

**Product Code:**

131-8240      Satin  
131-8260      Semi-Gloss

**VISCOSITY:** Zahn #2 signature cup 36 sec at 77°F  
**FLASH POINT:** -4°F (-20°C)  
**DENSITY (lb/gal):** 9.15  
**SOLID (% by weight):** 49%  
**SOLID (% by volume):** 32%  
**SHELF LIFE (months):** 6

**Product Description:** Optiset 550 is a one-component, pigmented pre-catalyzed Reactive Amino Coating (RAC) with good resistance properties. This product meets the German "E-1" classification for the emission of formaldehyde as tested by an accredited laboratory using North American test methods. This is a fast building pigmented pre-catalyzed RAC due to its high solid content (32% volume). Optiset 550 demonstrates very good moisture, household wear, household chemical and mar resistance. The coating has light stable properties due to the type of resin used. This coating may be catalyzed to further enhance its durability. Contact your coating supplier for a recommendation. Optiset 550 has very low odor during the curing process while maintaining its rapid dry and cure properties. Special Recognition: Meets Kitchen Cabinet Manufacturer Association (KCMA) Standards. Recommended: Architectural Woodwork Institute (AWI). O.P.2.

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

**Environmental Data (as supplied):**

**VOC less exempt lb/gal:** <4.59  
**VOC lb/gal:** <4.28  
**VOC less exempt g/l:** <550  
**VOC g/l:** <520  
**VOC lb/lb Solid:** <1.00  
**VHAPs lb/lb Solid:** <0.004

See individual compliance sheets for specific data

**Application Data:**

**SUGGESTED USES:** Wood Finish  
**MIXING RATIO:** 100 parts 131-82XX to 1 part 873-1205\*  
**POT LIFE:** 8 hours\*  
**APPLICATION VISCOSITY:** Zahn #2 signature cup 35 – 36 seconds  
**REDUCER:** 803-1325 or 800-5500  
**RETARDER:** 800-5328  
**CLEAN-UP SOLVENT:** 803-1298  
**RECOMMENDED WET FILM:** 3 – 5 mils  
**COVERAGE:** Coverage is 545 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

\* Amount of catalyst required & pot life if material is catalyzed.

## Directions for Use

Optiset® 550 Pre-Cat White TC  
131-82XX

**Surface Preparation:** Wood substrate should be sanded with 120, 150 or 180 grit paper prior to coating. Primers should be sanded with 280/320 grit stearated paper prior to topcoating. An appropriate primer is Versaprime® 275 545-5120 or self-seal. When recoating, the previous coat of Optiset 550 or primer must be sanded and the next coat applied within eight hours. Optiset 550 White cannot be used on metal, old oil or cellulose lacquers.

**General information:** Agitate material before use. Always mix Optiset 550 while adding hardener and reducers in the recommended mixing ratios. Optiset 550 must be agitated thoroughly at all times to ensure product consistency and consistent gloss.

Apply at 3-5 mils wet on sanded or primed substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. Maximum film build of Optiset 550 White should not exceed 4 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Contact with metal surfaces should be avoided.

Optiset 550 White must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. Optiset 550 White must not be used and dried at temperatures below 64°F or relative humidity above 65%. During hardening the enamel 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>	10 – 15 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	2 hours	30 - 45 minutes
<b>Dry to Stack:</b>	3 hours	60 - 90 minutes

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.

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.

Akzo Nobel Coatings, Inc  
1431 Progress Ave  
High Point, NC 27260  
336-841-5111