



546-5900 Optiseal 275 Pre-Cat Clear Sealer

Product Codes: 546-5900	Viscosity: Zahn #2 signature cup 19 sec at 77°F Flash Point: -4° F (-20°C) Density (lb/gal): 7.9 Solid (% by weight): 27% Solid (% by volume): 20% Shelf Life (months): 3
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Product Description:
 Optiseal 275 is a one-component high solids pre-catalyzed Reactive Amino Coating (RAC) sealer that provides excellent sealing properties and very rapid dry. This product has been formulated to meet 275 g/l VOC regulations. Optiseal 275 is an easy sanding sealer designed for the professional applicator that requires a rapid dry and an easy sanding material. Labor saving through the elimination of a coating step or two is generally realized due to the high solids in the product. Special Recognition: Meets Kitchen Cabinet Manufacturer Association (DMCA Standards). Recommended: Architectural Woodwork Institute Pre-catalyzed Lacquer System (8th Ed).

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

Environmental Data (as supplied):	VOC less exempt lb/gal: <2.27 VOC lb/gal: <0.70 VOC less exempt g/l: <275 VOC g/l: <84 VOC lb/lb Solid: <0.35 VHAPs lb/lb Solid: <0.001
Note:	See individual compliance sheets for specific data

Application Data:	Suggested Uses: Wood Finish Mixing Ratio: 100 parts 546-5900 to 1 part 873-1205* Pot Life: 8 hours (catalyzed) Application Viscosity: Zahn #2 signature cup 17 - 19 seconds Reducer: 803-1325 or 803-1349 Retarder: 800-5815 Clean-up Solvent: 800-5500 Recommended Wet Film: 3 - 5 mils Coverage: Coverage is 332 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.
Note:	Amount of catalyst required & pot life if material is catalyzed. *The addition of reducers or retarders could affect the 275 VOC compliance.

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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. The sealer should be sanded and the next coat applied within eight hours of being sanded. Optiseal 275 cannot be used on metal, old oil or cellulose lacquers. Stain systems used under acid catalyzed systems should be acid stable. Optiseal 275 may be topcoated with pre-catalyzed RAC topcoats such as Opticlear 275 topcoat 431 39XX or E-Var 275 421-84XX (546-5900 must be catalyzed prior to use). AkzoNobel recommends using 825-39XX series stains or 824-50XX series waterborne stains.

General Information:

Agitate material before use. Optiseal 275 must be agitated thoroughly at all times to ensure product consistency. Always mix Optiseal 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 Optiseal 275 should not exceed 2 mils dry. Maximum film build of total coating system must not exceed 3 mils dry. Contact with metal surfaces should be avoided.

Optiseal 275 may be catalyzed to further enhance its durability. Optiseal 275 must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Optiseal 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.

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.

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:	20 minutes	Flash off before entering oven
Dry to Sand:	1 – 1.5 hours	30 – 45 minutes
Dry to Stack:	2 - 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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