



Chemcraft®

A Great Finish is Only the Beginning

545-5900 Optiprime 275 White Pre-Cat Primer

Product Codes: 545-5900	Viscosity: Zahn #2 signature cup 24 sec at 77°F Flash Point: -4°F (-20°C) Density (lb/gal): 9.08 Solid (% by weight): 39% Solid (% by volume): 26% Shelf Life (months): 3
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Product Description:
 Optiprime 275 White is a one-component, high solids, pre-catalyzed Reactive Amino Coating (RAC) used as a primer for pre-catalyzed or catalyzed systems. This product has been formulated to meet 275 g/l VOC regulations. Optiprime 275 White is a high solids primer with high build and filling properties. The material has good hiding characteristics and sands to a smooth finish.
 Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards.
 Recommended: Architectural Woodwork Institute Pre-catalyzed Lacquer System (8th Ed).

Uses:
 Optiprime 275 White is recommended for use office and household furniture, kitchen cabinets, as well as many other interior wood applications.

Environmental Data (as supplied):	VOC less exempt lb/gal: <2.29
	VOC lb/gal: <0.80
	VOC less exempt g/l: <275
	VOC g/l: <100
	VOC lb/lb Solid: <0.20
	VHAPs lb/lb Solid: <0.03
Note:	See individual compliance sheets for specific data

Application Data:	Suggested Uses: Wood Primer
	Mixing Ratio: 100 parts 545-5900 to 1.5 parts 873-1900
	Pot Life: 8 hours
	Application Viscosity: Zahn #2 signature cup 24 seconds
	Reducer: 803-1384
	Retarder: 800-5915
	Clean-up Solvent: 800-5500
	Recommended Wet Film: 3 – 5 mils
	Coverage: N/A
Note:	N/A

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Directions for use:

Surface Preparation:

Substrate should be sanded using 120, 150 or 180 grit steared paper prior to coating. When re-coatings Optiprime 275 White must be sanded and the next coat applied within eight hours. Optiprime 275 White may be topcoated with pre-catalyzed RAC topcoats such as Variset 275 131-17XX, or when catalyzed with Plasticolor 275 117-19XX.

General Information:

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

This coating may be catalyzed to further enhance its durability.

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

Maximum film build of Optiprime 275 White should not exceed 3 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. Contact with metal surfaces should be avoided.

Optiprime 275 White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats.

Optiprime 275 White must not be used and dried at temperatures below 64°F 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 finish surfaces. This may accelerate discoloration. 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 website at www.osha.gov for further information.

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:	1 - 2 hours	30 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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