Chemcraft International, Inc.

Product Information

Plasticolor Ready White 117-5525

PRODUCT DESCRIPTION

Plasticolor® Ready White is an acid curing, light stable, fast drying reactive amino coating with good building properties. It gives a smooth, knock proof and hardwearing surface resisting influence from alcohol, water, etc. It is used as the final coat over wood, plywood, chipboard, etc. meant for interior use.

FEATURES

Plasticolor® must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats.

Plasticolor® must not be used and dried at temperatures below 18C or relative air humidity above 65% as the hardening may otherwise become incomplete. During hardening, the enamel must not be exposed to ammonia vapours.

Ammonia cleaners should not be used for cleaning the finished surface. **Ammonia cleaners should not be used for cleaning the finished surface.**

SPECIFICATION VALUES

Gloss: 25

Flash Point:	14C (57°F)
Specific Gravity:	1.1
Weight per Gallon:	9.16 lbs.
Solids by Weight:	54%
Solids by Volume:	42%
Fire Hazard Class:	3
Health Hazard Class:	3
Viscosity at 25C (77F):	21" Z#2
VOC:	505 g/l
Lbs. VOC/Gallon:	4.2 lb/gal
Lbs. VOC/Lbs. Solids:	0.85
Lbs. VHAPs/Lbs. Solids:	0.56

Values at Application:(10% Catalyst)

Lbs. VOC/Lbs. Solids:	0.96
Lbs. VHAPs/Lbs. Solids:	0.55

If additional reducers or additives are used, compliance values must be recalculated.

SPECIFICATION INFORMATION

unopened and stored between 15C - 25C (59F - 77F). Always rotate stock.

Pot Life: Mix only enough for one days use for optimum product performance. Use of material that has been catalyzed for more than 8 hours may cause failure in film integrity.

Coverage: Coverage is 16-18 sq. m/L (690 sq.ft./G) at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Mixing Ratio: 100 parts volume by Plasticolor 117-5525: 8 parts by volume of Catalyst 999-017.

Reduction: Not requirede, but use slow reducer 121 802 for hot climates and extra flow. Other reducers may be recommended for varying conditions.

Use up to 20% by volume of thinner as required to obtain recommended viscosity.

Plasticolor Ready White 117-5525

DIRECTIONS FOR USE

Surface Preparation: Primer should be well sanded using 240 and 320 grit stearated paper. Suitable primers are Reslack Sealer (740 XXX) or Plasticolor® Primer (220 XXX). Primers must be sanded no more than eight hours before being coated. Care should be taken during sanding to avoid sanding through the primer.

Directions for Use: Catalyze and reduce material as recommended. Contact with metal surfaces should be avoided once the Plasticolor® has been catalyzed. To ensure proper sheen, the catalyzed material should be agitated at all times. Plasticolor® must be thoroughly stirred, while adding hardener and thinner in the recommended mixing ratio.

Total recommended film build of Plasticolor® primer and topcoat is not to exceed 6 mils dry. Over the Reslack primer, the topcoat should not exceed 4 mils dry.

The customer is responsible for following the recommended application procedures. Failure to adhere to the recommendations given in this technical data sheet will likely result in unsatisfactory film appearance or film failure.

The completed coating system should be checked for required properties prior to start up of production. will likely result in unsatisfactory film appearance or film failure.

APPLICATION

Method of Application:	**Viscosity**	**Wet Film**	**Dry Film**
Spray - Conventional	Z #2/19-23"	4-5 mils	1.6 2.0 mils
- Airless	Z #2/19-23"	4-5 mils	1.6-2.0 mils
- HVLP	Z #2/19-23"	4-5 mils	1.6-2.0 mils
- Air Assist Airless	Z #2/19-23"	4-5 mils	1.6-2.0 mils

All measurements recommended are based on results at temperatures of 20°C(68°F). Viscosity will vary depending on the temperature of the liquid.

Drying Times:

At 20C (68ºF)	(Minimum Required)	At 20C (122ºF)	(Minimum Required)
Tack Free:	15-20 minutes	Tack Free:	Flash off before entering oven
Dry to Sand:	Overnight	Dry to Sand:	2 hours
Dry to Stack:	Overnight	Dry to Stack:	3 hours

Note: 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.

Clean-Up: Use 121-001.

Chemcraft International Inc. views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Revised: October 7, 2008