



117-10XX Plasticolor White Post-Cat Pigmented TC

Product Codes: 117-1010 Matte 117-1020 Low Gloss 117-1035 Satin 117-1050 Semi-Gloss 117-1090 High Gloss	Viscosity: Zahn #4 signature cup 30 sec at 77°F Flash Point: 63°F (17.2°C) Density (lb/gal): 9.90 Solid (% by weight): 65% Solid (% by volume): 51% Shelf Life (months): 12
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Product Description:
 Plasticolor White is an acid curing, light stable, fast drying Reactive Amino Coating (RAC) with good building properties. This is a fast building product due to its high solid content (51% volume). Plasticolor White gives a smooth, knock-proof and hardwearing surface resisting influence from alcohol, water, etc. Plasticolor White has very good light stability based on the type of resin used.
 Special Recognition: When applied as specified, will meet required performance for the ANSI/KCMA A161.1 1990 9.0 Finish Test.
 Recommended: Architectural Woodwork Institute (AWI) O.P.4.

Uses:
 Plasticolor is used as the final coat over wood, plywood, chipboard, etc., meant for interior use. This product is recommended for kitchen cabinets, high build office or residential furniture as well as many other interior wood applications where high build and durability are required.

Environmental Data (as supplied):	VOC less exempt lb/gal: <3.50 VOC lb/gal: <3.50 VOC less exempt g/l: <405 VOC g/l: <405 VOC lb/lb Solid: <0.55 VHAPs lb/lb Solid: <0.30
Note: See individual compliance sheets for specific data	

Application Data:	Suggested Uses: Wood Finish Mixing Ratio: 100 parts 117-10XX to 10 part 873-0870 Pot Life: 12 hours Application Viscosity: Zahn #2 signature cup 22 – 25 seconds Reducer: 803-1325 Retarder: 800-5328 Clean-up Solvent: 803-1298 Recommended Wet Film: 5 mils Coverage: 866 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.
Note: N/A	

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Directions for use:

Surface Preparation:

Primer should be sanded using 240 and 320 grit steared paper. Suitable primers are Plastiprimer MDF 522-1410, Plastiprimer White 522-1420 or Chemlife® 24 White Primer 522-2400 for solid woods like Maple and Oak. Primers should be topcoated within eight hours of sanding. Care should be taken during sanding to avoid sanding through the primer.

General Information:

Catalyze and reduce the material as recommended. Plasticolor White is applied in one or two coats and can be used both as a primer and enamel on all kinds of wood meant for interior use. A premium system is however, obtained through priming with Plastiprimer MDF 522-1410, Plastiprimer White Hardwood 522-1420 or Chemlife 24 White Primer 522-2400.

A thorough sanding between the coats is essential to the adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. Plasticolor White cannot be used on metal, old oil or cellulose lacquers.

Total recommended film build of primer and Plasticolor White 117-10XX is not to exceed 6 mils dry. Over the primer, the topcoat should not exceed 4 mils dry.

To ensure proper sheen, the catalyzed material should be agitated at all times. Plasticolor White must be thoroughly stirred, while adding catalyst and thinner in the recommended mixing ratio. Contact with metal surfaces should be avoided once the Plasticolor White has been catalyzed.

Plasticolor White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats. Plasticolor White must not be used and dried at temperatures below 65°F (18°C) or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

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 (68°F)	Forced Drying Schedule (122°F)
Tack Free Time:	15 – 20 minutes	Flash off before entering oven
Dry to Sand:	3 hours	1 hour
Dry to Stack:	Overnight	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.

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