior wood when clarity and light stability are very important.

### Environmental Data (as supplied):

<b>VOC less exempt lb/gal:</b>	0.81
<b>VOC lb/gal:</b>	0.36
<b>VOC less exempt g/l:</b>	
<b>VOC g/l:</b>	
<b>VOC lb/lb Solid:</b>	0.06
<b>VHAPs lb/lb Solid:</b>	0.01

### Note:

See individual compliance sheets for specific data

### Application Data

<b>Suggested Uses:</b>	Spray
<b>Mixing Ratio:</b>	8% with 999-017 by volume
<b>Suggested Uses:</b>	8 hours
<b>Application Viscosity:</b>	Zahn #2 signature cup 20-25 seconds
<b>Reducer:</b>	121-8020 or 121-803
<b>Retarder:</b>	800-5328 EEP
<b>Clean-up Solvent:</b>	Lacquer Thinner
<b>Recommended Wet Film:</b>	3-5 wet mils
<b>Coverage:</b>	13 m <sup>2</sup> /l (145 pi <sup>2</sup> /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 stearedated paper prior to topcoating. Appropriate sealers are self seal or catalyzed 401 line vinyl sealer. When recoating, the sealer or previous coat must be sanded and the next coat applied within eight hours. Stain systems under acid containing coatings should be acid stable. Dancryl can not be used on metal, old oil or cellulose lacquers.

**General Information:**

Agitate material before use. Always mix Dancryl while adding hardener and reducers in the recommended mixing ratios. Dancryl 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 stearedated paper.

Contact with metal surfaces should be avoided.

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

To obtain a complete cure, the system should be applied at an ambient temperature above 18°C and a 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.

This product could be used as a self seal or over catalyzed vinyl sealer 401-004.

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:**

	<b>Room Temperature (20°C / 68°F)</b>	<b>Forced Drying Schedule (50°C / 122°F)</b>
<b>Tack Free Time:</b>	20 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	6 hours	Overnight
<b>Dry to Stack:</b>	2 hours	3 hours

**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.

Akzo Nobel Coatings, Inc  
 1431 Progress Ave  
 High Point, NC 27260  
 336-841-5111

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