



431-85XX Opticlear Light 550 Pre-Cat Clear TC

Product Codes: 431-8510 Matte 431-8520 Low Gloss 431-8540 Satin 431-8560 Semi-Gloss 431-8590 High Gloss	Viscosity: Zahn #2 signature cup 19 sec at 77°F Flash Point: -4° F (-20°C) Density (lb/gal): 7.3 Solid (% by weight): 24% Solid (% by volume): 17% Shelf Life (months): 6
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Product Description:
 Opticlear Light 550 is a one-component high solids pre-catalyzed Reactive Amino Coating (RAC). Opticlear 550 demonstrates very good moisture, household wear, household chemical and mar resistance. Opticlear Light 550 is supplied at a ready to spray viscosity. This coating will dry quickly and sand easily. Opticlear Light 550 may be catalyzed to further enhance its durability.
 Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.
 Recommended: Architectural Woodwork Institute Pre-Catalyzed Lacquer System (8th Ed).

Uses:
 Opticlear Light 550 is recommended for office and household furniture, kitchen cabinets, as well as many other interior wood applications.

Environmental Data (as supplied): Note: N/A	VOC less exempt lb/gal: <4.60 VOC lb/gal: <2.17 VOC less exempt g/l: <550 VOC g/l: <260 VOC lb/lb Solid: <1.3 VHAPs lb/lb Solid: <0.02
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Application Data: Note: N/A	Suggested Uses: Wood Finish Mixing Ratio: 100 parts 431-85XX to 1 part 873-1205 (when catalyzed) Pot Life: 8 hours (when catalyzed) Application Viscosity: Zahn #2 signature cup 18 – 19 seconds Reducer: 800-5500 Retarder: 800-5328 Clean-up Solvent: 800-5500 Recommended Wet Film: 3 – 5 mils Coverage: Coverage is 250 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.
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Directions for use:

Surface Preparation:

Substrate must be sanded using 120, 150 or 180 grit stearated paper prior to staining or coating. Sealers, if used, should be sanded prior to being coated with 280/320 grit stearated paper. The sealer should be topcoated within eight hours of being sanded. When recoating, the previous coat of Opticlear Light 550 must be sanded and the next coat applied within eight hours. Opticlear Light 550 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. AkzoNobel recommends using Chemcraft Intermix 825-0XXX series stains or 824-50XX series waterborne stains.

General Information:

Agitate material before use. Opticlear Light 550 must be agitated thoroughly at all times to ensure product consistency and consistent gloss. Always mix Opticlear Light 550 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 Opticlear Light 550 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 pre-catalyzed 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 for further information.

Opticlear Light 550 must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Opticlear Light 550 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)
Tack Free Time:	10 – 15 minutes	Flash off before entering oven
Dry to Sand:	2 hours	30 – 45 minutes
Dry to Stack:	3 hours	60 – 90 minutes

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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