



# Chemcraft®

A Great Finish is Only the Beginning

## 421-84XX E-Var 275 Post-Cat Clear TC

<b>Product Codes:</b> 421-8410 Matte 421-8420 Low Gloss 421-8440 Satin 421-8460 Semi-Gloss 421-8490 High Gloss	<b>Viscosity:</b> Zahn #2 signature cup 19 sec at 77°F <b>Flash Point:</b> -4°F (-20°C) <b>Density (lb/gal):</b> 8.51 <b>Solid (% by weight):</b> 41% <b>Solid (% by volume):</b> 36% <b>Shelf Life (months):</b> 12
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**Product Description:**  
 E-Var 275 is a two-component post-catalyzed Reactive Amino Coating (RAC). This product has been formulated to meet 275 g/l VOC regulations. E-Var 275 is a fast drying, good building product that shows excellent resistance to both chemicals and to physical wear. The coating has excellent leveling and a smooth even appearance, even on open-grain woods. E-Var 275 is supplied at a ready to spray viscosity. This coating will dry quickly and sand easily and can be used a self seal finish.  
 Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.  
 Recommended: Architectural Woodwork Institute Conversion Varnish System (8<sup>th</sup> Ed).

**Uses:**  
 E-Var 275 is recommended for office and household furniture, kitchen cabinets, as well as many other high performance interior wood applications. E-Var 275 is designed for use on all types of solid wood and veneer meant for interior use.

<b>Environmental Data (as supplied):</b>	<b>VOC less exempt lb/gal:</b> <2.20 <b>VOC lb/gal:</b> <1.15 <b>VOC less exempt g/l:</b> <264 <b>VOC g/l:</b> <137 <b>VOC lb/lb Solid:</b> <0.35 <b>VHAPs lb/lb Solid:</b> <0.10
<b>Note:</b> See individual compliance sheets for specific data	

<b>Application Data:</b>	<b>Suggested Uses:</b> Wood Finish <b>Mixing Ratio:</b> 100 parts 421-84XX to 3 parts 873-1205 <b>Pot Life:</b> 8 hours <b>Application Viscosity:</b> Zahn #2 signature cup 17-19 seconds <b>Reducer:</b> 803-1325 or 803-1349 <b>Retarder:</b> 800-5328 <b>Clean-up Solvent:</b> 800-5500 <b>Recommended Wet Film:</b> 3 – 5 mils <b>Coverage:</b> Coverage is 576 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.
<b>Note:</b> The addition of these reducers and retarders could affect 275 VOC compliance.	

## 421-84XX E-Var 275 Post-Cat Clear TC

### Directions for use:

#### Surface Preparation:

Substrate must be sanded using 120, 150 or 180 grit stearated paper prior to staining or coating. When sealing, the sealer coat should be sanded prior to being coated with 280/320 grit stearated paper. The sealer should be topcoated within eight hours of being sanded. This product is designed to be used as a self seal. When recoating, the previous coat of E-Var 275 must be sanded and the next coat applied within eight hours. E-Var 275 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using 825-39XX series stains or 824-50XX series waterborne stains.

#### General Information:

Agitate material before use. E-Var 275 must be agitated thoroughly at all times to ensure product consistency and consistent gloss. Always mix E-Var 275 while adding hardener and reducers in the recommended mixing ratios.

Apply at 3-5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Maximum film build of E-Var 275 should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. Contact with metal surfaces should be avoided.

Please note that, as with any other amino-containing product, this material contains, and has the potential to emit, formaldehyde (CAS# 50-00-0). As per the US Department of Labor Standard 29 CFR 1910.1048 covering formaldehyde, section (d)(1)(i) states that "Each employer who has a workplace covered by this standard shall monitor employees to determine their exposure to formaldehyde." Please refer to the OSHA web site at [www.osha.gov](http://www.osha.gov) for further information.

E-Var 275 must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. E-Var 275 must not be used and dried at temperatures below 64°F or relative humidity above 65%. During hardening 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)
<b>Tack Free Time:</b>	30 – 40 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	60 - 90 minutes	30 – 60 minutes
<b>Dry to Stack:</b>	Overnight	3 – 4 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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